



# Infor XA – Repetitive Production Management User's Guide

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## To the reader

This book contains the information you need to understand and run this application. The information in this book applies only to XA.

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## Before you begin

If you are not familiar with the System i, please complete the System i education for the basic operating concepts of the System i.

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## What this book contains

Chapters 1 and 2 acquaint you with the application. Be sure to read the first two chapters before you use the instructions in the remaining sections. Use these chapters to understand how this application works and what you need to know to manage it.

The next group of chapters describes the options on the Main Menu. For example, Chapter 3 contains information about option 1 of the Main Menu. Each chapter includes information about how to use the displays associated with each option.

The last group of chapters describes the reports and forms for this application.

Use the appendixes to find information about using offline files or other functions specific to your application.

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## Summary of changes

The following changes have been made to this application:

- **Integration with EPDM:** If EPDM is installed, the Repetitive Production Management application is now fully integrated with the EPDM functions and Item Revisions replaces Item Master. While this guide might contain references to Item Master files, the functions in this application now use Item Revisions for item information. For more information, see the *Enterprise Product Data Management Concepts Guide*.
- **Add User Exit to Manufacturing Order and Repetitive Schedule Close Routines:** Use Program UMIOC01R, after order selection but prior to the actual close, to add logic to the close routine for order closeout selection, order closeout selection by date in IM, and schedule purge select in REP.
- **Edit Reason Code in Inventory Management Transactions:** For applicable transactions, the reason code can now be edited against a Reason Table that is maintainable in IM, PMC, PCC, and REP. Valid reason codes are edited for proper transaction IDs when they are created. The user controls whether this enhancement is applied or not by maintaining an Inventory Management Control File byte. The function in OBPM and MM gives the user a dropdown menu to choose the Reason Code from valid ones already created in the table. The Reason Table is maintainable on the client.
- **Fix MRP Start Date for Unreleased Schedules:** If a scheduled item has a manufacturing lead time, the schedule start date remains the same as the planned order start date for an unreleased schedule. The computed REP schedule start date is applied when the schedule is released. All components are planned accordingly.
- **Negative Inventory Flag:** A field was added to the Warehouse Master and Warehouse Location fields to control inventory going negative. The following file extensions were created: Item/Warehouse Extension (ITEMBX), Warehouse Master Extension (WHSMSX), and Location Data Extension (SLDATX). See the following table and scenario for information on hierarchy and process.

Whs/Loc	Once	Never	Always
Once	Once, if whs qty >= 0	Never	If whs qty >= 0
Never	Once, if whs qty >= trn qty	Never	If whs qty >= trn qty
Always	Once	Never	Always

### Scenario:

If the Warehouse setting is *Never*, and the Location setting is *Always*, and the item is stored in more than one location, then any transaction can drive a location negative as long as the Item Balance does not also go negative.

Warehouse on-hand = 50 (Never)

Location LOC1 on-hand = 10 (Always)

Location LOC2 on-hand = 40

An issue of 15 from LOC1 would be allowed with the warning message *WAM3355 - New quantity on-hand is negative*.

However, an issue of 55 from either location would not be allowed. Instead, the system would issue error message *EAM3370 Negative balance on-hand quantity would be created*.

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## Chapter 1. Introducing Repetitive Production Management

This chapter contains general information about Repetitive Production Management (REP):

What Repetitive Production Management does .....	1-1
How the information flows within Repetitive Production Management .....	1-7
General Ledger interface .....	1-8
Common XA concepts .....	1-10
Using eWorkPlace with XA documentation .....	1-17

Some concepts and features that are common to most of the XA applications are discussed in two other books: *Getting Started with XA* and *Planning and Installing XA*.

- Menus and displays
- Group Job support
- Master file searches
- Audits and controls
- Security.

---

### What Repetitive Production Management does

The Repetitive Production Management (REP) application is designed for manufacturers who build or assemble products on a frequent or daily basis. The REP application gives you the ability to control these manufacturing processes through production schedules rather than traditional shop orders. REP helps you develop realistic production schedules, control the level of work in process, monitor schedule performance on a timely basis, maintain tight operating and audit controls, and provide a satisfactory level of customer satisfaction.

The Repetitive Production Management application enables you to do the following:

- Extract requirements from actual, planned, and user-defined demand to develop daily or intermittent schedules
- Develop smoothed schedule requirements for continuous flow manufacturing
- Maintain item schedules in relation to current schedules, new schedule requirements, line capacity, and component availability
- Release, track, and maintain manufacturing schedules automatically
- Enter schedule receipts to calculate standard labor usage and relieve component inventory
- Provide schedule performance reporting by line, item, and day
- Allocate items from specific locations and batch/lots to manufacturing schedules
- Summarize schedule costs (actual vs standard) by item and production line over a period of time
- Keep production lines replenished through electronic KANBAN
- Print a variety of analyses and special reports to provide a sound basis for REP decisions.



## The REP Main Menu

To understand the main functions of REP, look at the REP Main Menu.

The REP Main Menu has seven options that lead to secondary menus that offer additional options.

```
AMQM00                      Repetitive Production Management          *****
                               Main Menu

Type option or command; press Enter.

  1. Inquiry >>
  2. Reports >>
  3. Material Management >>
  4. Schedule Management >>
  5. File Maintenance >>
  6. General Ledger Interface >>
  7. Work with Repetitive >>

-----

F3=Exit      F4=Prompt   F9=Retrieve  F10=Actions
F11=Job status F12=Return  F22=Messages
```

**Option 1. Inquiry.** Use this option to review information from the master files.

**Option 2. Reports.** Use this option to print all reports available except those included in Material Management and Schedule Management.

**Option 3. Material Management.** Use this option to work with and control materials.

**Option 4. Schedule Management.** Use this option to control production schedules. You can enter, release, maintain, and purge schedules.

**Option 5. File Maintenance.** Use this option to add, change, or delete information in the master files.

**Option 6. General Ledger Interface.** Use this option to access three secondary General Ledger Interface menus: Account Assignment Rule Management, Transaction Account Assignment, and General Ledger Management. You can capture business activity data from the application and convert the data into ledger entries.

**Note:** You also must have the IM interface with General Ledger turned on when you use this option. Use the *Inventory Management User's Guide* for explanations of the displays in this option.

**Option 7. Work With Repetitive.** Use this option to review details about a schedule or review schedules for a particular date, item, line, or planner. You can review a particular schedule for details of operations, component materials, component allocations, or additional operation descriptions. You also can enter and maintain information about what products are being built, and which production lines are used to build these products, as well as specify which components are built at which location, and how these components are to be replenished.

## REP manufacturing process

Some manufactured items are produced in volume on a continuing basis. The items are produced daily, several times a week, or several times a month. A production line is typically used to manufacture these items.

A production line is a group of manufacturing facilities set up in a manner that allows parts to flow from one facility to the next. Parts begin at the first facility, or work station, and move to each successive facility until they are completed. The work stations are generally arranged in a relatively straight line or a U-shaped configuration. A production line can be self-contained (for example, a single flexible machine center), or interconnected to provide a smooth flow of parts from one station on the line to another.

Production lines generally have fixed rates and tooling. A production line produces an item at a specific rate and uses tooling that is adapted especially for the production of that item. The number of different items that may be produced by a production line is limited by the production characteristics of the items. Only those items that use the same sequence of manufacturing operations performed on identical facilities in the same order can be produced on that production line.

A production line can be built to produce a single unique part requiring a fixed setup, or it can be built to accommodate a mix of different parts with similar production characteristics. A production line can produce more than one type of item at the same time, if the work stations on the line can perform a variety of short flexible setups. For example, two models of the same item can be produced at the same time if the setups for each model can be done quickly, without changing the rate at which the item is produced.

An item is assigned a primary line of manufacture, where it is normally produced. Alternate lines can also be used to produce the item when the primary line is overloaded, or when more production capacity is needed.

## REP cycles

The REP application has two basic processing cycles:

- A planning cycle
- An execution cycle

The activities associated with the basic cycles provide the necessary support to schedule and run production lines at an elementary level.

The planning cycle allows you to plan and release production schedules. Figure 1-1 shows you the overall planning cycle.

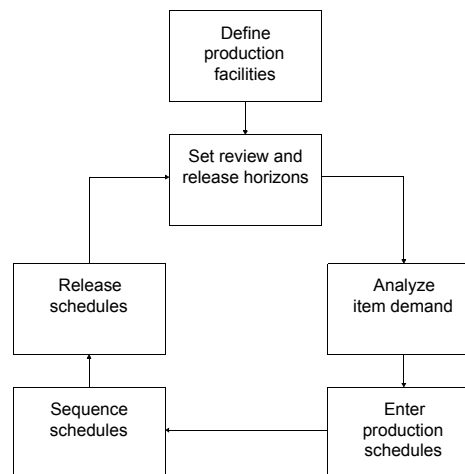


Figure 1-1. Planning cycle activities

Planning cycle activities include:

- **Define production facilities.** This function is a “make-ready” activity that defines your facilities to the application. To begin, you must define production lines, their daily availability, items produced on those lines, and their running characteristics. These characteristics include pieces per hour, changeover time, reporting points, or line locations where parts are issued, and stock locations that supply the line locations and where the finished goods are received.
- **Set review and release horizons.** The review horizon defines to the application how far into the future you need to view demand from other applications, so that you can schedule your lines properly. The release horizon defines how far into the future that you normally release schedules to production. When schedules are released, component parts are allocated. The review and release horizons are normally defined during your initial installation.
- **Analyze item demand.** In the planning cycle, analyzing item demand is the first step used to evaluate your schedules. In general, you need to review the demand for your schedules at least weekly and, in some cases, daily. Demand is extracted from either Customer Order Management (customer backlog), Material Requirements Planning (planned orders), or a Schedule Demand file that you can load yourself. You can control by item whether demand is shown on its true date of occurrence, or have the system calculate a smoothed demand pattern that helps you to level your resource requirements over the review horizon. Past due demand will be included on the system’s date.
- **Enter production schedules.** This function allows you to view the latest demand quantities by date for an item and compare them to schedules that are planned or released to production. At the same time, the released schedules also are viewed in terms of the line hours they generate on a production line and the total utilization of that line based on all items scheduled. With this information you easily can alter schedules by date, quantity, or production line, check component availability, and alter the sequence in which items are run.
- **Sequence schedules.** If multiple items are scheduled on a line for a given date, you can specify the sequence in which schedules are to be run to take advantage of schedule overlap and changeover time. The Sequence Schedule display initially lists schedules with common characteristics within a user-assigned schedule group code. To assist in determining the best run sequence for line

utilization, you can change the information on the Sequence Schedule display (changeover time, flow time, overlap, pieces per hour, and schedule quantity) for the best run sequence in terms of line utilization.

- **Release schedules.** When you are satisfied with your schedules, they are ready for release to production and resource allocation commitment. Any schedule with a schedule date that is within the release horizon is a candidate to be released. You can review these candidates by line, item, and date. If necessary, you can also release schedules outside of your normal release horizon.

The execution cycle shown in Figure 1-2 allows you to run the schedules you have released.

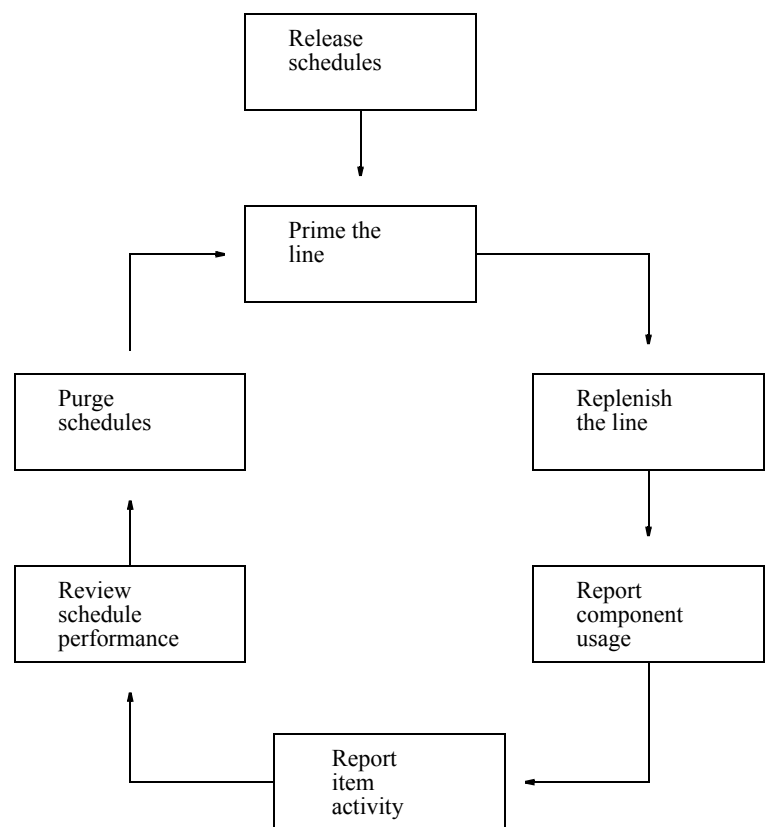


Figure 1-2. Execution cycle

Execution cycle activities include:

- **Prime the line.** You select released schedules to be started on the production line. Priming determines the amount of each component needed to fulfill the schedule.
- **Replenish the line.** This process involves the movement of component material to line locations from supplying locations. Priming, or reporting of containers of material used at a line, creates a demand for material replenishment. This demand is recognized through the printing of a Pick List.
- **Report component usage.** Component usage is recognized by one of two methods. The first method calculates usage automatically through the backflushing of reported production. The second method is visual, and generally

depends on a transaction being placed manually whenever a container is emptied. In both cases, material usage is detected and replenishment rules are applied to determine if more components are required at the line.

- **Report item activity.** At designated reporting points, you can report items that are partially completed, as well as any defect activity. The reporting transaction causes components to be immediately backflushed from their line locations, along with the amount of standard labor used. All transaction processing immediately updates all of the data files associated with the REP application.
- **Review schedule performance.** This function shows how the production line is meeting schedules. You can see variance reporting by item and line for units scheduled and completed, along with the associated yield information. Schedule activity can be viewed over the current period by day, cumulatively by day, and as a summary for an item against all lines.
- **Purge schedules.** This function allows you to purge schedules by date, by warehouse, or by individual schedules. You can elect to save purged schedules to the Manufacturing Order History files or these schedules can be deleted. Period reports that represent schedule quantity can also be produced prior to deleting the schedules.

## Additional REP activities

In addition to the activities in the two basic cycles, the REP application provides additional and more extensive functions and activities. The additional activities allow you to:

- Vary your work days and shift lengths by day by production line through Production Facility maintenance.
- Develop realistic schedules in Enter and Maintain Schedules by maintaining daily schedules, managing line utilization, checking for component shortages, and sequencing the order in which schedules are run.
- Receive summarized daily demand from COM by model lines by unique feature and option configurations (S-numbers).
- View an item's available-to-promise quantities by day.
- Update planned manufacturing dates into customer order line items in COM.
- Control the level of Work In Process (WIP) at the production line through the Item/Line definition function by specifying for a component the maximum containers allowed at a line location for a schedule.
- Add operations and components, perform component substitutions, and do discretionary allocations through Released Schedule file maintenance.
- Use bar coding and electronic KANBAN to replenish components.
- Track the usage of batch/lot components and dated inventory.
- Use bar coding to report units completed at a reporting point.
- Clear the line of unused components after the completion of a schedule.
- View and print the history of inventory transactions associated with a schedule.
- Produce summarized reports of schedule activity over a period of time by item and production line. The reports can be printed in terms of units or costs.
- Selectively process information through query functions on many of the selection displays.

---

## How the information flows within Repetitive Production Management

“Repetitive Production Management interfaces” on page 1-8 summarizes the flow of information in the Repetitive Production Management (REP) application.

REP can interface with seven of the XA applications. Each interface provides additional function to either Repetitive Production Management or the interfacing application). The applications that can interface with REP are:

- Customer Order Management (COM)
- Enterprise Product Data Management (EPDM)
- General Ledger (GL)
- International Financial Management (IFM)
- Inventory Management (IM)
- Material Requirements Planning (MRP)
- Product Data Management (PDM) (not available if EPDM is activated)
- Production Monitoring and Control (PM&C)

The IM and either EPDM or PDM applications are prerequisites for REP. When REP is interfacing with MRP, functions of MPSP are also available. REP requires multiple location support and can operate only in a controlled warehouse.

You must describe to the application your products and how they are manufactured. You describe the production line where the work is done, which items are to be schedule controlled and their operating characteristics, on which operation the components are backflushed, and the locations where component parts are supplied to the line. You can audit most of this information using the Item/Line inquiry or report. You can see the line locations and their stock status using the Item Detail by Location inquiry against a specific production line.

Once your products and facilities are described to the application, you can view your current scheduling requirements, existing schedules, and line loading to determine your latest scheduling requirements. This releases new schedules to the shop floor and maintains existing schedule quantities. You can work with components and operations on released schedules to handle component substitutions and last minute changes in discretionary allocations. At the same time, shop floor transactions are occurring that update locations with component movement, usages, and returns as well as reporting finished product activity. You can remove schedules from the application on a date established by you. At this time, you have the option to print reports that accumulate scheduling activity by item and production line.

When Enterprise Product Data Management (EPDM) is installed and activated, you can use site and revision-specific product definitions (items, bills, routings, and facilities) to enter and release manufacturing orders, enabling differences in manufacturing processes by item within site. If EPDM is activated, a site must be entered into all warehouse records.

---

## Repetitive Production Management interfaces

REP sends information to ...

- COM** Updates manufacturing due dates.
- GL** Transaction cost information and general ledger transactions.
- IFM** General ledger transactions.
- IM** Inventory management history and schedule data base; schedule close and purge information; updates the component issues and receipts.
- MRP** Schedule information to cause adjustments to planned orders and schedules.
- PM&C** Schedule information for transaction processing.

REP receives information from ...

- COM** Manufacturing due dates and order quantities into schedule extract function for developing production schedules.
- IM** Inventory status information, and calendar by line.
- MRP** Planned and firm planned orders which REP can use as net demand to plan its schedules.
- EPDM/PDM** Production facility information; routing information; bill of material information, variable capacity calendar, and default line and finished good location.
- PM&C** Component issues and receipts and replenishment requests.

---

## General Ledger interface

The goal of every accounting organization is to produce timely, accurate financial statements and reports that measure, financially, what is happening in the enterprise. Accountants must capture information about the business for accounting purposes.

The General Ledger interface lets accountants classify items, manufacturing orders, schedules, and production facilities for accounting purposes, using these fields:

- Item accounting class
- Order accounting class
- Schedule accounting class
- Production facility accounting class

Enterprise Product Data Management (EPDM), Product Data Management (PDM), and Materials Requirements Planning (MRP) also support these fields.

In XA, much of the business information that accountants need originates in “non-accounting” applications such as:

- Customer Order Management (COM). Information includes revenue from sales to customers and the associated cost of sales.
- Inventory Management (IM). Information includes movements into and out of inventory and the impact of these movements on manufacturing orders and schedules.

- Production Control and Costing (PC&C). Information includes movements into and out of manufacturing orders, such as: labor, machine, overhead, miscellaneous costs, manufacturing usage, manufacturing efficiency, and cost variances.
- Repetitive Production Management (REP). Information includes movements into and out of manufacturing schedules, such as: labor, machine, and overhead costs and variances.

Typically, people who use COM, IM, PC&C, and REP are not accountants. However, the people who want to use the General Ledger interface are likely to be accountants. Accountants can use the General Ledger Interface menu option in each application: COM, IM, PC&C, REP. Current users of these applications do not have to become accountants.

First you select the General Ledger interface during tailoring. Then, activate the transaction types using the Maintain Interface Control File menu option on this application's General Ledger Interface menu. Your application then saves information about the transactions for General Ledger when it processes transactions.

You can use generalized or specific rules to assign accounts to transactions. These rules reflect your accounting practices for how accounts are assigned, using multiple rules as necessary to cover different circumstances. You can change the rules and reassign accounts as necessary. As you create the rules and assign the accounts to transactions, XA checks the account numbers against the chart of accounts in the General Ledger Master file.

Two or more rules can apply to one transaction. You can set priorities to determine which rule prevails. Each application has a rules file and a priorities file.

After the General Ledger interface assigns the accounts to the transactions, you can review them. You can override the accounts assigned by the system or split a transaction so that it affects two or more accounts. No one can change the actual transaction data or the total transaction amount.

When your review is done, you can use a menu option to convert the transactions to General Ledger entries for GL. Transactions cannot be converted into General Ledger entries until they have been assigned valid General Ledger account numbers. The General Ledger interface summarizes the transactions for ledger purposes, if requested.

For transactions that affect multiple companies, the General Ledger interface handles intercompany accounting. It is possible to have transactions that result in ledger entries that affect more than one company. When this happens, XA creates intercompany receivable and liability entries to balance debits and credits at the company level. The Intercompany Accounting file contains the accounts used to do this task.

If IFM is installed, you can view a summary of REP transactions.



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## Common XA concepts

In XA, a standard system structure supports the Repetitive Production Management application and system functions. Most of the structure elements, such as using menus and displays, and group job support are discussed in *Getting Started with XA*. Some of the structure elements are discussed here.

## Files

Information in the REP application is maintained in the System Control file, master files, and work files.

### System Control file

The System Control file (SYSCTL) is the major system file for XA. It shows relatively unchanging information that is used by more than one application or operation. When you install an application and enter responses to the questionnaire, the information is stored in SYSCTL. It contains the functional options you chose, the report options you chose, and any constant information you entered (such as company name). To change information in the System Control file, answer the questionnaire again.

### Master files

The master files are permanently stored on your system. Most information in the Repetitive Production Management application is held in master files that are created during installation. The permanent REP files are:

- Component/Line (CMPLIN)
- Component Status (CMPSTS)
- Extract Requirements (EXTREQ)
- Intercompany Accounting (INTACC)
- Item/Line (ITMLIN)
- Line Capacity (LINCAP)
- Location Component (CMPLOC)
- Pending Available Allocation (PAALLO)
- Pending Available Quantity (PAQNTY)
- Repetitive Control File (REPCTL)
- Repetitive Production Management Transaction (PCCTXN)
- Repetitive Production Management Control (PCCCTL)
- Repetitive Production Management Account Assignment (PCCACC)
- Repetitive Production Management Account Sequence (PCCSEQ)
- Replenishment (RPLMNT)
- Schedule Demand (SCHDMD)
- Schedule Hours (SCHHRS)

**Component/Line (CMPLIN) file.** The Component/Line file is used to define the relationship of components and line locations relative to an item manufactured on a specific production line. It is used in conjunction with the Item/Line file. Normally components are tied to an operation based on the Operation Where Used field in the product structure file. The CMPLIN file is also used to override that relationship when the parent item is manufactured on another line. In this case, alternate routing operations may require the where used field to be overridden to support components used at different operations. Any changes to parent and component relationships in EPDM/PDM will be reflected in CMPLIN and its records in the Item/Line file will be flagged for review.

**Component Status (CMPSTS) file.** The Component Status file (CMPSTS) contains values that control the replenishment cycle. At the component/location level, it tracks how much is needed, how much has been supplied, how much has been used, and what is being replenished.

**Extract Requirements (EXTREQ) file.** The Extract Requirements file (EXTREQ) contains the net demand extracted from the Material Requirements Planning (MRP) application, from the Customer Order Management (COM) application, or user-entered demand from the Schedule Demand file. Each Extract Requirements record shows the net demand for an item/warehouse on a given date. The record contains the item number, warehouse, S-number (if applicable), date of demand, and net quantity.

**Intercompany Accounting (INTACC) file.** The Intercompany Accounting file (INTACC) is used to define the account numbers for each company in your installation that is to receive balancing ledger entries for multiple company transactions. Multiple company transactions can be created from the rules you define to the application. This file is available only if you chose multiple company processing during installation and tailoring.

**Item/Line (ITMLIN) file.** The Item/Line file (ITMLIN) is used to manage schedules and calculate the duration of a production process. This file contains one record for each scheduled item made on a production line. If a scheduled item is made on two different production lines, the item has two ITMLIN records. Item production rate, flow time, and changeover hours are included in the ITMLIN record. If a field has a value of zero (0), EPDM's routing header will be retrieved to find an override value.

**Line Capacity (LINCAP) file .** The Line Capacity file (LINCAP) shows the change in production line hours on a given day. It contains one record for each day that a production line has capacity different from the standard shift hours. Each record includes shift hours and resources for that day.

**Location Component (CMPLOC) file.** The Location Component file (CMPLOC) is used to maintain values that determine how the replenishment cycle is controlled. The user defines what mode of replenishment is used at a location and specifies the rules for replenishing items.

**Pending Available Allocation (PAALLO) file.** The Pending Available Allocation file (PAALLO) is used to create a reservation against the excess material before searching a supply location for stock when the pick program finds excess material in a PAQNTY record. This record is deleted automatically when the pick quantity is received at the line.

**Pending Available Quantity (PAQNTY) file.** The Pending Available Quantity file (PAQNTY) has records created in it when the pick quantity is in excess of the required quantity needed at the line. The pick list program looks to this file for supply before searching supply locations for stock.

**Repetitive Control (REPCTL) file.** The Repetitive Control file (REPCTL) contains user-set options that control certain Repetitive functions. This file is in addition to the REP tailoring questions found in the tailoring function.

**Repetitive Production Management Transaction(PCCTXN) file .** The Repetitive Production Management Transaction file (PCCTXN) contains the transactions saved for the General Ledger interface. These transactions are captured when you backflush labor during RO/RM/SM reporting and during schedule purge. They remain

in the file until you assign accounts to them and post them to General Ledger. Material transactions are handled via the IM general ledger interface. See the *Inventory Management User's Guide* for more information.

**Repetitive Production Management Control (PCCCTL) file.** The Repetitive Production Management Transaction file (PCCCTL) contains a control record for each transaction type that you save for the General Ledger interface. A control record is created for any transaction type that does not currently have at least one transaction record for the transaction type processed in the PCCTXN file. As long as there are existing transaction records in the PCCTXN file, the control record for that transaction type is updated. These control totals are updated throughout the Repetitive Production Management to General Ledger interface processing. The control totals are kept for: records that have unassigned account numbers, records that have account numbers assigned, records that have account numbers assigned that are invalid, and records that are assigned account numbers for different companies.

**Repetitive Production Management Account Assignment (PCCACC) file.** The Repetitive Production Management Account Assignment file (PCCACC) contains the rules that reflect your accounting practices for assigning account numbers to transactions. Several rules can exist for a single transaction type.

**Repetitive Production Management Account Sequence (PCCSEQ) file .** The Repetitive Production Management Accounting Assignment Sequence file (PCCSEQ) contains the priorities for applying the rules that you define for assigning account numbers to transactions. A single rule can have multiple priorities. The PCCSEQ file contains a user-specified sequence number for each priority so that the application knows in what order the rules are to be applied. The priority with the lowest sequence number is applied first.

**Replenishment (RPLMNT) file.** The Replenishment file (RPLMNT) controls the amount and timing of component replenishments to the production line. The file contains at least one record for each component allocated to a REP production schedule. Each record contains information such as record status, schedule number, schedule item, production line, component item, quantity to replenish at the line, and line location.

**Schedule Demand (SCHDMD) file.** The Schedule Demand file (SCHDMD) is the file for user-supplied demand information. It contains demand for an item/warehouse combination on a given day. Item number, warehouse, S-number (if applicable), date of demand, and quantity are included.

**Schedule Hours (SCHHRS) file.** The Schedule Hours file (SCHHRS) shows the line hours that a schedule places on a production line. It contains one record for each day that the schedule uses the production line. Each record contains data to identify the specific schedule (for example, item number, production line, due date, and so on) and the production date and schedule line hours to be consumed.

## Work files

Work files are temporary files created by REP to hold information for processing. These files include:

- Available to Promise (ATPWRK)
- Component Time Phasing (COTPWK)
- Extract Conflict (EXTCFT)
- Extract Requirements (EXTRQW)
- Item Master/Item Balance (ITEMWK)
- Manufacturing Order Detail (MODWKA) file A
- Manufacturing Order Detail (MODWKB) file B
- Manufacturing Operations (MORWKA) file A
- Manufacturing Operations (MORWKB) file B
- Product Structure (PSTWRK)
- Repetitive Transaction Entry (RPTRAN)
- Interactive Offline Processing Recovery (RPTRCV)
- Repetitive Transaction Batch Control (RPTRNC)
- Offline Repetitive Transactions Formatted (RPTRNW)
- Repetitive Offline Entry (RPTRN1)
- Offline Repetitive Transactions (RPTRN2)
- Repetitive Transaction Entry (RPWORK)
- Released Schedules Report (RPTWRS)
- Schedule Release Driver and Restart (SCHREL)
- Schedule Update (SCHUPD)
- Schedule Work (SCHWRK).

You cannot alter directly these files.

## Master file searches

XA has master file searches that you can use to look up information in various master files. To begin a search, type a question mark (?) in a field that supports searching.

After you type a question mark in an eligible field, use **FIELD EXIT** and then press **Enter**. A display appears on which you describe the type of search you want and what you want to find.

## Data entry and update methods

Data entry is the process of getting your transaction data, such as replenishments, component transfers to the line, component returns, component scrap, schedule scrap, and production receipts into the system. Updating is the process of applying the entered transactions to your master files.

You can enter transactions in two ways: one at a time from a work station, which is referred to as interactive or online data entry; or from a batch that has been entered on an offline device. The second way is referred to as offline data entry. In either case, the application edits the transactions and indicates any errors it detects.

The master files are updated with the entered transactions. Interactive data entry applies the transactions to the master files as soon as they are entered. Batch update applies an entire batch of transactions that is entered from an offline device, then edited and held in a transaction file until the update operation is requested.

PM&C's interface to REP will update REP immediately. User transactions entered through offline entry (Enter Transactions from Offline Files on menu AMQM30) or through loading of the Schedule Demand file are updated after you enter the information and take an update action in REP.

The primary advantage of interactive data entry with immediate update is that master files are up to the minute. The response to an inquiry, for example, takes into account the schedule update that was entered seconds ago.

## Offline data entry

Offline data entry provides you a way to process groups of information that relate to a specific function. Transaction data entered into a transaction file immediately updates the application's files, but holds the information for printing later in the day. You can decide when you want to print the batch to view an audit trail of information about transactions in the batch.

You enter transactions into the system, either from a work station or from an offline device. Either way, they become records in a transaction file in disk storage. A transaction file can contain one or more such batches.

Each batch is assigned a number. Batch numbers ranging from 1 to 999, are issued sequentially. When 999 numbers have been issued, the application begins again with the number 1. If a batch number already exists, no more batch numbers are issued until the existing batch is removed. You remove a batch either by processing it using a Batch Status display, or by backing up your files (if you chose not to reuse batches during application tailoring).

The application keeps track of each batch's status and shows it on the Data Entry Control display. Use this display as the starting place for any interactive data entry, whether you are entering a new batch of transactions or working on an existing batch that was entered interactively or from an offline device.

For Repetitive Production Management, using the Data Entry Control display is a preliminary step for each of the following operations:

- Entering and maintaining REP transactions
- Entering and maintaining IM transactions

## Unattached jobs

Unattached jobs are jobs you can run in XA that allow a work station operator to enter data and then continue with other activities without waiting for the data to be processed. Unattached jobs are not attached to any specific work station. An unattached job processes data more quickly than a batch job can process it.

Unattached jobs conserve system resources by processing one transaction at a time and by posting transactions from multiple feeder jobs. Transactions are processed on a first-in first-out priority. In addition, unattached jobs use minimum system resources when there are no transactions to be processed.

A feeder job can be data entered by a work station operator, a communications job, or another unattached job. If an unattached job is not active when a feeder job begins, the feeder job starts it automatically. Once started, an unattached job continues to run until it is held or ended by the system operator.

Both unattached and batch jobs run in the QBATCH subsystem. However, an unattached job does not wait for other jobs to complete before it begins to run. Unattached jobs are submitted to a special job queue, AMUJOBQ, created by XA that runs an unlimited number of jobs simultaneously.

You can review the status of unattached jobs by using the Unattached Job Status option on the Cross Application Support Inquiry menu (AMZM10). You can manually start, restart, release, hold, or end unattached jobs using the Unattached Job Status option on the Cross Application Support Maintenance/Change menu (AMZM30).

**Note:** Unattached jobs must be held before running options in dedicated mode. You can either hold the jobs manually or the system holds them automatically.

You identify unattached jobs on the System i Work with Active Jobs display by the job name that begins with UMy as opposed to AMy for batch jobs, where y is the file library designator for that environment.

For more information about unattached jobs, refer to the *CAS User's Guide*.

## Record locks

XA creates files with a wait time of 60 seconds. Currently, XA programs, including REP (with a couple of exceptions), abnormally end if a record accessed is locked more than 60 seconds. Batch jobs have overrides to the wait parameter on all update files. Interactive jobs should have a message returned to the display to tell you that a record is locked. The interactive program continues looping to retrieve the record.

The technique used for controlling the error notification of a record allocation by another job is based on the Wait record parameter of the file being retrieved. A message is shown with the ID of the user who has the record locked. The message continues to show until the record requested is available for retrieval.

## Application Program Interface (API) for automated job submission

- XA provides the ability to execute XA batch jobs without using the XA menus. The REP application tasks listed below can be executed through a program call. A programmer can insert the program call in one of your programs, allowing the XA task to be run as part of a larger user task.

Task/Command	Menu and Option
<b>Print REP Pick List</b> (PRTREPPKL)	AMQM30-02
<b>Reprint REP Pick List</b> (RPRTREPPKL)	AMQM30-02

- Refer to Appendix C, "Automated job submission for REP" for more information on this API.

## Work With Enhancements

Three of the REP Work with menus provide enhanced options to assist you in defining product and production line relationships in the following files: Item Line Master (ITMLIN), Component Line Master (CMPLIN), and Location Component file (CMPLOC).

In addition to the inquiry/review options, you can use options to maintain these files.

- The Work With Item/Line Definitions panel allows you to create, change, and delete product and production line information.
- The Work With Component/Line Definitions panel allows you to change individual as well as mass information about components and how these components are to be replenished.
- The Work With Location/Component Definitions panel allows you to create, change, delete, and validate information that determines how your replenishment cycle is controlled.

You also can use the Work With Component Status panels to view requirements by day to investigate database activity relative to the pick list.

See Chapter 9, “Work with Repetitive”, for more details.

## Inquiry

The Inquiry menu (AMQM10) is used for reviewing information in the REP master files. Numerous inquiry, status, and review displays are also available to assist you in processing transactions, releasing schedules, maintaining your master files, and carrying out other important REP functions.

In REP, the available inquiries are as follows:

- Item Balance inquiry shows all items or a range of items from the Item Balance file.
- Schedule Performance inquiry shows units scheduled, scrapped, and completed for current schedules since the last schedule purge.
- Schedule vs Demand inquiry shows an item’s scheduled production, demand, and variance quantities.
- Released Schedules inquiry shows information for released schedules, such as allocation, status, quantity, and cost.
- Work With Item/Line inquiry shows operation and component information for an item produced on a specific production line.
- Production Facility inquiry shows production line, work station, or work center information.
- Item Detail by Location inquiry shows information about items stocked at a production line or stocking location.
- Transaction History inquiry shows transaction records processed within the Inventory Management or Repetitive Production Management applications.
- Work with Location Component shows information about how your replenishment cycle is defined.
- Work with Component Status shows information relative to the pick list process.

From the Work With Repetitive option on the File Management menu, you can see detailed information processed within the REP and IM applications in the Work With Schedule Allocations, Schedule Descriptions, Schedule Operations, Date Schedules, and Schedule Material, Item/Line, Location/Component, and Component Status options.

## Major reports

REP offers report options you can use to print reports with only selected information. See Chapter 10, “Report descriptions”, for more detail.

The major reports printed by this application, and their uses, are as follows:

- Item Balance report shows all items or a range of items from the Item Balance file.
- Schedule Performance report shows units scheduled, completed, and scrapped for current schedules for the time period since the last schedule purge.
- Released Schedules report shows schedule information such as component allocations, status, quantity, and cost.
- Production Schedules report shows scheduled production over a period of time by item and line.
- Item/Line Process report shows standard labor and material costs of manufacturing an item or items on a production line, over a period of time.
- Item/Line report shows material and routing information for an item produced on a specific production line.
- WIP Totals report shows a summary of all costs to date for all open schedules and/or orders. You can select one or a range of warehouses you want to use.
- Item Balance Audit report shows discrepancies between the Item Balance file and the Item/Line, Product Structure, and Routing master files.
- Item/Line Audit report checks for schedule control items to see if at least one Product Structure record and at least one routing record exists. It also compares the Item Balance file to the Item/Line file to see if matching entries occur.
- Location Audit report allows you to validate the location fields used in the Repetitive Product Management application. The following files are validated: Item/Line, Component/Line, Item Balance (scheduled items), Manufacturing Order Master, and Manufacturing Order Detail (scheduled orders).

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## Using eWorkPlace with XA documentation

eWorkPlace (eWP) is the Microsoft®, Windows™-based graphical user interface for XA. The eWP windows co-exist with the XA character-based displays, called Host screens. If you are using eWP, you can view the corresponding Host screen for any eWP window, if necessary.

**Note:** If you have modified a Host screen, the GUI default is used. The default GUI feature can be enabled or disabled.

The user’s guides and help text contain instructions that reference the host XA screens (called panels and displays) rather than the eWP windows.

To understand how a Host screen instruction relates to an action on a eWP window, it is helpful to look for text on a window control that corresponds to the instruction. For example, **Cancel** on a button and on a File pull-down corresponds to the user guide instruction “use **F12=Cancel** to return to the previous display”.

**Note:** For the instruction “press **Enter**”, the corresponding control on an eWP window is an **OK** button.



The following table shows other examples of instructions from the documentation and the corresponding actions you take on the eWorkPlace window.

Documentation instructions	eWorkPlace actions
To change the details of a vendor, type <b>2</b> next to the vendor and press <b>Enter</b> .	Select a vendor, then select Change or type C from the List menu or select Change using the right mouse. Click the OK button.
To create a vendor, use <b>F6</b> .	Select Create on the Functions menu or click the Create button.
Position to command. If you want to skip to a particular command, type the full or partial command.	Type the full or partial command in the position to entry field and click the Position button.
Type the information requested and press <b>Enter</b> .	Type values in or select values for the entry fields and click the OK button.
Type the information requested and use a function key.	Type values in or select values for the entry fields and click a button or select an action on the Functions pull-down.
Use the Item Master maintenance display to.....	Use the Item Master maintenance window to.....

For more information about eWP, see *Getting Started with eWorkPlace*.

## Chapter 2. Managing Repetitive Production Management

This section describes the processes and calculations required to manage the Repetitive Production Management (REP) application.

Overview..... 2-1  
 Preparing your REP files ..... 2-8  
 The planning cycle—Entering and Maintaining Schedules ..... 2-84  
 The execution cycle—Releasing and Tracking Schedules..... 2-115  
 Other REP activities ..... 2-147

### Overview

The sections in this chapter are designed to give you information on the principles involved in the REP application. The information is contained in the following:

- “Preparing your REP files” should be read before you begin setting up your REP files. This part contains useful information about maintaining your REP files as circumstances change or problems occur.
- “The planning cycle—Entering and Maintaining Schedules” describes the activities you perform to determine the items to produce and the dates the items are needed. This part also provides information on how to schedule the manufacture of those items on the production lines.
- “The execution cycle—Releasing and Tracking Schedules” describes the activities that cause an item to be manufactured on a production line and how to report and monitor the progress of a production schedule.
- “Other REP activities” explains additional concepts and activities related to manufacturing items on REP production lines.

The following figure shows a typical production line layout and the elements of the line as used in the REP application. Some of our discussion is based on this figure.

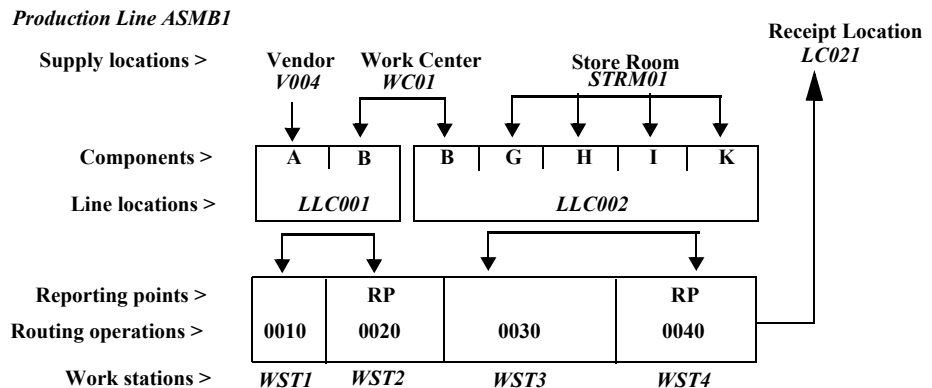


Figure 2-1. Typical production line.

The work stations on the production line are designated WST1, WST2, WST3, and WST4. The supply locations are designated V004 (a vendor), WC01 (a work center), and STRM01 (a store room).

## Understanding preliminary activities

This discussion is to introduce in a general way the activities and terms used in REP. Later in the chapter you will find specific steps and more detailed information for setting up your files.

REP uses the master files discussed in Chapter 1 to store the information used in managing your production process. Depending on whether you have PDM installed or EPDM activated, REP uses different files. The table below shows the files:

Type of information	EPDM file	PDM file
Items	ITMRVA, B, C	ITEMAS A, B, C
Bills of material	BOMHDR, BOMDTL	PSTRUC
Routings	RTGHDR, RTGOPR	ROUTNG
Facilities	FACMST	WRKCTR

The first activity when you begin preparing for the REP application is to define the production lines on which you schedule manufacturing. A production line is a collection of work stations or work centers at which items are manufactured through a continuous or flow process. Parts typically move along a flow with few, if any, queues at an operation. Because the flow is continuous, dispatch lists (which signal when work is due at specific work stations or work centers) are unnecessary.

The second activity is to define stocking locations used in the manufacturing process. When components are needed at the production line, they are transferred from stock locations in the storeroom. Stock locations that are used to supply specific locations on the line are called supply locations. Supply locations can represent vendors, work centers, or storeroom areas. The components are moved from storeroom or vendors to stock locations.

Along the production line, these stock locations are called line locations in order to distinguish them from the supply locations. In Figure 2-2, notice that component B can be stored at more than one line location on the production line. As finished units are produced, they are placed in locations called receipt locations (LC021). The receipt location represents a stock location at the end of the production line or a planned receipt location in the warehouse.

The REP application requires multiple location support (an example is component B in Figure 2-1), which can occur only in a controlled warehouse. You define the warehouses that are controlled by using Work With Warehouses in Inventory Management (IM).

Depending on your warehousing practices, manufacturing process, and layout, you can:

- Define unique stock locations for each item,
- Store several items in the same location.

At the production line, you can:

- Define separate line locations for each component
- Place several components in the same line location.

If you are implementing a stock location system for the first time, you can begin by defining a few stock locations (for example, one line location for each production line), then add more locations gradually. The more precise you are in defining your stock locations, the more definitive will be the component pick list or component return list, when bringing material to and from the production line.

You will need to define the schedule-controlled items. These are items that are produced using schedules on the production lines. The source of demand for these items must be identified. Demand can come from:

- Material Requirements Planning (MRP)
- Customer Order Management (COM)
- The Schedule Demand file

You choose the primary source of demand for all items when you answer the questions in the REP install/tailor questionnaire, but the source of demand can be changed for individual items.

A production line can produce one or many items each day, but it is normally limited to items that have the same sequence of operations, since each line has a fixed sequence of work stations that perform specific operations. Production lines must be balanced; each operation on the line should be performed in the same amount of time. If several items use the same series of operations and a similar amount of time, they can be identified through a schedule group code. When production schedules are sequenced for a day, items with the same schedule group code are sorted together. You should, however, consider whether the items have the same setups and components before you identify their schedules as a schedule group. This avoids unnecessary line tear-downs and changeovers.

Production schedules tell you specifically the number of units a line should produce of an item on a due date. You can:

- Schedule that item more than once a day on that line, allowing you to have multiple production runs per day
- Break down a day's production of an item into "lot sizes", creating separate schedules for each lot

You can use the application to:

- Control the sequence in which schedules are run on a production line
- Sequence two schedules one after another, yet actually run both schedules concurrently. This is referred to as "mixed model" scheduling. For example, a model item has two consecutive schedules on the same production line. Product configuration "A" is slightly different from product configuration "B", and both models can be produced on the production line concurrently. You intersperse several units of "A" with units of "B", so that the production line would see AAA BB AAA BB AAA BB. That is, the line runs 3 units of "A", followed by 2 units of "B", and the pattern is repeated until all "A"s and "B"s have been produced.

You can track the manufacturing performance of an item on a production line. Define the schedules as part of a "production campaign", and the total quantities produced and scrapped by the schedules in the campaign are tracked. The campaign is a series of schedules for the same item on the same production line. The schedules can be a series on the same day or a series spread across multiple days. Other items can be produced on the production line during this time period without interfering with the campaign counts. You can update the campaign summary counts by using the Carry Forward function in Enter and Maintain Schedules. The carry forward quantity also

can be updated when a schedule is purged. If a schedule in the middle of a campaign is purged, the carry forward quantity on the schedules after the purged schedule may appear to be incorrect; but in fact, it is not.

Schedule sequencing should not be confused with campaign tracking. Schedule sequencing determines the order in which schedules are run. Campaign tracking summarizes the quantity produced by a series of schedules.

Some items have different models that are the same except for features and options. Model items can have the same item number with different features and options selected, or each configuration can have a different item number. You can produce model items on the same line, either consecutively or in parallel.

Parts are normally transported to the production line in a container. The type of container and the standard quantity in the container are both defined. You can report transaction activity based on:

- The number of full containers
- The number of individual pieces

Another activity defines the routing for each item scheduled on the line. The routing can be a single operation (such as assemble and package) or have multiple operations. Each operation is performed at a work station or center. The production line can be set up as a series of adjacent work stations (often with interconnecting material handling devices) or it can use work centers that are not close together, sending materials from one center to the next using material handlers. In Figure 2-1, operations 0010, 0020, 0030, and 0040 are performed at work stations WST1, WST2, WST3, and WST4, respectively.

A reporting point (or intermediate reporting point) allows you to determine the number of partially completed units produced through that operation. The last operation of the schedule is assumed to be a reporting point, but you can define additional reporting points in other operations. If you are producing a high volume of parts with a short build time, you probably do not need to define intermediate reporting points. If, however, you are experiencing problems at an operation and want to monitor progress, define the operation as an intermediate reporting point. Then you can determine the number of units passing through the operation.

If the parts you produce take longer than a shift or day to manufacture, you can define additional reporting points at shift or daily intervals. For example, if you are running two shifts and the item takes three days to produce, you can set reporting points at the operations that are 8 or 16 hours (one or two shifts) apart. Then you can see what is produced each shift or at the end of each working day. Reporting points backflush components that have been used in the partially completed end item which can allow additional material to be moved to the line locations if auto replenishment is used and backflush consumed components which can allow them to print on the next day's pick list.

When the number of units passed through a reporting point is reported, the component parts used in the units are backflushed from the line locations where they are used. Backflushing is the technique used to charge components and standard labor and overhead to a schedule. You can choose to backflush using either the adjusted quantity per or the standard quantity per. Backflush codes are provided in the Warehouse Master and Item Balance files, allowing you to set the default for all items in the warehouse, and to override it for individual component items you want to handle differently. When units are backflushed, the components are issued from the line locations and charged to the schedule. The on-hand balance at the line location is

relieved by the issue. The standard labor hours and overhead costs used to build the unit are also calculated and charged to the schedule.

Components and standard labor are backflushed from the reporting operation to the previous reporting point. In Figure 2-1 completed units reported at operation 0040 (the last operation) cause material and labor consumed at operations 0040 and 0030 to be backflushed, while partially completed units reported at operation 0020 backflush materials and labor consumed at operations 0020 and 0010.

Another activity is to define the operation where each component is used. Each component record in the bill of material identifies the operation where the component is used. If a component is used in more than one operation (such as a common fastener), the component must be entered into the bill of material each time it is used on a different operation. Because each component in the bill of material must be uniquely identified, you need to add a user-sequence number to the component item number. This allows you to see the components used by each operation. In Figure 2-1, component B is used in operations 0020 and 0030. Component B, therefore, has two records in the bill of material.

When defining the bill of material, you must enter the quantity per for each component. If there is a by-product of the production process, it is entered into the bill of material with a negative quantity per. If a component has a negative quantity per, it is placed into the line location instead of being consumed from the line location during backflushing.

An item can be produced on multiple production lines where operations can be performed in a sequence different from the primary production line. You can change the operation sequence number for the affected components.

An additional activity is to define scheduling information for each item scheduled on a production line. Examples of scheduling information to be defined are:

- The number of pieces produced each hour or the amount of time between completion of each unit
- The amount of time needed to change over the production line to start a new production run
- The amount of time necessary to produce a single unit of the item

For the above three bullets these times are calculated automatically and stored in EPDM's routing header record. You can override these calculations by placing a non-zero value in those fields.

- Whether the start of a schedule for the item can be overlapped with completion of the previous schedule.
- Whether production for a day can be separated into lots of equal size (that is, lot sized).

You can assign line locations in one of three ways. In Component Line maintenance, you can associate explicitly a line location to a component, or assign all components of the finished good to the same line location. You also can choose to define in a work station record an associated stock location that will be used to define a line location for components used when an operation uses that work center.

With this information, schedules are sequenced and calculations are made of line hours consumed for each schedule (including the total line hours for all schedules running on the line that day).

The final activity is to connect your previously defined line locations to the components of the production item and the line where the item is produced. Each component can have a line location assigned which identifies to the system where the component is introduced into the system.

In addition to assigning a component to a line location, attributes about that component and the line location must be defined. Examples of what the application needs are:

- The maximum quantity of a component that can be stored at the location at a given time.
- The minimum replenishment quantity that can be requested.
- Whether allocations for the component are to be for individual schedules, or for the location (to be shared for different schedules).
- Whether replenishments are to be generated automatically or manually for this component. If they are to be generated automatically, you specify the generation guidelines in this activity.

This activity completes the definition of the production facilities on the replenishment cycle. With this information, you can:

- Schedule items on production lines
- Release and prime schedules
- Report units complete and backflush standard labor and components
- Issue component stock at the line locations
- Request refills of material used at line locations
- Print component pick lists to alert material handlers to restock line locations.

## Understanding production line activities

After all the necessary information has been defined, the following activities take place at the production line. For easy reference, the illustration of a typical production line is repeated here.

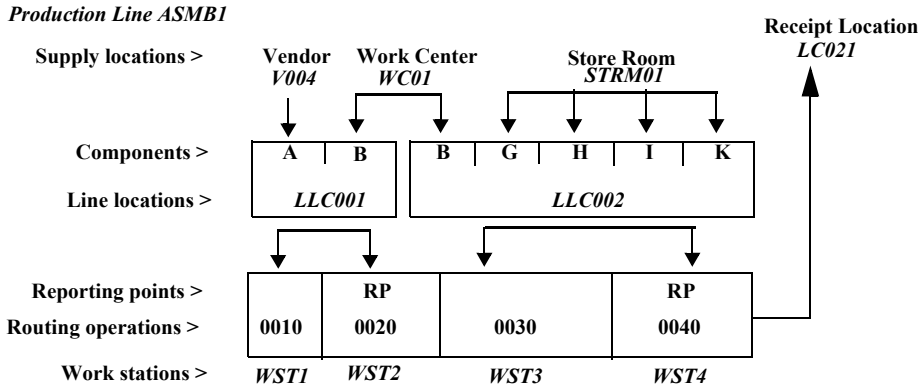


Figure 2-2. Typical production line.

When you want to start a production schedule, and schedules have been entered and released, you need to authorize component material to be brought to the line, by using the Prime the Line function which calculates the amount and date of each component needed for the replenishment process. Then pick lists are printed (through a separate menu option) and material is brought from locations V004, WC01, and STRM01 to production line locations LLC001 and LLC002 (see Figure 2-2). Material transfer transactions report that the units have been transferred to the line. The line is started, and units begin to move through the work stations.

When you report that units have passed through operation 0020 or have been completed at operation 0040 (reporting points):

- The line locations (LLC001 and LLC002) are backflushed based on the quantity per and backflush code. The number of units is multiplied by the quantity of components (A, B, G, H, I, and K) used in each unit.
- The on-hand balance at the line location is reduced for each component. Standard labor used is also calculated for each operation and stored in the Open Operation file for the schedule

When scrap occurs and units are lost, the components and labor used to produce the bad units are charged to the schedule, and the component on-hand balance at the line location is reduced. Scrap can be reported at any operation; these operations do not have to be designated as reporting points.

Completed units are received into a location that you specify. The receipt location can be specified when you set up your Item Line record, or it can be specified in the production line record in the Production Facility file.

Independent of the completion, scrap, and operation reporting, empty containers at a line location can signal that replenishment of component parts from their supplying locations is needed. The need for replenishment also can be signalled automatically as completed items are reported, indicating the usage of components. Replenishment continues until a sufficient quantity of each component has been sent to the line to produce the item's scheduled quantity. This cycle uses the Electronic KANBAN pull technique. If you do not wish to use the pull technique, you can manually control movements of parts to the line through the use of Just-In-Time (JIT) locations.

After the last units are completed, a Component Return List can be printed, and leftover parts can be returned to their supply locations, if desired. In Figure 2-2, the supply locations shown represent a vendor (V004), a storeroom (STRM01), and a work center (WC01).

You can use the Schedule Performance inquiry at any time to compare production to schedules. This inquiry shows the quantity completed by each schedule and the schedule's yield. Accumulated schedule quantities for a day can be reviewed or the figures can be summarized over a period. A Schedule Performance report also is available.



Before you remove the schedules from the system, you can print performance reports by item or production line to compare the standard (anticipated) amount of material used with the actual amount used. The amount of standard labor incurred is also reported. This information can be shown in units, costs, or both, for a single schedule or all schedules within a date range.

You can purge schedules from the system either individually or by specifying a purge date. If you specify a purge date, all schedules whose due date is equal to or earlier than the purge date are removed. The purged schedules can be saved to Manufacturing History files for later analysis through the manufacturing history function.

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## Preparing your REP files

After you complete the REP installation process, using Cross Application Support (CAS) install/tailor, you must enter information into your REP files to set up the REP application for your use.

To prepare your REP files, you must perform the following steps, in the sequence shown. Each step is described in detail in the following section, in the same order as shown here:

- Step 1.** Define production lines, work centers, and work stations
- Step 2.** Define stock and line locations
- Step 3.** Define standard containers
- Step 4.** Define location characteristics
- Step 5.** Define batch/lot and FIFO date control
- Step 6.** Define batch/lot quality control
- Step 7.** Define floor stock (uncontrolled and controlled)
- Step 8.** Define material movement between locations
- Step 9.** Define schedule-controlled items
- Step 10.** Define demand
- Step 11.** Define routings
- Step 12.** Define bills of material
- Step 13.** Define the items processed on a production line

At this point, you should select the tailoring options in the REPCTL file that are specific to your manufacturing operation. These options are in addition to the ones selected during install/tailor.

- Step 14.** Choose REP operational options

To validate the information you define for all of the preceding items, you must complete the next step.

**Step 15.** Run the audit reports listed, in sequence:

Item Balance Audit report

Item/Line Audit report

Location Audit report

To complete the REP file preparation, complete the next steps.

**Step 16.** Select the printer output queues to determine the printer on which your reports are printed

**Step 17.** Set the time horizons to determine how far into the future to create production schedules, and when to begin releasing them.

A Quick-Start file-related method of implementing REP for a pilot program in a plant using XA manufacturing orders is as follows:

1. Define production lines, work centers, and work stations
2. Define line locations (assumes warehouse is controlled and stocking locations are defined already)
3. Review existing routings for work center/work station changes
4. Review BOM for OPWFU (operation where first used) changes
5. Perform item balance file maintenance to define schedule controlled items, primary line, and container information. Define containers for components.
6. Create item line records in Work with Item/Line
7. Create/update component line records using option 20 in Work with Item/Line
8. Review/change component location records in Work with Component Location to define desired replenishment characteristics
9. Perform file maintenance on the REPCTL file, using option 10 on the File Maintenance menu
10. Run the audit reports
11. If extracting demand from MRP, run a MRP generation. Run extract demand in REP.
12. Enter and maintain schedules
13. Release and prime schedules
14. Print a pick list
15. Enter CL transactions
16. Report production

## **Step 1. Defining production lines, work centers, and work stations**

Production lines, work centers, and work stations are maintained in the Production Facility Master file. When PDM is installed, you use option 4 on the REP File Maintenance menu (AMQM50) to define those to be used in the REP application. If EPDM is activated, this option is not available and you must use EPDM to define these facilities in the FACMST file. When entering a production line, you can:

- Define the calendar that the line will use in work days
- Specify capacity by work day
- Define general receipt location where finished items can be received

- Enter the variable capacity of the facility by shift on a daily basis

If the production line is set up with the operations adjacent to one another, the operations are performed at work stations. The work stations can be linked through material handling devices such as transport belts or robot material handlers.

If the operations are separated by some distance and parts are moved in small batches from one operation to the next, the work is performed at work centers. A work center is a group of machines that perform similar functions. Items can be produced on one machine, several machines, or a series of machines (such as a flexible machining center).

A production line can be made up of a combination of work stations and work centers. For example, a series of component insertion machines can be set up as part of a printed circuit board production line. After the components are inserted, a group of boards moves to a wave soldering work center and then to a hand insertion work station.

An important difference between work stations and work centers is that a work station is dedicated to a production line while a work center can perform a mixture of operations for job shop orders and production schedules. A line stocking location can be defined in the work station record that can provide a default line location when component line records are added.

For REP, whether you define an operation using work centers or work stations has no particular significance other than the terminology you want to use.

The production lines you enter are used in “Step 13. Defining the item process on the production line” on page 2-62, to describe the items that are produced on a production line. The work stations you enter are used in “Step 11. Defining routings” on page 2-45, to describe the work stations used at each operation in the routing.

After entering your production lines, work centers, and work stations, you can review your entries using option 6 on the REP Inquiry menu (AMQM10). You can also print your entries using the Production Facility report option on the PDM menu AMEM03. If EPDM is activated, neither of these options are available and you must use EPDM to inquire and print.

The following data fields in the Production Facility master file are used in the REP application to calculate component required dates for schedule replenishments, and/or calculate standard costs for schedule costing. A discussion of each field follows. Every field in the file is not discussed here. See “AMVT71—Production Facility Maintenance (Add)” for more detailed information.

- Queue time
- Prime load code
- Setup labor rates, run labor rates, and machine rates
- Overhead rate/percent, overhead code
- Shift length (desired/minimum/maximum)
- Capacity (desired/maximum)
- Variable capacity

## **Queue time**

Queue time is the amount of time parts wait before they are processed at a work station or work center. On most production lines the queue time is minimal. However,

if there is a delay before work can begin on the first unit of a production schedule, queue time should be added to the operation time. Queue time is added once for each operation that contains it.

Queue time is expressed in standard days. The **Queue Time** field has three integers and two decimal positions (for example, 999.99). This value is multiplied by eight hours to arrive at the number of queue hours.

### Prime load code

The prime load code (PLC) specifies the formula used to calculate the setup and run duration for the operation. This information is used to determine the operation duration and to schedule the operation start and end dates. The prime load codes are:

- 0** No hours accumulated. Setup and run times are not important at the specified work station or work center.
- 1** Run machine hours
- 2** Setup labor hours divided by setup crew size
- 3** (Setup labor divided by setup crew size) plus run machine hours
- 4** Run labor hours
- 5** (Setup labor divided by setup crew size) plus run labor hours

The following table shows how the setup and run times are calculated for each formula, where:

- SULHR = Set up labor hours
- ASUHRS = Setup hours (divided by setup crew size)
- ARLHRS = Run labor hours per unit
- ARMHRS = Run machine hours per unit

PLC	Setup Time	Run Labor/Unit	Run Machine/Unit
0	0	0	0
1	0	0	ARMHRS
2	SULHR	0	0
3	ASUHRS	0	ARMHRS
4	0	ARLHRS	0
5	SULHR	ARLHRS	0

### Setup labor rates, run labor rates, and machine rates

You can enter rates for setup labor, run labor, and machine hours (both current and standard). These rates are used in EPDM and PDM product costing, REP scheduling, and WIP costing.

For further information on costing, see “Schedule costing” on page 2-148 and “WIP costing formulas” on page 2-149.

### Overhead rate/percent, overhead code

The overhead code and rate or percent are used to calculate the overhead cost for operations performed at the work station or work center. Overhead cost codes A and B use an overhead percentage; overhead cost codes C and D use an overhead rate. Enter a rate or percentage depending on the cost code selected.

These formulas illustrate the overhead cost calculations, where:

<b>SOCOD</b>	Standard overhead code (entered)
<b>SOVER</b>	Standard overhead rate/percent (entered)
<b>SLHRS</b>	Standard labor hours (calculated)
<b>SMCST</b>	Standard machine cost (calculated)
<b>SMHRS</b>	Standard machine hours (calculated)
<b>SSLCST</b>	Standard setup labor cost (calculated)
<b>SRLCST</b>	Standard run labor cost (calculated)

If SOCOD = A, then Standard overhead cost =

$$SMCST \times \left( \frac{SOVER}{100} \right)$$

If SOCOD = B, then Standard overhead cost =

$$(SRLCST + SSLCST) \times \left( \frac{SOVER}{100} \right).$$

If SOCOD = C, then standard overhead cost = SMHRS x SOVER.

If SOCOD = D, then standard overhead cost = SLHRS x SOVER.

For further information on costing, see "Schedule costing" on page 2-148 and "WIP costing formulas" on page 2-149.

### **Shift length (desired/minimum/maximum)**

The desired shift length is the amount of time normally available during a shift and is used to determine capacity load. For example, if the first shift is scheduled from 8 a.m. to 4 p.m., seven work hours remain when lunch, breaks, and cleanup time are subtracted from the shift. Seven hours, then, is the desired shift length.

Shift lengths are based on the amount of productive time that a production line can be run. If relief workers are used during breaks and lunch and the line continues to run, the desired shift length can be eight hours. If overtime is used, then maximum shift length could be greater than eight hours.

The production line shift lengths stated in the Production Facility Master file are long term and are usually not changed unless overall production is increased or decreased. For short-term shift length changes, use the variable capacity function explained later in this section.

Minimum shift length is the level of capacity which defines where desired line capacity begins. This field does not appear on displays. It is a calculated field, based on a REP tailoring question that defines minimum as a percentage of desired shift length. Both minimum and maximum shift lengths are used as edits against line load, while desired shift length is used to reflect optimal line loading.

### **Capacity (desired/maximum)**

The desired and maximum capacity of a production facility are based on the normal number of resource units (machines or workers) available in the facility. For a production line, however, the desired and maximum capacity usually become one resource unit. REP does not use multiple resource units in the capacity calculations

for production lines. Therefore, capacity is equal to the shift lengths for a production line described in the previous section.

In some cases, capacity can be changed by adding or subtracting workers. When capacity changes, the item rate (the rate at which completed units appear at the end of the production line) should be changed, but the production line capacity should not be changed.

### **Variable capacity**

Enter temporary or short-term changes to capacity through the variable capacity function. These changes can be for days, weeks, or months. You can increase or decrease the shift lengths for production lines and work centers. Work center resource units can also be increased or decreased to affect capacity. A production line is considered to be a single resource unit. For this reason the capacity calculations in REP ignore multiple resource units as specified in the Production Facility Master file. This function is reached as an option on the Production Facility Maintenance Select display when PDM is installed. See “AMVT70—Production Facility Maintenance (Select)” and “AMVTC2—Variable Capacity Maintenance (Add)” for more information on using those displays. If EPDM is activated, variable capacity maintenance is performed using Option 11 on the REP File Maintenance menu (AMQM50).

## **Step 2. Defining locations**

Stock, supply, and line locations are maintained in the Location Detail file. You use option 7 on the REP File Maintenance menu (AMQM50) to define supply and line locations.

You can track inventory in multiple warehouses, which can be either controlled or uncontrolled. REP requires the use of a controlled warehouse. Controlled warehouses allow you to stock an item in more than one location. When you answer the IM install/tailor questionnaire, you specify whether to track stock in controlled warehouses by batch/lot, FIFO date, and/or quality control status.

### **Stock locations**

In a controlled warehouse you can store an item in more than one location. Each location is identified by an alphanumeric field that is from four to six characters long. IM defines the six positions (aabbp) as follows:

<b>aa</b>	Aisle. A row of stock locations (two positions).
<b>bb</b>	Bay. Vertical locations in an aisle (two positions).
<b>l</b>	Level. Horizontal locations in a bay (one position).
<b>p</b>	Pallet. A subdivision within a bay or level (one position).

A seventh position is available but you can use only the characters A to E or 1 to 5, depending on the IM install/tailor questionnaire selections made. The positions would then be defined as aabbpS, where S represents a subdivision or division within a pallet.

You do not have to follow this scheme. You can use any character combination you choose, such as BLDG, COLDRM, or FLOOR. Devise your own scheme for naming locations based on the number of inventory stocking locations, production lines, and production line locations you need. You should, however, be sure to include locations for the following:

- Receiving and inspecting purchased parts
- Storing raw materials, fabricated parts, components, and subassemblies
- Production line locations
- Locations to inspect and receive finished goods
- Quality control areas
- Work-in-process (WIP) areas.

When you define a location you can set up the location to store more than one item or more than one batch/lot or both. If you are controlling inventory by FIFO date, a stock location can contain stock for more than one FIFO date. You also can store an item in multiple locations.

Multiple stock locations are described in the *Inventory Management User's Guide* under the headings "Stock location scheme," "Multiple locations per item," and "Multiple items and multiple lots per location."

REP uses the following types of locations:

- Line
- Supply
- JIT
- Warehouse (or receipt)

## **Line locations**

Line location relationships, specified through the Work With Item/Line option on menu AMQM50, identify the specific locations on the production line where components are delivered and used. A stocking location for the work center or work station can be defined in the production facility file. This enables the line location in the CMPLIN file to be updated with a line location based on the operation where first used of the component. Released Schedule maintenance on the same menu is used to change the component line locations for released schedules if necessary. You determine the number and names of the locations needed. Line locations are identified by an alphanumeric field that is from four to six characters long.

If the production line area is small, and the number of different parts are few, you can use a single line location. If the production area is larger, you can specify a line location for each work station. If many parts are stocked at the line, you can choose to specify different locations for each part, or multiple parts can be stored at the same line location. If you are using numbers of different small parts stocked at a work bench, you can make the work bench the line location for all of the parts.

Components do not need to be physically stored on the production line. You can specify a buffer area adjacent to the production line, and operators can draw from the buffer stock when the component quantity on the production line is low. A line location can also serve more than one production line. If two lines are running next to each other and an item is used at two adjacent work stations, a common line location can be specified.

Line locations can be assigned automatically by specifying a location associated with a work station. This location is defined as the facility stocking location. The association is made by following the linkage from a component's "operation where used" field to the work station defined in the routing operation record. This function can simplify the amount of time it takes to set up a schedule controlled item for production.

When defining locations, you can have the first few characters of the location identifier represent a production line (ID) and the remaining characters the physical line locations. Using this scheme, you can tell the Pick List program to print component requirements for a range of line locations (for example, locations on a production line).

**Note:** Line locations also can be used to “hide” inventory from the pick list. If you have defective inventory, you might move it to a line location that is not defined in the Location/Component file. In this way, the pick list will avoid allocating defective material for use on the production line.

## Supply locations

The term supply locations means stock locations that are used to replenish line locations. Parts are drawn from supply locations to replenish components used on the production line.

Supply locations do not have to be in the store room. A supply location could be any one of the following:

- The location of a work center supplying fabricated parts. (This location is not the same as the facility stock location.)
- The location at the end of a feeder line that supplies subassemblies to the production line
- A vendor.

Use Item Balance maintenance on menu AMQM50 to identify the default supply location using the warehouse location field. Use Location/Component maintenance on the same menu to define overrides to a default supply location. Use Released Schedules maintenance on the same menu to define any overrides to a supply location after a schedule is released.

For further information on supply locations, see “Pick list” on page 2-119.

## JIT locations

On Just-In-Time (JIT) production lines, components are received from feeder lines or a vendor directly to the production line. Since the components never pass through the store room, replenishments are unnecessary. Components are assumed to be at the location when needed. You can also define JIT locations to bypass the normal REP KANBAN replenishment process in favor of using your own replenishment method; i.e., components used at JIT locations will not appear on a pick list.

You identify a JIT location, using Item/Line Maintenance on menu AMQM50 and specifying the name of the default supply location to be the same name as the line location. As finished units are reported, the component is issued from the JIT location, and the location’s on-hand balance is reduced.

In Figure 2-3, a part is built on the feeder line and is received into the line location where it will be used. For example, part A is produced on a feeder line 1 and when completed is stored in location B10. This part is used as a component on production line 2 to produce part B.



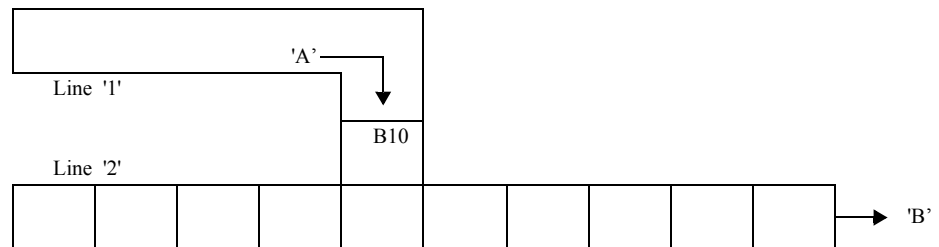


Figure 2-3. Part A built on feeder line and received into line location

JIT items are not printed on the pick list. JIT components are backflushed.

### Feeder lines and JIT locations

Feeder lines are not directly connected to other production lines. Different production schedules are used to report status and control replenishments to the feeder line and the production line. However, the feeder line can be connected indirectly to the production line by using the same location to:

- Receive the completed items from the feeder line
- Supply a work station on the production line.

The items produced on a feeder line have a JIT location at the end of the line. The JIT location is also the line location where the feeder line end-items are considered to be components used in an operation on the production line. You define the item's supply location when you enter the stock location in its Item Balance record. You define the component's line location on the production line when you enter the line layout through Work With Item/Line maintenance. REP does not synchronize feeder line production to the final assembly line. Feeder lines must be scheduled similarly to the final assembly line.

### Warehouse (or receipt) locations

The location where completed units are stored can be called the warehouse (or receipt) location. As units are completed, they are accumulated, reported as receipts, and moved to the warehouse (or receipt) location. These locations are conceptual and not identified in location maintenance. If you do not want to choose a warehouse (or receipt) location for production line receipts, you can accept the default location. Use Item Balance maintenance on menu AMQM50 to specify the default warehouse location for items. The **Warehouse Location** field in the Item Balance file is the default warehouse location for the completed item, and the default supply location when the item is used as a component. If a need exists for the same item produced on different lines to be delivered to different receipt locations, the override receipt location can be defined using Work with Item/Line. The warehouse (or receipt) location can be:

- In the store room for components
- In finished goods stored for end items
- A location on the shop floor for subassemblies needed for other manufacturing operations
- A line location on the next production line

- A stock location at the end of a production line.

If you are using a random storage facility, you can choose an empty stock location for the receipt or place it in the last location used to receive the item.

### **Step 3. Defining standard containers**

Containers can be used to transport components to the production line, and to move finished items to their store room location. Container information is defined in the Item Balance file, using option 1 on the REP File Maintenance menu (AMQM50). You specify the standard quantity per container and the container description in the part's Item Balance record. See "AMI7A7—Item Balance File Maintenance - Repetitive Manufacturing (Add or Change)" for more information on that display.

You report the quantities you move in containers and odd pieces. All containers are assumed to be full, and while the odd pieces may be transported in a container, the partially full container is expressed as the number of pieces, rather than as a fraction of a container. For example, you want to move 35 units of a component, and a full container carries 10 pieces. You report 3 containers and 5 pieces, rather than 35 pieces or 3.5 containers.

You also can move a component by the piece, without using containers. Specify the quantity per container in the Item Balance record as 1. The REP reports and displays show only pieces. The limitation with this approach is that the maximum number of containers that can be reported on a transaction is 999.

#### **Changing the quantity per container**

If you change an item's Quantity per Container (the quantity of parts transported in the standard container) you should be aware of an operation difficulty. Pick lists printed before the change use the old container size. Pick lists printed after the change use the new container size. Both pick lists show the total number of pieces to be picked, but the number of containers will differ. You will need to adjust the line location/ component definitions for every line location where the component can be delivered per the new container size so that full containers print on the pick list. You also will need to define the location maximum in terms of the new container size. You should schedule the changeover of container sizes for a time when the item has no outstanding pick lists, or be very careful when you pick and report the number of containers transferred to the line. You also should be careful when you report the number of containers passing through an operation reporting point, or received at the end of the production line.

#### **Container description**

The container description is a user-defined abbreviation of four characters or less for the type of container. For example, some container descriptions could be:

- BOX (boxes)
- TOTE (totes)
- PAN (pans)
- BSKT (baskets)
- PLLT (pallets)
- BRRL (barrels).

## Container labels

The container label is an important element in the KANBAN replenishment process. As components are used at the production line, each empty container is returned to the store room to be refilled, and the container label is used to report the need for replenishment and also authorize the movement of more material to the production line. In this way, components are “pulled” to the line from supply locations.

The components are transported in containers as they are moved from their supply room location to the production line. The container labels provide the following information:

- Component item number and user sequence number
- Item description
- Batch/lot number
- FIFO date
- Quantity being transferred, also in containers and pieces
- Supplying warehouse and location
- Production line, and line location to be delivered to
- Pick list and reference numbers
- Schedule number.

**Note:** Production line and schedule number print on labels only for schedule-based replenishments.

You can print individual labels for each container, or one label for each location supplying the component. The container labels can be placed inside, or attached to the outside, of the containers.

You can choose to print container labels at the same time that you print a pick list, or you can use the Print Container Labels option on the Material Management menu (AMQM30) to print container labels at any time. If you want component scrap (SC) transactions in PM&C for inventory that existed at the line when the pick list was printed, you must use the turnaround number from the container labels to want the transactions.

**Container label bar codes** . Bar codes can be printed on container labels. You must have selected the interface to REP when you answered the PM&C questionnaire, and activated the interface later. You must use an IPDS printer to print container labels with bar codes.

Each bar code printed on the container label represents a turnaround number, which identifies the replenishment that was picked and transferred to the line. The bar code can be scanned using a wand for rapid input of the turnaround number, and the pick or return quantities entered through the data collection terminal's keyboard. The turnaround number is also numerically printed just above the bar code.

If you are printing bar codes on your container labels, some of the information is printed in large print to let you read it from a distance. The same printer which allows you to print the bar code also allows large print to be provided for the following fields:

- Production line
- Line location
- Component
- Supply location.

For detailed information on the size and format of the container labels, see “Bar coding” on page 2-82.

## Step 4. Defining supply characteristics of a component at a location

After you have defined line locations, you must assign replenishment characteristics for each location and component combination. These records are created by REP when you enter location/component records in Work With Location/Component Maintenance on menu AMQM50. Only selected fields are discussed here. Complete field descriptions are found in Chapter 9.

### Replenishment basis

The replenishment basis (or mode) is defined in a selection stored in the Location Component (CMPLOC) file, using the Work With function. Replenishment modes are either location based or schedule based. When location based replenishment is selected, component requirements are accumulated and tracked across all schedules using the component stored at the location. Consequently, the replenishment cycle process allows material movement transactions without reference to schedule numbers.

***Schedule-based component/line locations.*** Control and track replenishments and allocations for a specific schedule and component. The data is reported for that specific schedule and component.

***Location-based component/line locations.*** Control and track replenishments and allocations at a summarized level. The data is accumulated across all schedules for each warehouse, component, line location and required date.

Essentially, location-based component/line locations are designed to share components when multiple schedules exist at the component/line location. During backflushing, components allocated for a specific day can be borrowed to satisfy issues for another day. In this situation the material borrowed is replaced through the replenishment pick list process. Schedule-based component/line locations are designed not to share components across multiple schedules.

Both schedule- and location-based component/line locations support FIFO date/batch lot usage. It is important to note that the location-based method moves the level of FIFO/batch lot support from a schedule level to a component/location level. Schedule-based replenishment uses a distribution algorithm to spread picked components over all schedules for a day.

If you select location based replenishment, you cannot create discrete allocations <sup>1</sup> for that component in the location. Material movement to and from the production line is tracked across ALL schedules. When material is issued, the FIFO date and/or batch/lot used is shown via the Repetitive Transaction Register report and the Inventory Management Transaction History Inquiry menu.

### Benefits of using Schedule-based replenishment

- Control over component usage. Allows the system to control replenishments and allocations to specific needs (schedules).
- Historical traceability of FIFO date/batch/ lot. Enables FIFO date/batch/lot integrity to the lowest level. This may be valuable for increasing the accuracy of potential product recall situations.

1 The ability to selectively allocate (or reserve) items to schedules. Items are allocated by specific batch/lot, location, and/or FIFO date.

- Discrete allocations. Allows schedule-specific allocations to be made for sensitive components.

### **Benefits of using Location-based replenishment**

- Consolidates material movement requests. The pick list produces fewer movement requests, since replenishment quantities are consolidated by component, by date and specific line location.
- Reduces potential for unapplied planned issue (IP) transactions. Components are available for issues across multiple schedules. However, to report transactions against a schedule you must deliver material to the line for that location, before processing a receipt or scrap transaction.

### **Replenishments quantity**

The replenishments quantity represents the standard amount of a component that you want to bring to a line location in a single delivery. For example, when a component is to be delivered to a line location, you can specify the number of containers of that component to be delivered. For another line location, you might want to specify a different replenishment quantity.

When replenishment is required, the quantity to be replenished is calculated following these rules:

- The quantity to be replenished must be at least the minimum replenishment quantity.
- The quantity to be replenished cannot cause the location maximum quantity to be exceeded.

The replenishment quantity feature is used to support movement of multiple containers and pieces from a supply location to a line location. In setting the location replenishment quantity, take the following into consideration:

- Location maximum quantity
  - Floor space available at the line
  - Container size
  - Piece size
- Replenishment quantity
  - Desired work-in-process (WIP) volume and variability
  - Rate of pieces used at a line location and variability
  - Delivery time and variability
  - Time between replenishments (printing the pick list).
  - Packaging.

The value you enter becomes the standard replenishment quantity. It must be a number that is greater than zero. If the quantity to be replenished is less than the minimum replenishment quantity, REP increases the quantity to be replenished to the standard replenishment quantity. If the quantity to be replenished is not a multiple of the standard replenishment quantity, REP increases the quantity to the next higher multiple. For example, assume the standard replenishment quantity is set at 10, and the quantity to be replenished is 25. REP increases the quantity to be replenished to 30, which is the next higher multiple of the standard replenishment quantity.

Using this feature, you can have one container at a location and replenish another container after a portion of the original is consumed, or replenish a multiple of the location replenishment quantity if multiple containers or pieces are issued.

At the time that the pick list is printed, the location maximum quantity may be exceeded for a component by a quantity that is no more than a location replenishment quantity minus one piece. This is because a multiple of the location replenishment quantity may print. For example, assume the quantity to be replenished is 1, the standard replenishment quantity is 10, the location maximum quantity is 20, and there is a quantity of 19 at the line location. REP increases the quantity to be replenished to 10, which is the next higher multiple. If no more material is issued from the location and the full 10 is delivered to the location, then the total at the line location will be 29. That amount exceeds the location maximum quantity of 20 by one piece less than the standard replenishment quantity.

If you want to control exactly the component amount replenished to a location, then the location replenishment quantity should be set to one piece, with a replenishment trigger of one. Therefore, for every component used, one unit is replaced.

## Replenishments trigger

This quantity represents how much of a component is to be used at a specific line location before a replenishment request is printed on a pick list. For example, you may replenish for every container used, or perhaps you may want to replenish only after several containers are used. Or, if a large container holds only a few parts, you could use the replenishment usage trigger to say that after three parts are used out of a container, send another container to the floor. The assumption in this case is that by the time the replacement parts arrive, most of the remaining parts at the line location will have just been used, thus allowing the new container to replace the empty one.

Component usage is calculated when processing receipt and scrap transactions and calculating usage via backflushing. To use this function, you must also select the auto replenishment function discussed later.

To calculate the proper level for a usage trigger quantity, consider the following factors:

1. How much of the component will be used during the time the component is being replenished. The longer it takes for the replenishments to move from the stock room and arrive at the line location, the greater the number of components consumed. This is often called "demand through replenishment lead time". You must know the rate at which components are consumed by the manufacturing process, and the average and (planned) maximum length of time between printing the pick list and reporting the arrival of the components at the line location. The average replenishment lead time is a gauge that lets you know how often components will arrive at the production line. You can use this figure in your calculations, but you may want to add buffer stock to prevent the line from shutting down when the replenishment delivery time exceeds the average. Or, you can use the maximum delivery time; but this figure has a tendency to increase inventory at the line location each time a replenishment takes place.
2. The amount of Work in Process (WIP) on the production line. The quantity of the component that is tied up in WIP includes:
  - The number of components that are in the partially completed end items that are on the production line. This is equal to the quantity per (of the component) for each item multiplied by the number of end items on the production line.

- The number of components in the (average) number of finished units of the end item that have not been reported as completed yet.
3. The amount of unreported scrap. Multiply the average scrap rate for the component times the number of partial units on the production line and the number of completed units that have not been reported.
  4. How often you want replenishments to be sent to the line location. If material handling equipment is scarce, you may want to set the length of time between replenishments to a longer period. Multiply the number of hours between replenishments by the number of components that are used and scrapped each hour.

The first three factors ensure that a barely adequate quantity of the component is sent to the line location, and that the trigger quantity is reached just as the replenishment arrives at the line location. The fourth factor sets the tempo for replenishments.

When the minimum replenishment quantity is greater than the usage trigger quantity, an inventory buildup occurs. You are sending more to the line location than has been used. The minimum replenishment quantity should be less than or equal to the trigger quantity.

When the maximum location quantity is less than the usage trigger quantity, the stock level at the line location gradually falls. You are stocking less at the line location than you are using. The location maximum quantity should be greater than or equal to the usage trigger quantity.

You also should review your schedule quantities. If the trigger level is higher than the quantity of the component used in a typical schedule, you should not use automatic replenishments or set trigger levels.

### Replenishments minimum

This quantity represents the smallest amount you would send to a line location. If you never send out a partial container, make this field a multiple of a full container. In the event a schedule is nearing completion and only a few components are needed -- that is, less than a container -- you might choose to send a full container of parts. What is left over would remain at the line location for a future schedule.

### Location maximum

This is the maximum quantity of this component that is planned to exist at this location at any time. Its limit is controlled by you, and is set based on a desired level of work in process. As a production process becomes more predictable, you may choose to lower the level of work in process at a specific line location.

The location maximum quantity must be divisible evenly by the standard quantity per container defined in the Item Balance file.

**Note:** You can exceed the location maximum quantity by entering an IM transaction that moves material into a line location. Only the REP Pick List program checks the location maximum quantity.

### Using run-out limits

When a schedule is nearing completion, a small quantity of the component may still need to be sent to the line location. If this is a common component that is used all of

the time on the production line, you may not want to limit the runout quantity. Instead you want the standard replenishment quantity to be sent to the line location. On the other hand, if the component is used infrequently or is an expensive part that you do not want left on the production line, you may limit the runout quantity to only the number of necessary parts.

## Auto-replenishments

This is a flag to indicate if the component and line location will have its replenishment cycle based on the replenishment trigger quantity or by manually entering Replenish Line (RL) transactions.

You might consider using this function if you have short flow times (hours/minutes) and don't have time to issue manual RL transactions.

In the Location Component file (CMPLOC), you can flag those components at a line location that are to be replenished automatically by the system. The flag for automatic replenishments indicates which components at a line location should have replenishments generated by the system once the component's replenishment trigger quantity has been issued from the production line location. In this situation, when enough of a component has been issued to reach its replenishment trigger quantity, a request to replenish the location is printed automatically on the next pick list. When auto-replenishments are in use, replenishment (RL) transactions are no longer required to signal the request of delivery of more material. However, replenishment transactions can be entered to override the replenishment trigger quantity and force the location to be replenished.

Changing of the auto-replenishment flag is allowed even if the warehouse/line location/component is used within an active schedule.

Manually entered replenishment transactions (RL transactions) are accepted for both auto-replenishment and non-auto-replenishment locations. The quantities of the manual replenishments are considered during pick list processing.

**Effect of Backflush transactions.** The system tracks the quantity issued for a component at a line location. IP transactions (generated from schedule receipt (RM), operation reporting (RO), and schedule scrap (SM) transactions) and component scrap (SC) transactions increase the number of issues for a component at a line location. When the usage is greater or equal to the replenishment trigger quantity, a replenishment signal is generated automatically by the system.

Unneeded parts may appear occasionally at a line location when a component is set up for auto-replenishment. If the component's quantity used (at that location) exceeds its trigger quantity, the component is printed on the next pick list. Reversing an RM, RO, or SM transaction causes its generated IP transactions to be reversed, and the associated component quantity used at that location to be decreased by the quantity that was issued. If the reversal of the component IP occurs after the pick list has been printed, the quantity used can fall below the trigger quantity signalling that parts are no longer needed, but the pick list has been printed and the parts are on the way to the line location. You should determine whether the parts at the line location are needed and transfer the unneeded stock back to the warehouse.

**Effect of Manual replenishments.** The quantity requested for a manual replenishment (an RL transaction), is accumulated and printed on the next pick list for the component at the location. However, this quantity is subject to the same restrictions as the automatic replenishment quantities, such as location maximum,



location minimum, and location replenishment quantity. If the component at the location is set up for auto-replenishments, the greater of the quantity calculated for auto-replenishments, or the total of the manual replenishment, is used as the quantity to supply. The accumulated manual quantity then is reduced by the replenishment transaction quantity to no less than zero. If there are not enough components to supply all of the auto-replenishment quantities and the manual replenishment quantities, the manual replenishment quantities are supplied first.

**Replenishment transactions for manual replenishments.** Quantities of replenishment transactions are limited only by the total quantity remaining to be replenished. If the component is scheduled based, this quantity is limited to the remaining need for the schedule. If the component is location based, this quantity is the total across all schedules for the required component for that line location on the same day. The quantities that show on a pick list can be limited by a number of constraints, such as the location maximum quantity, or remaining production need.

### **Use excess pipeline inventory**

With the introduction of minimum replenishment quantities into the pick list generation logic, it is possible to request more material than is actually needed when the pick list is initially printed. There is then a situation where material has printed on a pick list that does not have an identified requirement. The system can recognize this situation and allows subsequent pick lists to claim this excess material for use. Therefore, the need is not printed on a pick list but attached to material already in the process of being delivered to the line.

The Pending Available Quantity (PAQNTY) file contains information about printed pick list entries that have excess material.

When the Use Excess Pipeline Inventory feature is selected (through Work With Location/Component), each pick list checks for the existence of excess material for each component and location combination. If quantities are available, then the Pending Available Allocation (PAALLO) file records claims against the excess quantity in the Pending Available Quantity file. These claims result from subsequent pick lists for the same component at the same location.

When a CL transaction is posted, the claims against the excess material are transferred into allocations against the material at the line location. If the CL transaction is reversed, the material and allocations are left at the line location.

If unclaimed excess material was included in the CL transaction, the excess material is moved into the line location as unallocated inventory. This excess inventory is available for future printing of the pick list to allocate or for use in planned issue (IP) transactions.

If the CL transaction is reversed, the original excess material (or some portion thereof) will be moved back into the store room only if it is still unallocated at the line location. The excess material that is moved back into the store room is not reallocated to the pick list. When you enter another CL transaction against the pick list line reference number, the excess material will not be included in the picked quantity.

If any one of the schedules that are using a pick list record backflushes, the transaction cannot be reversed.

## **Override supply location**

Normally the supply location for a component is its stocking location as defined in its item balance record. This assumes that each line location containing the component uses a common supply point. If this not the case, you can use the Work With Location/Component option to specify an override supply location to handle dedicated supply locations that feed specific line locations.

## **Step 5. Defining batch/lot and FIFO date considerations**

Use Item Master file maintenance to designate items as batch/lot controlled so that the stock in each controlled warehouse is tracked by batch/lot number. Define FIFO date control in the IM questionnaire.

### **Batch/lot control**

Each receipt of the item is assigned a batch/lot number. You can assign the same batch/lot control number to several receipts, or each can be unique. Any issue or adjustment transaction for the item must specify the batch/lot affected. Batch/lot controlled items can also be quality controlled.

Once an item is defined as having batch/lot control, all transactions involving that item must carry the batch/lot number. The application edits these transactions to ensure batch/lot integrity.

In backflushing, a batch/lot number is assigned automatically to the issue based on the batch lot at the location. If inventory is allowed to go negative at a location, the issue transaction is assigned batch/lot number ##### and the FIFO date is set equal to the transaction date. You will need to correct this data with correct information to keep your FIFO date and batch/lot records accurate.

The histories of all transactions are stored in the IM's Transaction History file. You can request inquiries and reports from this file by item number and (batch/lot) number, allowing the tracking of a batch/lot from first receipt through customer ship. You can have batch/lot control active, even if quality control is not.

Usually, you would not make discrete allocations of items batch/lot controlled, such as bottle caps or packing cases, to a manufacturing order but would issue them out of inventory as needed. However, you can specify on the Discrete Allocation display (AMINF1) that you want to allocate items not batch/lot controlled. Then these items appear on the Manufacturing Order Allocation Selection display (AMING1). See the *Inventory Management User's Guide* for more information on those displays.

Pick list processing in REP attempts to replenish the same batch/lot to a line location whenever a replenishment request is received.

Batch/lot control is described in the *Inventory Management User's Guide* under the heading "Batch/lot control."

### **FIFO date control**

If items have a shelf life or if you want date controlled usage, select FIFO date integrity when answering the IM install/tailor questions. FIFO dating allows you to

identify and use the oldest items first so that items can be used before their expiration dates.

When FIFO date integrity is turned on, items in controlled warehouses are tracked by FIFO date and the receipt (FIFO) date must be entered on all receiving transactions. Issue and adjustment transactions must also specify the FIFO date to identify the stock that is affected.

Pick list processing in REP lists replenishment by FIFO date and batch/lot sequence. If you select both batch/lot and FIFO date tracking, inventory is tracked by both methods.

FIFO date control is described in the *Inventory Management User's Guide*.

## **Step 6. Defining quality control considerations**

You can decide which inventory items will have a shelf life and are subject to cyclic quality control (QC) inspection. The shelf life of an item is expressed as the number of calendar days until QC needs to test the item and enter a QC transaction to approve or reject the item quantity. An item defined as having QC control must also have batch/lot control. Therefore, the shelf life for an item is controlled on a batch/lot basis.

Reports are available to show you those batch/lots of an item whose shelf life has expired or will expire shortly. Once a batch/lot has exceeded its shelf life, it is considered unavailable for use until it has been inspected and approved by quality control. If you answer N to QC Control, the Shelf Life will be defined as 0000.

### **Establish item QC and batch/lot controls**

Use Item Master file maintenance to set quality control, inspect on receipt, and batch/lot control for each item. Each of the control codes is explained, as follows:

#### **Quality control (QC) status**

The QC status of an item can be one of the following:

- 10** Shelf life checked. The item is within its shelf life and inspection is not yet required.
- 17** Manufacturing waiting. The manufactured item requires inspection before it is received into stock.
- 19** Due inspection. The item shelf life has expired and it requires inspection.
- 20** No shelf life. The item does not have a shelf life.
- 80** Reject. The item has been rejected and requires disposal or rework.
- 90** Purchase waiting. The purchased item requires inspection before it is received into stock.

Quality controlled items can have the following characteristics:

1. Shelf life
2. Be inspected before they are received into stock
3. Have both a shelf life and be inspected before receipt.

Use Item Master maintenance on IM menu AMIM70 to specify that the item is batch/lot controlled, quality controlled, or inspected before it is received into stock. You can also use the option to specify the number of calendar days in the shelf life.

When a quality controlled item with a shelf life is received to stock, the QC inspection date is calculated. If you select FIFO date control on the IM install/tailor questionnaire, the number of shelf life days is added to the FIFO receipt date to arrive at the new QC inspection date. If you do not use FIFO date control, the receipt date is added to the shelf life days.

Each inventory transaction checks the QC inspection date. If the date has been reached the batch/lot is unavailable until it passes inspection. After the inspection, a new QC inspection date is calculated.

The Excess Stock report will note those components at a location whose shelf life has expired.

Quality control status tracking is described in the *Inventory Management User's Guide* under the heading "Quality control (QC) inspection."

### **Effect of quality control on replenishments**

The quality control status of a batch/lot affects replenishments. An item that is designated as quality controlled is tracked by batch/lot. If the item also has a shelf life, a FIFO date must be entered when the item is received and on all following transactions. When a batch/lot is received, the initial shelf life expiration date is calculated by adding the number of shelf life days to the FIFO date. A batch/lot which has passed the expiration date cannot be used and must be sent to quality control (QC) for inspection. When the batch/lot passes inspection, a new shelf life expiration date is calculated based on the date the batch/lot was approved by QC.

Expired batch/lots cannot be picked, transferred to a line location, or issued to a production schedule. They can only be transferred or returned to a QC or store room location. If the expired batch/lot is shown on a pick list, the replenishment must be bypassed by entering zero in the quantity picked.

A component with a negative quantity required is considered to be a by-product. When a by-product is batch/lot controlled, the IP transaction generated during the backflush function cannot be applied, because the batch/lot number is not known. The user must select these IPs for maintenance and enter the batch/lot number in order to have them applied.

If a by-product has a shelf life, the FIFO date assigned will be the transaction date.

## **Step 7. Defining floor stock (uncontrolled and controlled)**

### **Uncontrolled floor stock**

You can use Item Balance maintenance to define an item as an uncontrolled floor stock component. The part usually has a low cost, is used in large volumes, and is stocked on the shop floor.

When a production schedule is released, the uncontrolled floor stock component is charged to the schedule as if the quantity needed was fully issued at the time of

release. Inventory is not relieved. You need perform no further parts accounting for the schedule.

The components reach the shop floor through a miscellaneous issue transaction, without the issue being charged to a production schedule. Quantities of the part are drawn from the shop floor location and used to produce other parts or scrapped. When the uncontrolled floor stock component reaches a low enough level, an additional quantity of the item is moved to the shop floor using another miscellaneous issue transaction.

Uncontrolled floor stock items are not automatically replenished by the REP application when empty containers are returned to the store room. Also, the items do not appear on the pick list. You must enter a miscellaneous issue transaction through IM Transaction Entry to send more uncontrolled floor stock items to the shop floor.

To control the replenishment of the component manually at all locations, without tracking the component's usage in detail, define the component as uncontrolled floor stock. If you want to control the replenishment of the component at a specific location manually, use Item/Line maintenance to define the line location as a JIT location.

Uncontrolled floor stock items are described also in the *Inventory Management User's Guide* under the heading "Uncontrolled floor stock."

**Controlled floor stock.** You can also use Item Balance maintenance to define an item as a controlled floor stock component. Controlled floor stock items are treated the same as "regular" components in REP.

Controlled floor stock items are described in the *Inventory Management User's Guide*.

## Step 8. Defining material movement between locations

In order to have the right components at the line in time for production, it is important to understand and define to the system how material moves in the replenishment process. This section describes movement of material between supply, line, and receipt locations. REP's KANBAN function is also discussed.

Figure 2-4 shows how material flow occurs in the REP application:

- Supply locations provide containers of parts to the line locations.
- Feeder lines provide parts immediately to the line through the use of JIT locations, (no pick list is available to support this process).
- Finished parts on the production line go to receipt locations.
- When reports of empty component containers and finished items reach the application, they trigger requests for more parts to flow from the supply locations. This is shown in Figure 2-4 by the arrows pointing back to the supply location.

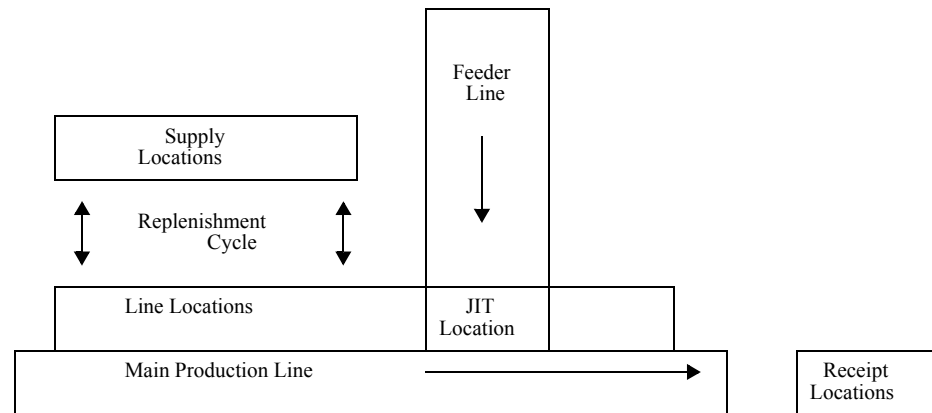


Figure 2-4. Movement between locations, no material available at the production line

Component flow is known as the replenishment cycle because it ensures an adequate supply of components on the production line. This flow starts when the production line is primed and the initial quantity of components is calculated. The initial pick lists cause containers of components to be transferred from the supply locations and moved to the production line. When the components arrive, a component transfer to line (CL) transaction increases the on-hand balances at the line locations.

At the end of the production line, completed units are reported through a schedule receipt (RM) transaction, and the quantity of each component used to produce the completed units is calculated and deducted from the component line location. This calculation is an accounting transaction, and reflects the movement of components from the line locations into the finished product. The usage of these components may cause components to be replenished, as the increased usage may exceed the trigger level at a line location.

The relationship previously described can be entered using Work With Item/Line Maintenance. Using this option, the relationship of supply and line locations can be defined for each component. The receipt location for the end item also can be defined.

To see which locations are empty, print the Empty Locations report from IM menu AMIM23. To see the contents of existing locations, use the Item Detail by Location inquiry from IM menu AMIM10 or print the Locations and Contents report from IM menu AMIM23.

For information on transaction processing, see the section on entering transactions in "The execution cycle—Releasing and Tracking Schedules" on page 2-115.

## KANBAN systems

KANBAN is a method of Just-In-Time production that uses standard containers or lot sizes with a single card attached to each. It is a pull system in which work centers signal with a card that they wish to withdraw parts from operations or vendors that feed them. REP provides support for both manual and electronic KANBAN, using the relationships described in Figure 2-4 on page 2-29.

**Manual KANBAN system** . Material at a line location can be replenished by using KANBAN (replenishment authorization) labels. When you run the Prime Production Lines option from the Material Management menu (AMQM30), the need to supply components to the line is recognized by the system. Later, the print pick list option looks for components needing replenishment and prints the material needed, its supply location, and its line delivery location on the pick list. KANBAN labels can be printed along with or after printing the pick list. Each KANBAN label is attached to or placed in the appropriate component container. When the material is delivered to the line, the information printed on the KANBAN label can be used to enter a material transfer transaction which updates the on-hand balances at the supply and line locations.

As containers of material are used at the line, the KANBAN label is returned with the empty container, and serves as authorization to replenish the material at the line location. You can use the information on the KANBAN label to manually enter a replenishment (RL) transaction or use a bar code scanner (if PM&C is installed) to enter the information rapidly into the system. When the next pick list is printed, additional containers are sent to replace the empty containers, as long as components are still required to meet a schedule.

KANBAN labels do not have to be sent to the stock room, but can be sent directly to the vendor who supplies the material. The KANBAN labels serve as authorization to produce and ship the material. KANBAN also can authorize a feeder line to produce needed parts.

**Electronic KANBAN system** . Electronic KANBAN offers another method of authorizing the sending of parts to the production line. Using the auto-replenishment function, you pre-authorize the transfer of parts. When finished item transactions are processed, the components used to produce the items are backflushed. This causes the usage to be noted by the automatic replenishment mechanism and the stock at the line location to be lowered, without having to enter a replenishment (RL) transaction. In effect, an electronic KANBAN has taken place. You have entered a receipt transaction, and the system is ready to authorize the sending of parts. When the next pick list is printed, components are checked to see if they need replenishment.

Since the automatic replenishment function already knows of any previous usage, it authorizes the picking of any needed components that are controlled through auto-replenishment. There are a number of factors that can be used to specify such things as the minimum and maximum replenishment quantities, how many parts must be used before more parts are sent to the line location, and whether replenishments can be drawn from stock that is being delivered to the line location but has not been allocated to a specific schedule. For more information on these factors, see “Step 2. Defining locations” on page 2-13 and “The execution cycle—Releasing and Tracking Schedules” on page 2-115.

## Step 9. Defining schedules and schedule-controlled items

Use the Item Balance file maintenance option on the REP File Maintenance menu (AMQM50) to define scheduled items and use the Enter and Maintain Schedules option on the REP Schedule Management menu (AMQM40) to enter schedule information.

## Schedule-controlled items

Schedule-controlled items are assembled or finished items that are primarily scheduled and tracked using the REP application. You define items as schedule-controlled in the Item Balance file, using option 1 on the REP File Maintenance menu (AMQM50). The items you define as schedule-controlled are the only items used in “Step 13. Defining the item process on the production line” on page 2-62.

Schedule-controlled items are manufactured on production lines. A schedule-controlled item can also be manufactured in a job shop using a manufacturing order rather than a production schedule, but the existing routing most likely will be altered or a new routing entered for the order due to the use of different facilities. An item that is not schedule-controlled cannot be manufactured on a production line.

## Concurrent schedules

You can run several schedules concurrently. For example, different configurations of the same item are scheduled to be run on the same date and line. The information identifying each schedule (warehouse, item, production line, and schedule date) is the same, but the schedules have different S-numbers. The schedules can be sequenced to run at the same time. Assume the production line can make three units of configuration A, followed by one unit of configuration B, and then repeat the pattern of three As and one B. The schedules run concurrently, but the shop floor determines which configuration to build next. REP does not determine the pattern of how the configured items are sequenced other than sequencing a day's schedule by run sequence number and schedule group code field. The run sequence field is initially blank until you override it with a sequence number.

Concurrent schedules can also be used to build different items at the same time, providing the setups at the work stations can be changed quickly. Naturally, the items should have family setups (the items have similar setups with only small variations at several work stations).

## Schedule group code

You can use this field in the Item Balance file to identify items with similar manufacturing characteristics (items using the same sequence of operations with like setups and cycle times). These items can be assigned the same schedule group code.

Use group technology (the study of parts to determine which parts have similar design or manufacturing characteristics) to classify parts into schedule groups, or use family setups to identify the parts that belong in the same schedule group.

Use the **Schedule Group** field to determine the order in which schedules are shown or printed on displays and reports. For example, the Schedule Entry and Maintenance Detail display shows the production schedules for a day and production line sorted by schedule group sequence so that all schedules with the same schedule group are together. The Sequence Schedules display also shows the schedules sorted by schedule group. Reviewing schedules in this fashion reduces the time needed for setup and tear down and more efficient scheduling is possible.

You can override printing these items in sequence by schedule group code by specifying a user sequence number on the Sequence Schedules display (AMQ452).



You can use the Production Schedules by Schedule Group report (AMQ2N4) to print production schedules by item within a schedule group and production date, for a specific production line and warehouse.

## Lot sizing

Lot sizing is the ability to split planned production schedules into smaller schedules whose schedule quantities are equal to the original production schedule quantity. The item's lot size flag in its Item Balance record must be set to Yes before the item can be lot sized. The planned schedule must also be less than minimum lot size or greater than maximum lot size in order to be lot sized. Lot sizing can be done by using the Use Proposed Change function. See "Lot sizing for multiple schedules" on page 2-102 for more information.

## Use proposed change

The Use Proposed Change function aligns supply (schedules) with demand (customer orders or MRP demand). The Schedule Entry and Maintenance Summary by Item and Line Detail displays show the demand and supply for each day. The **Proposed Change** column shows the difference between demand and supply for each day. Using the Use Proposed Change function key on each display creates schedules to meet demand on days without production schedules. It also changes schedule quantities to the demand quantity on days where demand and supply are not equal, and deletes schedules on days without demand.

When you press the Use Proposed Change function key on the Summary by Item display, the Use Proposed Change function is applied to all of the schedules for the item. When that function key is pressed on the Line Detail display, only the schedules on that date are affected.

The function affects schedules on each day or days, even when the schedules are on different production lines. It does not affect completed schedules.

See "Proposed change processing" on page 2-95 for more information.

## Carry forward function

You may want to track an item's production over a period of time. You can do this by designating schedules as "carry forward". These schedules form a production campaign group. You report production by schedule in the normal manner. Periodically, you use the Carry Forward function key in the Enter and Maintain Schedules option to assess progress for all items and all campaigns. Each schedule in the campaign is evaluated to see if it has produced its schedule quantity. If the schedule is over- or under-production, the difference is calculated. Beginning with the first schedule in the campaign, its difference quantity becomes the carry forward quantity to the next schedule in the campaign. Each schedule in turn adds its difference to the carry forward quantity until the last schedule in the campaign is reached. The carry forward quantity shows how close the schedules in the campaign have come to the production goal for the campaign.

A single item may have several campaigns. For example, different campaigns can be established for each month. The campaigns for the item cannot be overlapped; that is, they cannot be established for the same period of time.

Using the Carry Forward function key on the Schedule Entry and Maintenance displays calculates the carry forward quantity for all items and all campaigns. When schedules are purged, the carry forward calculation also is performed to update the remaining schedules in the campaign. If a schedule in the middle of a campaign is purged, the carry forward quantity on schedules after the purged schedule may appear to be overstated. Typically, you would purge schedules in campaigns in sequence.

The Carry Forward code in the Item Balance record determines whether the item's schedules normally are part of a production campaign. If the code is 1, the schedules are not part of a campaign. If the code is 2, the schedules are part of a campaign. The Carry Forward code can be changed when the schedule is created, or it can be maintained later.

## **Step 10. Defining demand**

The REP application uses demand as the basis for assisting a user in determining production schedules over a period of time. Demand can originate from Customer Order Management (COM), Material Requirements Planning (MRP), or the Schedule Demand (SCHDMD) file. Demand is extracted into the REP application by selecting option 3, Extract Schedule Requirements, on the Schedule Management menu (AMQM40).

The terms "demand" and "requirements" are used interchangeably. COM generally uses the term "demand" while MRP uses the term "requirements." In either case the terms refer to a need that must be satisfied either from inventory or production.

From the COM application, demand is represented by items entered on a customer order. Each item has a manufacturing due date and a quantity. When option 3, Extract Schedule Requirements, is selected on the AMQM40 menu, demand for an item is summarized by date to determine the item's gross demand. Next, available inventory is applied against gross demand starting with the current date. The result is net demand or what must be built to satisfy customer demand. Net demand becomes the basis for scheduling in REP's Enter and Maintain Schedule function.

From the MRP application, demand is usually referred to as requirements. Gross requirements can represent customer demand, forecasts, demand from MPSP, and dependent demand generated from a higher level MRP item. Gross requirements are represented by the item's summarized requirement quantities by date. In the MRP's netting process, gross demand/requirements are offset by available inventory to determine net requirements. Net requirements are then lot-sized into planned orders per the item's order policy code. The resulting planned orders and any firm planned orders becomes the net demand that is extracted into the REP application using the Extract Schedule Requirements option. See "Smoothing demand" on page 2-35 for more information on the MRP netting process.

Using the item's net demand, you can develop or finalize production schedules. If you create production schedules equal to the net demand, then you are planning to build your product to a Just-In-Time philosophy.

### **Sources of net demand**

Net demand for a schedule-controlled item can be reviewed on REP schedule entry and maintenance displays:

- AMQ442—Enter and Maintain Schedules, Summary by Item

- AMQ444—Enter and Maintain Schedules, Summary by S-Number
- AMQ445—Enter and Maintain Schedules, Detail

**Note:** “Net demand” is addressed in the context of XA Repetitive Production Management. The precise definition of REP net demand depends upon the demand extract source.

You can select one of the three sources of REP net demand, or let REP automatically determine the demand extract source based upon which XA applications are installed and interfacing.

The three sources of REP net demand are:

1. Material Requirements Planning (MRP). If MRP is installed and interfacing, it is the default demand extract source.
2. Customer Order Management (COM). If COM is installed and interfacing and MRP is not interfacing, COM is the default demand extract source.
3. Schedule Demand file (SCHDMD). If neither MRP or COM are installed and interfacing, SCHDMD is the default demand extract source. If COM is the default extract source and demand is loaded in the SCHDMD, the SCHDMD demand is added to COM demand by item. This sum serves as the schedule-controlled item's total demand.

You may choose to have net demand extracted from COM for your zero level demand and then MRP for your lower level demand. Your decision must be made depending on whether you are building to customer orders or lot sizing for economic build quantities.

Before REP extracts net demand, it is important that the development of an MRP plan of open, planned, and firm planned orders is completed. If MRP is used as the source of net demand, REP extracts MRP's planned and firm planned orders as net demand over the review horizon. These quantities provide a guide to help you develop a schedule within REP.

Smoothing of net demand is performed during:

- MPSP's generation of master schedules for master scheduled items
- MRP's planning run for scheduled items
- REP's extraction of COM demand
- REP's extraction of demand from the Schedule Demand file.

Net demand is smoothed beginning with the date specified by either the smoothing code or the smoothing start date, and continues to the end of the REP review horizon.

## **Extract source code**

The extract source code in the Item Balance file can override the normal hierarchical demand sources.

These sources are used if the extract source code is blank. If the extract source code is not blank, demand is extracted as follows:

**blank** Default. No override.

- 1** Demand is extracted from MRP. Independent demand (from Forecasting, MPSP, or COM) and dependent demand (component demand from higher

level assemblies and items) is extracted (in the form of planned schedules) and is available to REP.

- 2 Demand is extracted from COM. The customer order backlog from line items and blanket release line items are extracted (netted by available inventory and manufacturing orders) and passed to REP. If planned schedules have been entered into the Schedule Demand file, these are also extracted and are available to REP. Past due demand is also included on the date of extract.
- 3 Demand is extracted from the Schedule Demand file only. If demand has been entered into the file, it is extracted and passed to REP.

### Smoothing demand

When you smooth net requirements, uneven demand is processed to maintain more level production, enabling you to use resources more efficiently. Net requirements are the daily gross demand less the available inventory. Net requirements represent the minimum quantity that must be built in order to satisfy gross demand. Along with available inventory, for example, if 1,000 units are needed on Friday and no inventory is available, but the capacity of the production line is 400 units per day, the demand can be spread out over the week and only 200 units need to be produced each day as shown in Figure 2-5. Smoothing lowers the line utilization to less than 100% capacity, but the benefits are a relatively constant daily amount for the flow of component parts to the production line and use of resources. However, using this approach may cause inventory levels to rise at a modest level over a short period of time.

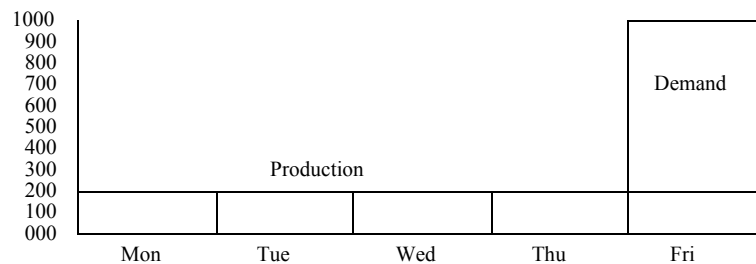


Figure 2-5. Demand smoothing example 1

If an additional 500 units are needed on Wednesday, demand can be spread again and 300 units produced each day as shown in Figure 2-6. The 500 units for Wednesday are produced on Monday and Tuesday. The remaining 100 units from Tuesday are added to the 300 units produced on each remaining day (Wednesday, Thursday, and Friday) to fill the 1,000 units needed by the end of the week.

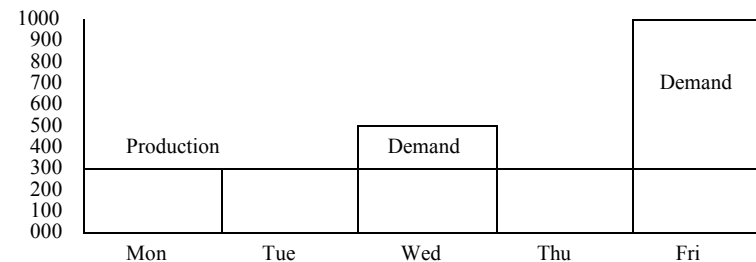


Figure 2-6. Demand smoothing example 2

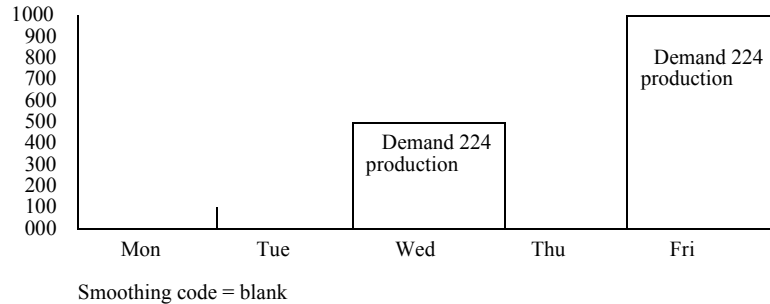
By smoothing net requirements over prior days, it may be easier to schedule production and still ensure that net requirements are met on the due dates. The longer the horizon over which net requirements are smoothed, the smoother the resulting plan. However, you need to balance the benefits of having smoothed production schedules to a potential of building inventory over the horizon. More examples of smoothing net requirements are discussed later in this section.

**Smoothing code** . The smoothing code determines whether or not the item's net requirements are to be smoothed and when smoothing should begin. Demand characteristics for certain items may dictate your choice of which smoothing codes to use. Some items may have fairly consistent demand from day to day. Others may have intermittent demand, while others just coming into production may have demand further into the future. If the smoothing code is blank, smoothing will not occur.

You can choose the smoothing start date by entering the proper smoothing code in the Item Balance record for an item, on display AMI7A7, or by entering a smoothing start date that overrides the date generated by the smoothing code. The smoothing code values are:

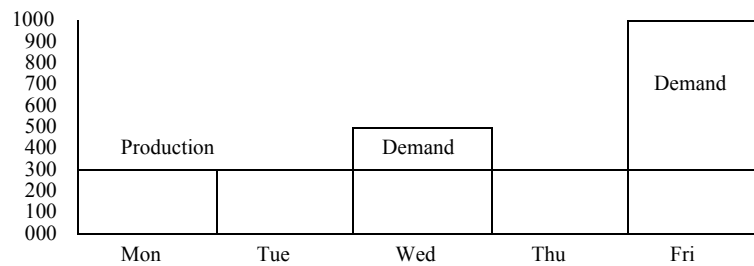
- blank** No smoothing
- 1** Repetitive schedule release horizon plus one work day
- 2** First date of net requirements

If the smoothing code is blank, as shown in Figure 2-7, the net requirements appears as it is projected to occur.



*Figure 2-7. Effect of using no smoothing*

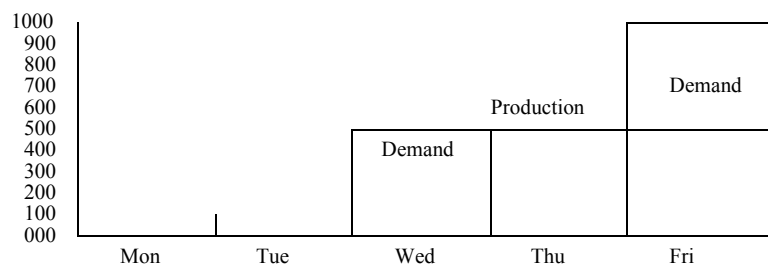
If the smoothing code is 1 as shown in Figure 2-8, any net requirements after the REP schedule release horizon and on or before the review horizon are smoothed. Assuming the REP schedule release horizon is Friday, the smoothed net demand for the following week is shown as 300:



Smoothing code = 1

*Figure 2-8. Effect of using smoothing code 1*

If the smoothing code is 2 as shown in Figure 2-9, smoothing begins with the first date on which net requirements appear and ends with the review horizon end date. The smoothed net demand is 500.



Smoothing code = 2

*Figure 2-9. Effect of using smoothing code 2*

## Smoothing start date

The smoothing start date allows you to control exactly where in the horizon you want to begin smoothing. Prior to this date, the smoothing algorithm is not active (even if you have specified a smoothing code). On this date, smoothing will start and continue to the end of the review horizon.

One use of the smoothing start date is to prevent producing parts too early, as in the case of introducing a new product. In this case, the new product tooling will not be available until some future date.

The smoothing start date can be:

- REP schedule release horizon plus one work day (default). When this smoothing start date is selected, the system date plus one work day is used as the start date for calculating smoothed requirements. If capacity constraints are significant and you want to build ahead rather than significantly vary production rates, this can be a better selection than using the first date of net demand. REP schedule release horizon plus one work day can also be used for items with constant demand, that are continuously manufactured and shipped from stock.
- First date of net requirements. When this start date is selected, the first date of net requirements is used as the start date for calculating smoothed requirements and

preceding dates are ignored. If any large net requirements spike exists on the smoothing start date, you may not see any smoothing effect because there are no previous days to smooth the demand spike. If the first date of net requirements is before the REP schedule release horizon plus one work day, the greater of the two dates becomes the smoothing start date.

- User-specified override date. When you enter the smoothing start date, it must be equal to or greater than the system date and be equal to or less than the schedule review end date. The system retains this date until it is changed or becomes older than the system date, at which point the smoothing code is used to determine the smoothing start date.

Note that inside the smoothing horizon you must be careful about using proposed changes. Schedules inside the horizon may have been smoothed sometime in the past while the net demand is from the last extract. Procedurally you should recognize these changes and resolve how to handle the situation.

The smoothing start date is stored in the Item Balance record. You can maintain both the smoothing code and the smoothing start date using:

- Enter and Maintain Schedules display (AMQ442),
- MRP display AMM351, if MRP is installed and interfacing with REP
- MPSP displays AML452 and AML453, if MPSP is installed and interfacing with MRP

### Smoothing algorithm logic

Following is a step-by-step explanation of the smoothing algorithm logic. Each step has two parts: an explanation and a numeric example. The assumed smoothing horizon is eight days with day 1 as the smoothing start date.

The primary steps of the smoothing algorithm are:

1. Determine the smoothing horizon and requirements within the horizon.

The total demand for a 10 day period is 285 units. The smoothing horizon ends at day 8 since it is the last day that has requirements within the 10 day review horizon.

<b>Day:</b>	<b>1</b>	<b>2</b>	<b>3</b>	<b>4</b>	<b>5</b>	<b>6</b>	<b>7</b>	<b>8</b>	<b>9</b>	<b>10</b>	<b>Total</b>
Total requirements	73	40	25	5	40	30	32	40	0	0	285

2. Apply available inventory of 43 units to determine the item's net requirements by day.

The net requirements remaining over the example horizon is 242 units (after applying the available inventory of 43 units on day 1). The resulting net requirements follows:

<b>Day:</b>	<b>1</b>	<b>2</b>	<b>3</b>	<b>4</b>	<b>5</b>	<b>6</b>	<b>7</b>	<b>8</b>	<b>9</b>	<b>10</b>	<b>Total</b>
Net requirements	30	40	25	5	40	30	32	40	0	0	242

3. Calculate the cumulative net requirements by day within the smoothing horizon. The cumulative net requirements represents the minimum quantity that must be built in production. Therefore, cumulative net requirements plus available inventory will satisfy the total requirements.

<b>Day:</b>	<b>1</b>	<b>2</b>	<b>3</b>	<b>4</b>	<b>5</b>	<b>6</b>	<b>7</b>	<b>8</b>	<b>9</b>	<b>10</b>
Cumulative Net requirements	30	70	95	100	140	170	202	242	0	0

4. Divide the total of cumulative net requirements in step 3 (242 units) by the number of work days (8 days) from the smoothing start date to the date of last net requirements in the horizon (day 8). The result is a need to build 30.25 units per day.

<b>Day:</b>	<b>1</b>	<b>2</b>	<b>3</b>	<b>4</b>	<b>5</b>	<b>6</b>	<b>7</b>	<b>8</b>	<b>9</b>	<b>10</b>
First Cut Production	30	30	30	30	30	30	31	31	0	0

This is the first cut at a smoothed production schedule. The fraction is summarized and rounded to the next higher integer and distributed one unit a day starting with the date of last net requirements within the smoothing horizon and working backwards toward the smoothing start date. In this case, 242 units divided by 8 working days yields a stable production of 30 units per day with a remainder of 2 units. The remainder is spread from the last net requirements in the horizon back toward the current date (1 unit at a time).

**Note:** Steps 5 through 8 are repeated until a smoothed schedule is determined which meets the original due dates of unsmoothed net requirements.

5. Calculate the cumulative production schedule by day within the smoothing horizon.

<b>Day:</b>	<b>1</b>	<b>2</b>	<b>3</b>	<b>4</b>	<b>5</b>	<b>6</b>	<b>7</b>	<b>8</b>	<b>9</b>	<b>10</b>
Cumulative First Cut Production	30	60	90	120	150	180	211	242	0	0

6. Subtract the cumulative net requirements of step 3 from the cumulative production of step 5 to determine where cumulative production will not meet cumulative net requirements. The following table shows negative deltas and indicate problems with the production schedule.

<b>Day:</b>	<b>1</b>	<b>2</b>	<b>3</b>	<b>4</b>	<b>5</b>	<b>6</b>	<b>7</b>	<b>8</b>	<b>Total</b>
Daily Deltas	5-	10-	2+	22+	12+	12+	10+	0	0

Positive values indicate where cumulative production will exceed cumulative net requirements which leads to a build up of inventory.

The algorithm will continue to loop through the preceding calculations (with some variation) until all negative values are eliminated. When this is achieved, production will meet requirements over time and with a relatively smooth production schedule in terms of units produced per day.



7. To adjust the production plan (calculated in Step 4) and to eliminate the negative variances, you must increase production between the smoothing start date and the production date with the largest negative variance (day 2) to the smoothing start date by the delta divided by the number of days. Therefore, an extra 10 units of production must be spread through days 1 and 2 and 10 units must be removed from days 3 through 8. This results in adding 5 units per day to days 1 and 2 ( $10 \div 2$ ) and 1.66 units per day to days 3 through 8 ( $10 \div 6$ ). However, since decimals cannot exist in the production scheduling algorithm, the decimals are summed on days 3 through 8 to yield a total of 4 units (.66 x 6). These units are spread backwards from the last day in the horizon (1 unit per day). The results of these calculations follows. In the example, the largest negative variance is 10.

Day:	1	2	3	4	5	6	7	8	Total
Spread	5+	5+	1-	1-	2-	2-	2-	2-	0
Largest Negative Delta									

8. Add the deltas (in step 7) to the previous first cut production (in step 4) to arrive at a second cut production schedule.

Day:	1	2	3	4	5	6	7	8	9	10	Total
Second Cut Production	35	35	29	29	28	28	29	29	0	0	242

9. Calculate the cumulative production by day within the smoothing horizon using the quantities determined in the previous smoothing iteration (step 8).

Day:	1	2	3	4	5	6	7	8	9	10
Cumulative Second Cut Production	35	70	99	128	156	184	213	242	0	0

10. Subtract the cumulative net requirements of step 3 from the cumulative second cut production in step 9 to arrive at a set of daily deltas.

Day:	1	2	3	4	5	6	7	8	9	10
Daily Deltas	5+	0	4+	28+	16+	14+	11+	0	0	0

11. Since the deltas are either zero or positive, the results of the second cut production schedule in step 8 is the final smoothed production schedule; no further smoothing iterations are required. By implementing this schedule a slight buildup of inventory will occur on days 1 and 3 through 7. However, the production schedule is relatively flat compared to the requirements pattern in step 1.

12. In MRP, after the smoothing algorithm is completed, lot-sizing according to the item's MRP order policy code is invoked to determine planned orders for that item in the bill of material. The MRP minimum, maximum, and multiple modifiers are also applied. Subsequently, these orders are exploded to lower levels in the MRP generation to determine component requirements. The net requirements for the components of the item are calculated within MRP and smoothed. Generally, an order policy code of 'A' (discrete) is used to convert the smoothed production schedule (or MRP net requirements) to planned orders.

For the smoothed production in step 11, assume the lot-size is discrete (order policy code 'A'), and a released schedule of 25 units is due on day 1. The mix of planned orders and released schedules that REP extracts from MRP as net requirements is:

<b>Day:</b>	<b>1</b>	<b>2</b>	<b>3</b>	<b>4</b>	<b>5</b>	<b>6</b>	<b>7</b>	<b>8</b>	<b>9</b>	<b>10</b>	<b>Total</b>
Schedule receipts	25	-	-	-	-	-	-	-	-	-	25
Planned orders	10	35	29	29	28	28	29	29	0	0	217
Net demand	35	35	29	29	28	28	29	29	0	0	242

**Note:** The MRP planning run and MPSP master schedule generation increase in run time with the smoothing algorithm.

### Smoothing examples with different start dates

An example of the effect for using different smoothing start dates follows. The smoothing algorithm logic steps previously discussed are used, only the smoothing start date is changed.

**Example 1.** This example uses the first date of net demand as the smoothing start date. The smoothing code in the Item Balance record is 2.

In the example, the first date of net demand is day 5, and the schedule review horizon end date is day 10. Therefore, the smoothing horizon is 6 days long.

<b>Day:</b>	<b>1</b>	<b>2</b>	<b>3</b>	<b>4</b>	<b>5</b>	<b>6</b>	<b>7</b>	<b>8</b>	<b>9</b>	<b>10</b>	<b>Total</b>
Net Demand	0	0	0	0	150	300	200	250	50	250	1200

When the first date of net demand is chosen as the smoothing start date for the smoothing algorithm, the algorithm ignores the dates that precede the first date of net demand and treats that date as day 1 of the smoothing horizon. If the first date of net demand is before the greater of the REP schedule release horizon-plus-one work day or MRP Current Date, the greater of these two dates is the smoothing start date as shown in the preceding example for smoothing code 1.

Using the first date of net demand as the smoothing start date may be preferred when you do not wish to build inventory too early.

The step-by-step calculation is illustrated as follows:

<b>Contents</b>	<b>Index</b>
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<b>Day:</b>	<b>1</b>	<b>2</b>	<b>3</b>	<b>4</b>	<b>5</b>	<b>6</b>	<b>7</b>	<b>8</b>	<b>9</b>	<b>10</b>	<b>Total</b>
Net Requirements (step 2)	0	0	0	0	150	300	200	250	50	250	1200
Cumulative Net Requirements (step 3)	0	0	0	0	150	450	650	900	950	1200	1200
First Cut Production (step 4)	0	0	0	0	200	200	200	200	200	200	1200
Cumulative First Cut Production (step 5)	0	0	0	0	200	400	600	800	1000	1200	1200
Deltas of Cumulative First Cut Production (step 6)	0	0	0	0	50+	50-	50-	100-	50+	0	
Spread Largest Negative Delta (step 7)	0	0	0	0	25+	25+	25+	25+	50-	50-	
Second Cut Production (step 8)	0	0	0	0	225	225	225	225	150	150	1200
Cumulative Second Cut Production (step 9)	0	0	0	0	225	450	675	900	1050	1200	1200
Deltas of Cumulative Production (step 10)	0	0	0	0	75+	0	25+	0	150+	0	

Because the second cumulative deltas are either zero or positive values, the second iteration of step 8 is the final smoothed net demand for example 1.

### Manufacturing lead times

The lead times entered in the Item Balance file are not directly used by the REP application but should have realistic values for use by other manufacturing applications. The lead time fields for schedule-controlled items are in days, while the production line times are in hours. The following suggested values should be used when setting up the lead time fields:

- **Lead Time Code**—This field can be either M (manufacturing) or P (purchasing). Use M for schedule-controlled items.
- **Lead Time Manufacturing**—The amount of time from starting the first unit at the first operation to receiving the last unit at the last operation. This value should be the sum of the changeover time, flow time, and the result of multiplying the cycle time by the standard lot size (minus 1 unit). The total is divided by the number of hours that the primary production line is run each day.

**Note:** The flow time contains the cycle time for the first unit, so the total cycle time (standard lot size times cycle time) must be reduced by one unit. Cycle time

in this instance is defined to be the time between units coming off the production line.

- **Variable Manufacturing Lead Time**—The portion of the total manufacturing lead time which depends on the quantity produced. Enter the cycle time. The total is divided by the number of hours that the primary production line is run each day.
- **Adjusted Manufacturing Lead Time**—The portion of the total lead time required for quantity-independent administrative activities such as review time or requisition processing time. This value is added to the standard manufacturing lead time to arrive at the total manufacturing lead time.
- **Average Manufacturing Lead Time**—Enter the average number of days between the schedule start date and the schedule completion date.

### **MPSP/MRP considerations in creating planned schedules/orders**

When using the smoothing function in MPSP and MRP, you should use order policy code A (discrete order quantity) or G (time periods of supply) with one day of supply. Both of these order policy codes create planned orders for the exact amount of the smoothed demand. You may want to consider using a multiple order modifier field if you schedule production in terms of standard containers. For example, if your container holds 100 pieces, the order modifier would be for 100. The maximum order modifier could be used to warn you of production exceeding a desired maximum production for a day. The minimum order quantity could be used to raise your production to a minimum desired level.

If the MPSP application is installed and interfacing, you should enter values for the following MPSP, MRP, and REP fields:

- Master production schedule item code
- Master production schedule planning source code
- Master level item code
- Order policy code
- Number of days (in MPSP, time periods of supply)
- Minimum order quantity
- Multiple order quantity
- Maximum order quantity.

If the MRP application is installed and interfacing, you should enter values for the following MRP fields:

- Master level item code
- Order policy code
- Number of days
- Minimum order quantity
- Multiple order quantity
- Maximum order quantity

For REP, you should enter values for the following fields:

- Order policy code
- Number of days
- Minimum order quantity
- Multiple order quantity
- Maximum order quantity

Most of these fields are in the Item Plan file (ITMPLN), which you maintain by selecting the Item Balance option on the File Maintenance menu (AMQM50). The

Item Plan file fields are on the Item Balance File Maintenance–Planning Information display (AM17A8).

Refer to the *Material Requirements Planning User's Guide*, and the *Master Production Schedule Planning User's Guide* for a detailed explanation of order policy codes. Refer to "Order point" and "Economic order quantity (EOQ)" in the *Inventory Management User's Guide* for an explanation of order policy codes B and C.

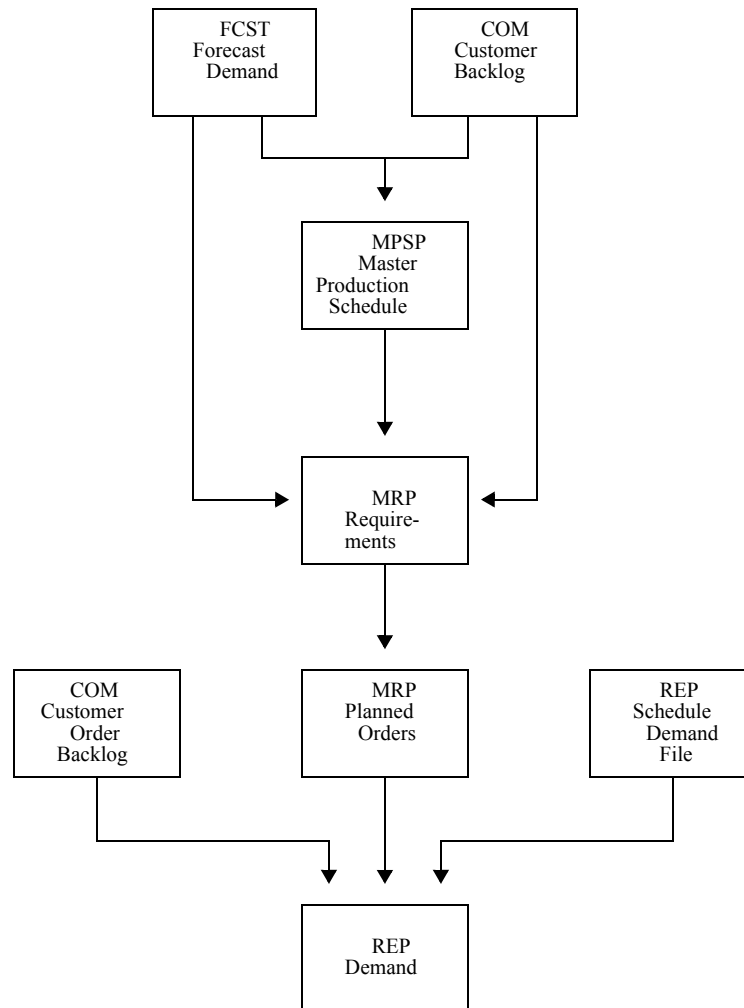


Figure 2-10. Flow of demand

When you run the MPSP Master Production Schedule Generation and MRP Planned Order Generation (or Net Change) options, three processing steps (1, 2, and 4) and an optional step (3) take place if the item is schedule-controlled and requires smoothing.

1. Demand (gross requirements) is extracted.
2. Available inventory and scheduled receipts are applied to arrive at net requirements.

3. Net requirements are smoothed (optional).
4. Planned orders are generated and lot sized.

When you run the REP Extract Demand menu option, three similar processing steps take place.

1. MRP planned orders are extracted.
2. COM customer backlog by item and day is extracted.
3. Schedules placed in the Schedule Demand file are extracted.

## Step 11. Defining routings

You must set up a routing for each schedule-controlled item in the Routing file using EPDM or PDM. If a routing is already set up, add REP information to the operation record.

After entering your routings, you can review your entries using the Routing inquiry in EPDM or PDM or print them from EPDM or PDM in a costed or not-costed format.

### Routing

A routing describes the method of manufacture for a particular item, and includes the operations to be performed and their sequence. The operation sequence number shows the order of the operations, and each operation shows the standard times for setup and run. The work station or work center involved is also shown.

For example, a routing for the base frame of a filing cabinet could be composed of 5 operations. These operations are always performed whenever this item is built.

<b>Oper</b>	<b>Wrk Stn</b>	<b>Setup</b>	<b>Run</b>	<b>Description</b>
0010	Shears	0.2	.05	Cut to length
0020	Form	0.3	.05	Notch and bend
0050	Weld	0.2	.05	Weld corner
0060	Grind1	0.2	.05	Rough grind
0070	Grind2	0.2	.05	Finish grind

## PDM considerations for alternate (or additional) operations

At times, you may need to add additional operations to a base routing. The additional or alternate operations can be entered into PDM's routing and used as needed.

For example, the base frame may need weights added to balance cabinets with deep drawers or holes for the cabinet lock. The PDM routing would appear as:

Oper	Alt Rtg	Wrk Stn	Setup	Run	Description
0010		Shears	0.2	.05	Cut to length
0020		Form	0.3	.05	Notch and bend
0030	AA	Cutter	0.1	.05	Slit for base weights
0040	AA	Weight	0.1	.05	Add base weights
0050		Weld	0.2	.05	Weld corner
0060		Grind1	0.2	.05	Rough grind
0070		Grind2	0.2	.05	Finish grind
0080	BB	Drill	0.1	.05	Drill lock holes

The Alt Rtg column represents the alternate (additional) operations that can be selected with the base routing. In PDM Routing maintenance function, this field is called the **Select Code**. This code determines an alternate routing that can be selected for an item built on a specific production line. If alternate routing code AA is selected for this item, the schedule's routing appears as:

Oper	Alt Rtg	Wrk Stn	Setup	Run	Description
0010		Shears	0.2	.05	Cut to length
0020		Form	0.3	.05	Notch and bend
0030	AA	Cutter	0.1	.05	Slit for base weights
0040	AA	Weight	0.1	.05	Add base weights
0050		Weld	0.2	.05	Weld corner
0060		Grind1	0.2	.05	Rough grind
0070		Grind2	0.2	.05	Finish grind

The routing would produce a base frame with weights. If the base frame can have both base weights and a cabinet lock, the PDM routing would appear as:

<b>Oper</b>	<b>Alt Rtg</b>	<b>Wrk Stn</b>	<b>Setup</b>	<b>Run</b>	<b>Description</b>
0010		Shears	0.2	.05	Cut to length
0020		Form	0.3	.05	Notch and bend
0030	AA	Cutter	0.1	.05	Slit for base weights
0031	CC	Cutter	0.1	.05	Slit for base weights
0040	AA	Weight	0.1	.05	Add base weights
0041	CC	Weight	0.1	.05	Add base weights
0050		Weld	0.2	.05	Weld corner
0060		Grind1	0.2	.05	Rough grind
0070		Grind2	0.2	.05	Finish grind
0080	BB	Drill	0.1	.05	Drill lock holes
0081	CC	Drill	0.1	.05	Drill lock holes

You would use an alternate routing selection code of CC to include all possible operations. The base frame routing can now support four different configurations.

You can define routings without base operations. All operations are then specified with an alternate routing code. In effect, the master routing is composed of several sets of subroutings, each controlled by a different alternate routing code. When a schedule is entered, you must enter an alternate routing select code, and the resulting routing must have at least one operation.

### **Inactive operations**

An operation's status can be either active or inactive. After a schedule is released, only the active operations can be reported although both types of operations appear in the schedule's routing.

You may want to define an inactive operation to be used for rework or to provide an alternate facility where work can be performed when the primary facility is overloaded. Use Released Schedule Maintenance to change the operation status. If you change an active operation to inactive, the components used at the operation are also set to an inactive status. When an operation is changed to an active status, the components also become active.

### **Effect of alternate operations on product costing**

Use alternate operations with care. When an alternate operation is used as part of a production schedule's routing, the overhead cost and standard machine or labor costs are calculated, as is the material cost for the components. These figures are added to the schedule's costs.

Product Costing does not distinguish between base operations and alternate (additional) operations. Product costing adds the operation cost for ALL operations into the accumulated overhead, machine, and labor costs for the item, and the purchase and material costs for ALL components are added to the item's cost.



## **EPDM considerations for alternate operations**

EPDM provides for primary and alternate processes. A process generally will describe the exact material and operations to use when producing an item. Consequently, alternate operations, as described for a PDM interface, is most likely not used.

When you define the item/line relationship, you will also specify the process to be used; that is, the bill of material and routing version to use. See Item/Line Maintenance in this chapter for more information.

## **Additional routing descriptions**

When you enter an operation, you can also enter an expanded description that provides more detail about the work done by the operation. Information on operator skill levels, maintenance and setup procedures, tooling, tolerances, and inspection and testing criteria and methods can also be entered.

## **Reporting points**

Receipts are normally reported at the last operation. Under certain circumstances, however, you should report the number of units completed at an operation prior to the last operation.

For example, if the production process takes longer than a shift to complete a unit, the number of units completed by a shift could be reported. If the flow time (production process time for one unit) is 12 hours, you can establish a reporting point at the operation that is performed 8 hours after a unit is started. If the flow time is 20 hours, two reporting points can be defined, 8 hours apart.

It can also be desirable to report the number of units completed by a troublesome operation. When the number of completed units decreases, the operation may be experiencing difficulties.

Operations can be selected as reporting points. After an operation has been selected, the number of units completed by the operation is always reported.

Reporting points are treated as intermediate receipt points and are reported using an Operation Reporting (RO) transaction. Each time the number of units is reported through an Operation Reporting transaction, the costs for that operation and all preceding operations (to the previous reporting point or the first operation in the routing) are calculated and charged to the schedule. The costs charged to the schedule include the materials used, the standard labor and machine hours, and the overhead costs. These charges provide a timely accounting of performance and costs.

A Schedule Scrap (SM) transaction is used to report partially completed units that are scrapped at an operation. The operation can be a reporting point, but the transaction can be reported against any operation. The last operation of the routing is always considered a reporting point, and should not be specifically defined as such. A Schedule Receipt (RM) transaction will backflush costs from the last operation back to the previous reporting point.

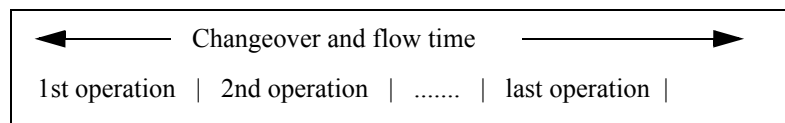
## Scheduling operations

During repetitive manufacturing, operations are not scheduled. Since materials flow from one work station to another, manufacturing is continuous. Operations begin as soon as the first unit reaches the work station and continue until the last unit leaves the work station. However, the operation start dates are calculated in order to determine the date on which the components used in an operation are needed. If a routing takes 3 days to complete a unit, the components for the first operation are needed when the schedule is started and later operations need their components on the second and third days.

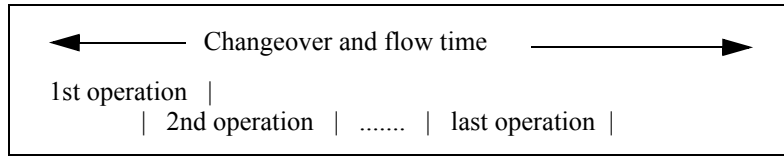
Operation start dates are determined by first calculating the operation time for each operation. The setup and run duration per unit (determined by the prime load code from the work station record in the Production Facility file) are added to the move and queue times.

Move time is specified in the operation record of the Routing file and queue time in the work station record in the Production Facility file. These values are normally zero when work stations on a production line are used to manufacture the product. If work centers are used and are not located close together, you may need to enter move and queue times. Move time is the time in days to move work from one operation to another. You normally specify move time as a positive value. Negative move times can be used when describing a feeder line as part of the manufacturing process. (See “Synchronized feeder lines” on page 2-50 for more information on using negative moves times.) The move time per operation is calculated by multiplying the move time (in days and hundredths) from the operation record by 8 hours. The queue time per operation is calculated by multiplying the queue time (in days and hundredths) from the work center record by 8 hours.

After the operation times have been calculated, they are added together and the result is compared to the sum of the changeover and flow times. If the total operation time is less than the changeover plus flow time, the operations are forward scheduled. The operation start date of the first operation is set equal to the schedule start date. The operation start date for the second operation is determined by adding the operation time of the first operation to the schedule start date. If the number of hours exceeds the total available line hours for that day, the second operation’s start date is advanced to the next work day. The operation start date for each operation is determined by adding the operation time for the previous operation to the start date of the previous operation.



If the total operation time is greater than the changeover plus flow time, the operations are backward scheduled. The operation end date of the last operation is set equal to the end date of the flow time. The operation start date for this operation is determined by subtracting the operation time from the end date of the flow time. If the number of hours exceeds the total available line hours for that day, the operation’s start date is changed to the previous work day. The operation start date for each operation is determined by subtracting the operation time from the previous operation’s start date. As the total operation time is greater than the changeover plus flow time, the earliest operations may be overlapped and have the same start date.



The length of each work day is determined by adding the base shift lengths to the variable shift lengths. Base shift lengths are the number of hours that the production line can normally be run, and are entered in the production line record of the Production Facility file as the desired shift lengths.

Variable capacity shift lengths are changes to the base shift lengths which increase or decrease the number of hours available by shift. When you enter variable capacity shift lengths through Production Facility maintenance, also enter the date when the change takes effect and the number of days it will be in force.

### Synchronized feeder lines

The application allows you to integrate synchronized feeder lines into an assembly line. For example, you may have a truck assembly line with integrated power unit (engine and transmission) and cab feeder lines.

Routing operations

Main Assembly 0010... ..0090	Power Unit 0100... ..0160	Main Assembly 0200... ..0290	Cab 0300... ..0420	Main Assembly 0500... ..0990
---------------------------------	------------------------------	---------------------------------	-----------------------	---------------------------------

Operation timings

Main assembly	0010... ..0030	0070... ..0090	0200... ..0290	0500... ..0990
Power unit	0100... ..0160			
Cab	0300... ..0420			

A single truck routing is used to describe this manufacturing process. In this example, every operation is assumed to take the same amount of time (2 hours). That is, the sum of the move, queue, and run times for each operation are assumed to be equal. The total routing is shown, followed by a break out of the operations for the main assembly line, power unit feeder line, and cab feeder line in time sequence.

The main assembly line begins with operation 0010. At operation 0200 the power unit is received and installed into the truck chassis. At operation 0500 the truck cab is installed. Operations 0510 through 0990 complete the truck assembly. Operations 0100 through 0160 build the power unit, and are overlapped (that is, run in parallel) with operations 0030 to 0090 on the main assembly line. Operation 0160 places the completed power unit into a JIT location where it is used by operation 0200. Operations 0300 through 0420 build the cab assembly, and are overlapped with main assembly operations 0070 through 0290. Operation 0420 places the completed cab into another JIT location where operation 0500 installs it on the truck chassis.

The total manufacturing time (flow time) for a feeder line is calculated by adding the queue and run times for the first operation; the move, queue, and run times for all other feeder line operations; and the move time necessary to place the unit in stock at the proper line location of the main assembly line. The power unit feeder line has 7 operations and has a flow time of 14 hours (7 operations x 2 hours). Each power unit must be completed before it is installed in the truck chassis at operation 0200. Therefore, the first operation of the power unit feeder line has a negative move time of 1.75 (equivalent to 14 hours), aligning the start of the feeder operations with the start of operation 0030 on the main assembly line. Similarly, the cab feeder line has 13 operations and a flow time of 26 hours. The move time in the first feeder operation is negative 3.25 days, and the first feeder operation is aligned with operation 0070 on the main assembly line.

This technique is useful for feeder lines that are fully integrated and synchronous with the main assembly line. That is, the assembly line to feeder line relationship is such that:

- A shutdown on the main assembly line will also shut down the feeder lines.
- The assemblies produced on the feeder lines are matched to the units coming down the main assembly line.

This technique should not be used with asynchronous feeder lines, which provide a stock of assemblies for use by the main assembly line and continue to run while the main assembly line is stopped. If it is important to know how many assemblies are produced by a feeder line and how many units are in stock at the end of the feeder line, you must schedule the feeder lines separately from the main assembly line.

To keep production reporting for the feeder lines and main assembly line separated, reporting points must be established at the end of each main assembly line segment and at the end of each feeder line. In our example, there are 3 main assembly segments and reporting points are needed at operations 0900 and 0290. The last segment ends at the last operation, 0990, which by default is automatically a reporting point. The feeder lines end at operations 0160 and 0420, and reporting points are needed at these operations.

The completion of units on a feeder line is reported through Operation Reporting (RO) transactions. A Schedule Receipt (RM) transaction is allowed only at the last operation. In our example, RO transactions at operations 0160 and 0420 report the completion of power units and cabs. An RM transaction at operation 0990 reports the completion of a truck.

Without reporting points, confusion would reign. Without a reporting point at operation 0090, entry of an RM transaction at the end of the power unit feeder line also would signal that operations 0010 through 0090 were completed on the main assembly line. Without a reporting point at operation 0160, an RO transaction at operation 0290 of the main assembly line also would signal that a power unit has been built on the feeder line. The reporting points keep the reporting for each feeder line separated from the reporting for the main assembly line.

Feeder lines make their product available to the main assembly line by moving it from the end of the feeder line to a JIT line location on the main assembly line. Since the feeder and main assembly lines are integrated, no transactions are needed to record the movement.

## Yield

The percentage of the expected parent quantity at the end of an operation compared to the quantity at the beginning of an operation.

Operation yield is used primarily where loss occurs as a product moves through each stage or operation. The operation yield is expressed as a percentage of the parent quantity that will remain in the production process at the end of the operation compared to what came into the operation.

Operation yield should not be confused with component loss. Operation yield is a loss in the parent quantity and component loss is a loss of an ingredient during the operation.

## Yield by operation

Operation yield is a planning factor that predicts the number of scheduled items lost during a manufacturing operation. The loss is expressed as the percentage of the units entering a manufacturing operation that are completed. This factor does not predict loss or scrap of components.

Component scrap occurs when a component is damaged during the manufacturing process and another must be used. It is reported through the Component Scrap transaction. Component loss can be caused by evaporation, spillage, or breakage, and is compensated for by increasing the amount of the component used in the operation.

For further information on operation yield, see the headings “Operation yield,” “Adjusted quantity per,” and “Impact of operation yield on product costing, material requirements, and scheduling” in the *Product Data Management User’s Guide*.

## Cumulative yield

The yield at an operation has a cumulative effect on the manufacturing process. Cumulative yield is determined by successively multiplying the operation yield at each operation through all operations. The result is the number of units that will exit the process. The Repetitive scheduling process considers yield and calculates component materials required at operations so that a schedule quantity can be attained at the last operation. In the following example, a cumulative yield of 72% indicates that 39 units will be lost in the process of building 100 units (139-100).

In the following example, a schedule is released to produce 100 units and has a routing with the following yields:

Oper	Yield	Run	Comp Qty Per
0010		1.0	2
0020	90%	1.0	1
0030		1.0	1
0040		1.0	2
0050	80%	1.0	1
0060		1.0	2

A comparison of the run hours and components required demonstrates the difference between a yield of 100% and the yields shown:

Oper	Yield	Run	Comp Qty Per	100% Run	100% Comp	Yield Run	Yield Comp
0010		1.0	2	100	200	100	200
0020	90%	1.0	1	100	100	100	100
0030		1.0	1	100	100	90	90
0040		1.0	2	100	200	90	180
0050	80%	1.0	1	100	100	90	90
0060		1.0	2	100	200	72	144
				600	900	542	744

For 100% yield, all 100 units are completed at operation 0060. When operations 20 and 50 have yields of 90% and 80%, only 72 units are completed in operation 0060 and fewer run hours (542) and components (744) are used.

A Schedule Scrap (SM) transaction is used to report the loss of scheduled items. The labor, materials, and overhead costs used to produce the lost units are calculated and charged to the schedule as scrap costs. Should you experience a higher scrap rate than planned, additional components are transferred to the line to make up for the higher losses.

### Adjusted quantity per

Adjusted quantity per represents the engineering quantity per in the product structure file adjusted for yield. This value is calculated in EPDM/PDM's Calculate Yield option and in REP's Released Schedule file maintenance option when a new component is added to a released schedule. Adjusted quantity per is used in the schedule release and replenishment processes to plan material for line locations. The calculation that is used to calculate a component's adjusted quantity per is:

$$\text{Adj Qty Per} = \text{Qty Per} \times \frac{\text{Cumulative Yield through Prev Operation}}{\text{Cumulative Yield through All Operations}}$$

The effects of yield on Adjusted Quantity Per is shown in the following example for a schedule quantity of 100.

Rtg Oper	Oper Yield	Cum Yield %	Oper Quantity	Compo-nents Req	Quantity Per	Adjusted Quantity Per	Schedule Requirement
0010	100	100	139	A	1	1.389	138.891
0020	90	100	139				
0030	100	90	125				
0040	100	90	125				
0050	80	100	125	B	1	1.250	125.000
0060	100	72	100	C	1	1.000	100.000

## Operation run quantity

At each operation, one or more of the scheduled items are being produced. The Operation Run Quantity is the standard number of units expected at the operation, and is used to calculate the Work-In-Process (WIP) value of the units. The labor, material, and overhead costs used to produce the units through that operation and all preceding operations is calculated and added to WIP.

Material costs for units on the production line are not charged to the schedule until the completed unit is received or reported as complete through an operation reporting point. Until that time, the material costs are in component inventory. When WIP material costs are calculated, the component (or store room) inventory cost is reduced and the material costs added to WIP.

## Step 12. Defining bills of material

You must set up a bill of material in the PDM Product Structure file or in the EPDM BOMHDR file for each schedule-controlled item. Use the appropriate option in those applications to set up these records.

The bills of material you enter are used in “Step 13. Defining the item process on the production line” on page 2-62 and allow you to assign line locations for each component used on the production line.

### Operation Where Used

Each component is used at a specific operation that is identified by the **Operation Where Used** field. You can enter the operation sequence number for an operation in the top level routing. If you leave the **Operation Where Used** field blank, the first operation in the top level routing is considered to be the operation where the component is used. If this is a component from a phantom item, the operation must be from the top level routing and cannot be an operation from the phantom item's routing. You can use the mass change facility in Work With Item/Line to assign the same operation where used to a set of components. See Chapter 9 for information on using the mass change facility.

The **Operation Where Used** field is important to the accurate tracking of materials and costs. When units are reported as complete, the components from that operation and all prior operations are charged as material cost to the schedule. The component stock is relieved from the line locations associated with the components that have been charged.

For example, a production line has five work stations, each performing an operation. A Schedule Receipt (RM) transaction reports that 20 units have been completed. The components are issued and charged to the schedule, and the inventory at the line locations is reduced by the component quantity used.

Oper	Comp	Qty Per	Line Loc	Old On Hand	New On Hand
0010	AA	1.0	L11	500	480
	AB	2.0	L15	200	160
0020	BB	1.0	L22	400	380
0030	CC	1.0	L31	350	330
	CD	5.0	L32	800	700
0040	DD	1.0	L41	200	180
0050	EE	3.0	L53	100	40

At operation 0030, 20 units of component CC and 100 units of component CD are used. The inventory at line location L31 is reduced from 350 units to 330 units, and the inventory at location L32 reduced from 800 to 700 units. The same process occurs at each of the operations. The **Operation Where Used** value determines the components used, and Component /Line definitions in the CMPLIN file in turn determine the line locations from which components are issued to the schedule. You can use Work With Item/Line Maintenance to set the override operation where used for phantom components or for regular components.

If operation 0020 is a reporting point, then a production receipt transaction backflushes the components from operations 0020 and 0010. Components AA, AB, and BB are issued and charged to the schedule, and the on-hand balances at line locations L11, L15, and L22 are reduced.

## Features and options

A bill of material can have one or more features defined. A feature is used when the item you are building can have more than one configuration. For example, when you order a car you can specify the engine type, type of transmission, body color, body trim, interior color, and accessories (such as the radio, air conditioning, and sun roof). Each car can have a unique combination of features.

You can specify a feature by entering the item number of a feature where the component item number is normally entered. You can also indicate whether the feature is required or optional. The bill of material for a car can look like:



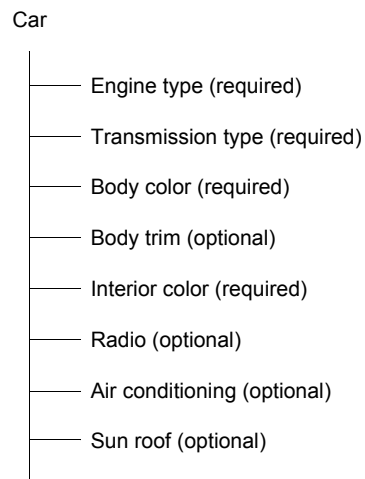


Figure 2-11. Bill of material for a car

The item number of a feature leads you to another bill of material that describes the options available. For example, the feature bills of material for the transmission type and radio are:

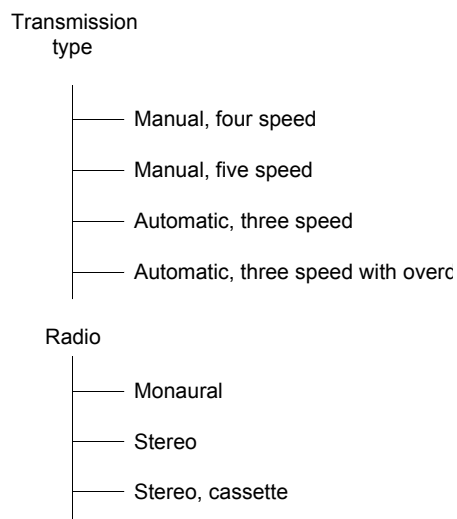
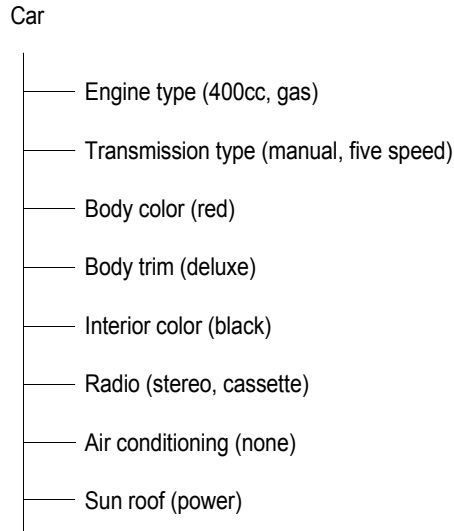


Figure 2-12. Bill of material for a transmission type and radio

When a production schedule is entered for an item having features, the options are selected through the use of an S-number (select number). Each section of the S-number corresponds to a specific feature. The value you enter in that section of the S-number determines the option, which is a component used to build the finished item. The component is used in a specific operation and is stocked at a designated line location. Features are used to group options and relate them to the finished item's bill of material. They are never used in any operation, and are never stocked at the production line.

When a schedule is released, the item's bill of material is used to create the production schedule's bill of material. Only the components used by the production

schedule appear in its bill of material. For example, the bill of material for a car with a specific S-number appears as:



*Figure 2-13. Bill of material for a car with a specific S-number*

Only the specified components (for example, 400 cc. gasoline engine, manual 5-speed transmission) appear in the car's bill of material. Other options for the engine or transmission feature do not appear. Since no option was chosen for the air conditioning feature, the air conditioning kit does not appear in the bill of material.

Each option is normally a single component. If the option requires multiple components, a kit or sub-assembly unit (a group of parts used in manufacturing a specific option) should be used. The item number assigned to the component (option item number) defines a kit or sub-assembly grouping. Only the kit appears in the bill of material for a production schedule, not the individual components in the kit.

When a feature is part of an item's bill of material, you must enter the operation where the feature is used. Since only the selected option appears on the production schedule's bill of material, the feature's **Operation Where Used** is used by the option.

## Phantom item number

A phantom (or common) item number is used to group a number of components together. These components are commonly used as a group in many assemblies. When you assign a phantom item number, the common components are grouped in the phantom item's bill of material and do not have to be added to each assembly in which they are used. Instead, the phantom item is added to the bill of material for each assembly.

When a production schedule is released and an insufficient quantity of the phantom is available, the components of a phantom item will appear in the production schedule's bill of material instead of the phantom itself. If sufficient quantity of the phantom is available to satisfy the schedule, only the phantom will be in the bill of material.

The process of substituting the components for the actual phantom item is called blow-through. Blow-through is not limited to a single level in a bill of material. For

example, a bill of material used to build an item can contain phantom items. The bills of material for the phantom items can also contain phantom items.

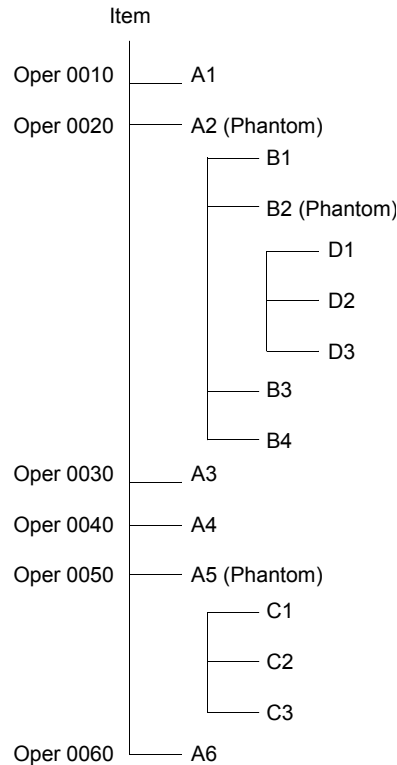


Figure 2-14. Phantom bill of material

Component A2 is a phantom item and its bill of material contains another phantom item, B2. Component A5 is also a phantom item, but its bill of material has no phantom items. When a production schedule for the item is released, it can contain a combination of the components A1 to A6, B1 to B4, C1 to C3, and D1 to D3. The components from all levels (including the lowest) can appear in a production schedule's bill of material.

When a production schedule containing a phantom item in its bill of material is released, inventory is checked to see if the phantom item is available. Available inventory is defined here as on-hand total quantity minus pending manufacturing allocations minus quantity pending release minus manufacturing allocated quantity minus pick list requirements. All of this data is stored in the Item Balance file for the phantom item in the warehouse that the schedule was entered for. If a sufficient quantity of the phantom item is available, the schedule uses the phantom item. If the available quantity is less than the quantity needed, the phantom item's components appear on the production schedule's bill of material.

In this example, if there is sufficient stock for component A2, then components B1, B2, B3, and B4 do not appear in the schedule's bill of material. If there is an insufficient number of A2 components and enough of component B2, then components D1, D2, and D3 do not appear in the bill of material. If there are not enough B2 components, then components D1, D2, and D3 appear.

Normally, a phantom item is not stocked in inventory, but defines a nonstocked subassembly that appears at one point in the manufacturing cycle and is immediately used.

When a phantom item is added as a component to a bill of material, the operation using the phantom item is entered. When blow-through is performed and lower level components are added to the production schedule's bill of material, the **Operation where Used** specified in the Component/Line definition for each component of the phantom is used.

If a phantom item has a routing, the phantom item's operations are not added to the production schedule's routing. Normally, component material used in the phantom bills of material are expected to be used at the routing operation where the first level phantom is defined. The **Operation where Used** specified in the Component/Line definition for the components of phantoms must be included in the routing for the end item. Components B1 to B4 and D1 to D3 will be backflushed from the operation in which component A2 is defined. Likewise, component material C1 to C3 is backflushed from the operation in which A5 is defined. The operation where first used for components of phantoms can be handled by a default that exists in the Item/Line file.

### Component item and user sequence

A component can be used in more than one operation, but each time it is used in a different operation, the component must be entered into the bill of material. The **Operation Where Used** and a unique user sequence number must also be entered. To use user sequence numbers, you must answer Yes to the question "Do you want to use user sequence numbers for your bills of material?" in the EPDM or PDM install/tailor questionnaire. Your response to the question "How do you want to use user sequence in relation to component items?" in the questionnaire determines the order that the components appear on reports. The combination of component item and user sequence numbers uniquely identify the component, and each unique component can be used in a separate operation.

In the example, component AAA is used in operations 0010, 0030, and 0040. The component appears in the bill of material three times. To uniquely identify the component, user sequence numbers AA01, AA02, and AA03 are used.

Operation	Component	User Sequence
0010	AAA	AA01
0020	BBB	
0030	AAA	AA02
0040	AAA	AA03
0050	CCC	

You can use unique sequences to assign user sequence numbers. In the example, a phantom bill of material adds component AAA to operation 0030 with a user sequence number from the XXX series of numbers. The user sequence numbers used for other components in the finished item's bill of material are from the DDD series of numbers.

Operation	Component	User Sequence
0010	AAA	DDD1
0020	BBB	
0030	AAA	XXX2
0040	AAA	DDD3
0050	CCC	

After entering your bills of material, you can review your entries using a variety of displays and reports. EPDM and PDM let you display the bill of material in a costed or not costed format, and both let you print the bill of material in a costed or not costed format. Both applications let you see only the features and options for the selected items. You can also print an indented product structure retrieval and a summarized retrieval to verify that you are able to uniquely identify components that can appear on the same finished item bill of material.

### By-product

A by-product is specified in the bill of material by entering a negative quantity per. This quantity indicates the amount of the item generated at the operation.

### Backflushing material and labor by operation

A production line starts with the necessary components delivered to the line. The finished items are counted when they come off the production line, and the quantity of the components used to produce the finished items is calculated. The technique of reporting component use when the finished item is complete is called backflushing.

You can choose to backflush using either the adjusted quantity per or the standard quantity per. Backflush codes are provided in the Warehouse Master and Item Balance files, allowing you to set the default for all items in the warehouse, and to override it for individual component items you want to handle differently.

Standard labor, machine hours, and material issued amounts are calculated when units are reported for material receipts (RM), operation reporting (RO), or schedule scrap (SM) transactions. These amounts are calculated for each operation and charged to the production schedule.

Overhead costs for each unit also are calculated based on the operation's standard labor and machine hours and posted to the production schedule. Planned issue transactions are created for the material.

For the preceding transactions, the amounts are calculated from the last reporting point to the operation where the transaction occurs. If operation 50 is a reporting point and the transaction occurs at operation 80, calculations occur for operations 60, 70, and 80. In addition if the transaction is a schedule scrap transaction, calculations occur back to the first operation so that a total scrap cost can be calculated and posted to the production schedules as scrap costs. If an item does not have a reporting point, then calculations occur back to the first operation.

Each transaction backflushes the material consumed. The components used by the operation are identified through the **Operation Where Used** field in the component/line (CMPLIN) record. Then the quantity-per from the MODATA record is multiplied by

the number of units completed or scrapped and posted to the issue and usage fields in the MODATA record. The material is also deducted from the line location and the Item Balance on-hand quantity and manufacturing allocated quantity. In addition, the allocated quantity in the Location Quantity (SLQNTY) record and the Allocated Quantity (SLALLO) record is reduced.

The following example shows how a receipt causes backflushing through lower operations. The production schedule calls for building a quantity of 10 of item A. Item A consists of the following components: one B, one C, three H, one I and one J. Item A requires operations 10, 20, 30, 40, and 50. Operation 20 is a reporting point (shown as RP at operation 20 in Figure 2-15).

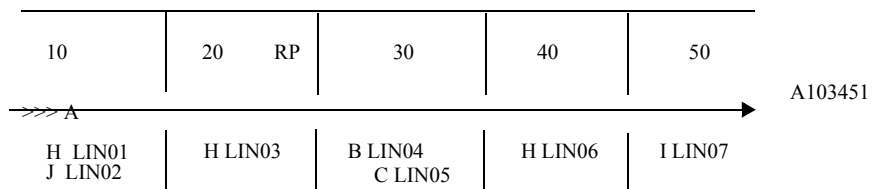


Figure 2-15. How a receipt causes backflushing through lower operations

Ten units are received from operation 20, a reporting point, and cause the following to be backflushed:

Operation	Backflush Quantity	Component to Backflush	Location to Backflush
20	10	H	LIN03
10	10	J	LIN02
10	10	H	LIN01

Operation 20 backflushes component H from location LIN03, J from LIN02, and H from LIN01.

This means that the material cost for 20 of component H and 10 of component J and the standard labor cost and overhead cost for operations 10 and 20 are charged to the schedule. The on-hand quantity and manufacturing allocated quantity in the Item Balance records is decremented by the backflush quantity for H and J. The location quantities and allocation quantities are also reduced by 20 for component H and 10 for component J.

Five units are scrapped at operation 40 and cause the following to be backflushed:

Operation	Backflush Quantity	Component to Backflush	Location to Backflush
40	5	H	LIN06
30	5	C	LIN05
30	5	B	LIN04
20	0	H	LIN03
10	0	J	LIN02
10	0	H	LIN01

Operation 40 backflushes component H from location LIN06. Operation 30 backflushes component C from location LIN05. Operation 30 backflushes component B from location LIN04.

When five units are reported scrapped at operation 40, the standard material, labor, machine, and overhead costs used at operations 30 and 40 are calculated for each operation and posted to the schedule as production costs and scrap costs. In addition, component issue transactions for 5 each of H, C, and B also are created. Processing then continues back to the first operation to accumulate the remainder of the scrap costs for posting. In this case, standard material, labor, machine, and overhead costs at operations 10 and 20 are accumulated and posted. Component costs for J and H (2) are accumulated for each unit scrapped, for a total of 5 and 20 respectively. No material issue transactions are created at operations 10 and 20, since these materials were already issued by an operation reporting (RO) transaction.

The on-hand quantity and manufacturing allocated quantity in the Item Balance records, the line location quantity, and the allocation quantity are reduced by five of component H, five of component C, and five of component B.

**Note:** The reporting point does not affect this scrap process. Scrap can be reported at any operation. Operations where scrap is reported do not have to be reporting points.

Later, 10 completed units are received at the end of the production line (operation 50) and cause the following to be backflushed:

Operation	Backflush Quantity	Component to Backflush	Location to Backflush	Stock Location
50	10	I	LIN07	A103451
40	10	H	LIN06	
30	10	C	LIN05	
30	10	B	LIN04	

Operation 50 backflushes component I from location LIN07. Operation 40 backflushes component H from location LIN06. Operation 30 backflushes component C from location LIN05 and component B from location LIN04.

This backflushing means that material costs for 10 of component I, 10 of component H, 10 of component C, 10 of component B, and labor costs for operations 30, 40, and 50 are charged to the schedule.

The on-hand quantity in the Item Balance records and at the line locations for components I, H, C, and B are reduced by 10 for each component.

Backflushing ends at operation 30 because a reporting point is reached at operation 20. Ten units of item A are placed into inventory location A103451.

## Step 13. Defining the item process on the production line

You have now defined most of the elements needed to run the REP application. When you enter the production line layout, all of the information that you have defined is brought together. You have described:

- The items to be scheduled
- The information used to extract, smooth, and lot size demand

- The production lines and work stations used to produce items
- The information for scheduling production lines and production schedules
- The components used
- The stocking locations supplying components
- The manufacturing operations used
- The stocking locations for completed items.

The following information is defined in this step:

- Scheduling factors for production schedules
- Schedule lot sizing factors
- The line locations receiving components
- The operation where a component is used
- The component's replenishment method and factors governing the quantity.

Three files are used to store the information previously listed. The first two files hold the production line layout for each item.

The Item/Line (ITMLIN) file has a record for each item you produce on a specific production line. The combination of production line and item identifies the Item/Line record.

The Component/Line (CMPLIN) file has a record for each component used to produce the item on the production line. When phantom items are used as components in bills of material, lower level bills of material may be searched and their components added to the top level bill of material. The Component/Line file has a record for each of these lower level components also. The combination of production line, item, component parent item, component parent's user sequence number and component and user-sequence number identifies the Component/Line record.

The Component/Location (CMPLOC) file stores the information used to control replenishment of the component in the location. The combination of line location and component identifies the Component/Location record.

Now you need to describe the basic manufacturing timings and lot sizes to produce the item on the production line. This information is stored in the Item/Line file.

- The time to change over (set up) the production line
- The total time to produce a single unit
- The time between the production of each completed unit
- Whether the processing time for this item can be overlapped with the processing time for the previous schedule on the production line.
- The schedule start option for the first schedule of the day
- The default alternate routing select code or the item process to be used
- The default line location (used for released schedule maintenance)
- The schedule quantity for a typical production run
- The minimum schedule quantity
- The maximum schedule quantity.

Use option 3, Work With Item/Line, on the REP File Maintenance menu (AMQM50) to describe the production line, or lines, used to produce each item.



An item can be produced on one or more production lines. One production line is selected as the primary line defined in the item balance file, and all others are considered alternates. The primary line is the line that receives the item's demand. If you use more than one production line to produce an item, you also need to describe all alternate lines.

If you are installing the REP application, you may not have defined any of the line layouts used to produce an item. Use the Work With Item/Line and Work With Component/Line panels to add the necessary Item/Line and Component/Line information.

If you are adding new items or production lines to an installed REP application, you still need to add the missing Item/Line and Component/Line information. Any maintenance in the product structure file requires you to revalidate the component/line relationships.

When new components are added to a scheduled-controlled item's bill of material, the component is also added to the production line layout following the operation where the component is used. The line location must be entered before schedules can be released against this line. If the work station facility stock location exists, it will be used as the line location in the CMPLIN file, if the **Operation where used** is defined in the PSTRUC or BOMHDR file.

The following discusses the information contained in the Item/Line file. Not every field is discussed. Field descriptions are also shown in Chapter 9.

## EPMD's Item Process

When EPDM is activated, when you define an item to a line, you must specify the EPDM item process that it will use. The EPDM item process represents a paired bill and routing linked by a component's **Operation where used** field.

## Changeover time

The changeover time specifies the maximum amount of time necessary to set up the production line before producing the first unit of the new item. The sum of the operation setup times may be used to calculate the changeover time. However, if several people are needed to perform a setup, the setup hours may not reflect a total duration but a total number of person hours required for the setup. If you are manufacturing products (such as food products) which require you to tear down and clean the line before you can use it for another product, you must add this time to the changeover time.

Changeover time is used to calculate the total duration of a production schedule, which in turn determines the utilization on the production line and affects later production schedules on the line.

A production line can be empty or have previously produced a different item. Depending on the product that was previously run, the actual changeover time can be less than the value you enter. When you use the Sequence Schedules display to determine the order in which you plan to run that day's production schedules, you can reduce the actual changeover time for each schedule. For example, you can consecutively run two schedules for products that have common (family) setups or use the same components at the same line locations. When you sequence the two schedules, you can enter a lower changeover time for the second schedule due to reduced operation setups and material stocking for the later schedule.

If the previous (yesterday's) schedule produced the same item, the changeover time for the next day's schedule is considered to be zero by the Sequence Schedules display.

The actual changeover time can also be influenced by parallel setups and setup crew sizes. If the line is empty and some or all operations are set up at the same time, the actual setup time is less than the changeover time. If a setup crew is used, setups also take less time. You should, however, specify the maximum time needed for the planned item and production line changeover.

If EPDM is activated, changeover, flow, and item rate can be calculated by EPDM based on data in the routing file for the item process selected.

### **Flow time**

Flow time is the amount of time needed to produce a single unit from the start of the first operation to the completion of the last operation, including the move, queue, and run times from the operations. It does not include changeover (setup) time or overlap time.

Flow time is used to calculate the total duration of a production schedule, which in turn determines the load on the production line and affects later production schedules on the line.

If EPDM is activated, changeover, flow, and item rate can be calculated by EPDM based on data in the routing file for the item process selected.

### **Item rate designator and item rate**

The item rate is the rate at which units are completed and can be entered as either pieces per hour or hours between units (cycle time). Pieces per hour and cycle time are reciprocals. If an item has a rate of two units per hour, then the cycle time for that item is a half hour (an item is produced every 30 minutes). Use the item rate designator P/C code to select:

- P** Pieces per hour
- C** Hours between units (1/cycle time)

For the item rate value, enter either the number of pieces produced each hour or the number of hours between the completion of each piece.

At times, production rates can change. When workers are needed in another area, for example, a line can be run at a slower pace with a reduced work force for several days. On the Sequence Schedules display, the item rate for a schedule can be changed to match the new pace, without changing the line's normal rate. In this way, only a few production schedules are affected.

Item rate is used to calculate the run time of a production schedule, which in turn determines the load on the production line and affects later production schedules on the line.

If EPDM is activated, changeover, flow, and item rate can be calculated by EPDM based on data in the routing file for the item process selected.

## Overlap code

The overlap code determines whether the start of a production schedule can be overlapped with the completion of the previous schedule. If schedule overlap is allowed, production of a new schedule can be started before the current schedule is completed.

The amount of overlap can vary. The maximum overlap between the current schedule and the new schedule occurs when:

- As the last unit of the current schedule completes its operation at the first work station on the production line, setup for the first operation of the new schedule is begun.
- As the last unit of the current schedule completes each successive operation, setup is begun for the new schedule.

The maximum overlap time is the smaller of:

- The amount of time from the current schedule that can be overlapped by the new schedule:  $\text{Overlap Time} = \text{Flow Time} - \text{Cycle Time}$  (from the current schedule)
- The amount of time from the new schedule that can be overlapped with current schedule:  $\text{Overlap Time} = \text{Changeover} + \text{Flow Time} - \text{Cycle Time}$  (from the new schedule)

The maximum overlap time is initially shown on the Sequence Schedule display, and can be changed to fit the circumstances on the shop floor.

Overlap time is used to calculate the total duration of a production schedule, which in turn determines the load on the production line and affects the scheduling of later production schedules on the line.

## Default alternate routing code

An item can be built on multiple production lines, each with different capabilities. The Default Alternate Routing Code determines which operations are normally added to the routing when the item is built on a specific production line. (Alternate routings are normally used only with PDM, since PDM supports only a single routing for an item.)

For example, one production line has advanced work stations, capable of performing more than one operation. Another production line has basic work stations, capable of performing single operations. The routing describes each operation, and a different Default Alternate Routing Code is specified for each production line. The routing can be specified in the following manner:

Operation	Alternate Routing Code	Work Station
0010		L10
0020	BB	L20
0021	AA	L21
0030	BB	L30
0031	AA	L21
0040		L40

AA is the default alternate routing code for the production line with advanced work stations. The four operations are performed at three work stations. Work station L21 performs operations 0021 and 0031.

Operation	Alternate Routing Code	Work Station
0010		L10
0021	AA	L21
0031	AA	L21
0040		L40

BB is used for the production line with basic work stations. The four operations are performed at separate work stations.

Operation	Alternate Routing Code	Work Station
0010		L10
0020	BB	L20
0030	BB	L30
0040		L40

If EPDM is activated, alternate routings can be defined in the item process record, and can be selected to be used on a given item line.

### Effects of alternate operations on changeover and flow times

As you can see from the preceding example, the operations on each production line are different. The changeover and flow times for each production line must match the operations used. For example, work station L21 on the advanced production line may have a shorter run time than work stations L20 and L30 on the basic production line. Be sure to specify the correct changeover and flow times for each production line used to produce the item. Overlap may also vary.

### First schedule start option

The first schedule of the day on the production line can start with changeover, flow time, or cycle time.

The schedule start option for the first schedule of the day will determine whether or not the schedule's changeover time or flow time, or both, is scheduled to begin on the previous day. You can select 1, 2, or 3 in the **First Schedule Start Option** field. The default value is 3.

- If you enter **1** and this item is the first item scheduled on a line for a given date, the schedule will assume to start and end on the schedule date. Therefore, the line changeover hours, flow time hours, and all cycle time hours are consumed on the schedule date.
- If you enter **2** and this item is the first item scheduled on a line for a given date, the schedule will assume to start on the previous work date with changeover hours. Flow time hours and cycle hours are consumed on the schedule date.
- If you enter **3** and this item is the first item scheduled on a line for a given date, the schedule will assume to start on the previous work date with changeover hours and flow time hours (first piece). Cycle hours are all consumed on the schedule date.

Thus, any changeover time and time associated with the production of the first item (flow time) will be scheduled on the previous day.

### **Item/Line considerations**

When you maintain your production layout, you need to consider the following:

- How components are selected during Schedule Release
- The effects of S-numbers and the Alternate Routing Select Code on component selection

### **Selecting components during schedule release**

Production schedules are created by Schedule Release. Each component and line location in a schedule must be in the same controlled warehouse as the finished item.

During Schedule Release, all base operations in the finished item's routing are added to the schedule's routing along with those specified by the alternate routing code (if one was entered). If a component in the finished item's master bill of material has an **Operation Where Used** that matches a base operation or matches a selected alternate routing operation in the schedule's routing, it is added as a base component to the schedule's bill of material. Each component's delivery or line location must be a valid location in the schedule's warehouse.

In the following example, a production schedule is released using the specified master routing. The Alternate Routing Selection Code is blank, so only the base operations and associated components appear in the schedule's routing and bill of material.

Standard Routing Oper	Standard Routing Alt Rtg	Standard Routing Comp	Schedule Routing Oper	Schedule Routing Comp
0010		AA1	0010	AA1
		BB1		BB1
0020		CC1	0020	CC1
0030	AA	DD1		
0040		EE1	0040	EE1
		FF1		FF1
		GG1		GG1
		HH1		HH1
0050	AA	II1		
0060		JJ1	0060	J
				J1
		KK1		KK1
0070	CC	LL1		
		MM1		
		NN1		
0080	CC	OO1		
0090		PP1	0090	PP1

### Effects of S-number and alternate routing code on component selection

As discussed earlier, model line items are items that can have different configurations. A production schedule for a model line item uses an S-number (Select Number) to identify the needed features and options. The master bill of material for the model line item defines the features as components. The feature uses another bill of material to define the feature's options as components. The schedule's S-number identifies the specific option used for each feature.

Each feature has an **Operation Where Used** field that also applies to the selected option. When a feature is added to the master bill of material, the operation where the feature is used is also entered. The **Operation Where Used** from the feature is considered the operation where the options are used. If the feature's **Operation Where Used** matches an operation in the schedule's routing, the option is added to the schedule's bill of material. The delivery or line location for the option must be a valid location in the schedule's warehouse.

In the following example, a schedule is released for a model line item and an S-number of 01 03 02 is entered. The master routing shows that Feature 1 is used at operation 10 and the S-number selects option 01. Feature 2 is used at operation 40 and option 03 is selected. Feature 3 is at operation 70 with option 02 selected.

Standard Routing Oper	Standard Routing Alt Rtg	Standard Routing Comp	Schedule Routing Oper	Schedule Routing Comp	Standard Routing Oper
0010		AA1	(01)	0010	AA1
		BB1	(02)		
0020		CC1		0020	CC1
0030		DD1		0030	DD1
0040		EE1	(01)	0040	
		FF1	(02)		
		GG1	(03)		GG1
		HH1	(04)		
0050		II1		0050	II1
0060		JJ1		0060	JJ1
		KK1			KK1
0070		LL1	(01)	0070	
		MM1	(02)		MM1
		NN1	(03)		
0080		OO1		0080	OO1
0090		PP1		0090	PP1

You can use an alternate routing select code to add additional operations to the schedule's base routing. These additional operations can add new components to the schedule. If a component in the master bill of material has an **Operation Where Used** that matches an additional operation in the schedule's routing, the new component is added to the schedule's bill of material. All additional components must also be in the same warehouse as the finished item and the base components. Each additional component's delivery or line location must be a valid location in the schedule's warehouse.

In the following example, a production schedule is released and has an alternate routing selection code of AA. The schedule's routing has base and selected alternate operations. The bill of material has base components and the components associated with the selected alternate operations. Operations 0060 and 0070 are not added to the schedule's routing and their associated components are not added to the bill of material.

Standard Routing Oper	Standard Routing Alt Rtg	Standard Routing Comp	Schedule Routing Oper	Schedule Routing Comp
0010		AA1	0010	AA1
		BB1		BB1
0020		CC1	0020	CC1
0030	AA	DD1	0030	DD1
0040		EE1	0040	EE1
		FF1		FF1
		GG1		GG1
		HH1		HH1
0050	AA	II1	0050	II1
		JJ1		JJ1
		KK1		KK1
0060	CC	LL1		
		MM1		
		NN1		
0070	CC	OO1		
0080		PP1	0080	PP1

The alternate routing can be defined without base operations. In effect, the master routing is composed of several sets of smaller routings, each controlled by a different alternate routing select code. When a schedule is released, an alternate routing select code must be entered, and the resulting routing must have at least one operation.

Each smaller routing can be defined for the manufacturing process used in a specific warehouse. In this case, when the schedule is released, the warehouse and associated alternate routing select code must be entered, and all components in the schedule's bill of material must have valid delivery locations defined in the specified warehouse.

In the following example, a production schedule is released with an alternate routing select code of BB. The production schedule's routing contains only the selected operations (0040, 0050, and 0060), and the bill of material has only the components associated with those operations.



Standard Routing Oper	Standard Routing Alt Rtg	Standard Routing Comp	Schedule Routing Oper	Schedule Routing Comp
0010	AA	AA1		
		BB1		
0020	AA	CC1		
		DD1		
0030	AA	EE1		
		FF1		
0040	BB	AA1	0040	AA1
		BB1		BB1
0050	BB	CC1	0050	CC1
		DD1		DD1
0060	BB	EE1	0060	EE1
		FF1		FF1
0070	CC	AA1		
		BB1		
0080	CC	CC1		
		DD1		
0090	CC	EE1		
		FF1		

### Default line location

Every component must have an assigned line location. This is the location on the production line where this component is stored. Replenishments are moved to this line location, and it is from this line location that the component is issued to manufacture the scheduled item. You can choose the default location where components added to this parent item will be sent. When you use Released Schedule maintenance to add new components to a released schedule, the default line location is assigned, unless you enter a different line location for the component. You also can use the mass change facility in Work With Item/Line to assign the same line location to a set of components. If the field is left blank and if there is a facility stock location assigned in the production facility record, the program will use the **Operation Where Used** field to determine the associated work station and consequently the line location for the component. Note that when using the latter function, the status code in the Item/Line file is set to Review, which will allow you to immediately release a schedule without first having to review its line location.

### Phantom component's operation

A scheduled item can have components which are phantom items. These phantoms also can have phantom components. Each component must be assigned to an operation in the top level routing. That is, each component must have an operation where used value. The phantom component's operation code selects the method by which the operation where used is initially assigned to components of phantom items.

Due to the various ways in which users may assign **Operation Where Used** information to components of phantoms in their product structure records, REP attempts to provide some flexibility on how to describe this information in Item/Line maintenance. It is important to make this distinction because the **Operation Where Used** field determines the operation where components are backflushed and where the components are shown on some displays and reports.

In Item/Line maintenance, you have an option on how you want to assign phantom component operation values to components of phantoms. This option applies only to components of the phantom. Once the option is selected and executed, you can change it only by deleting the Item/Line record and adding it again. Day to day changes in product structure and routings are communicated automatically to component records in the Item/Line file. Examples of product structure changes are adds, deletes of components, and changes to the **Operation Where Used** field. Examples of routing changes are deletes to an operation record.

The options for assigning phantom component operation information to components are:

1. Inherit phantom operation. All components of the phantom are assigned the phantom item's operation where used.
2. Assume first operation. The components of a phantom are always used at the first active operation of the scheduled item's (parent) routing. The **Operation Where Used** field is blank, which means the first operation.
3. Retain component operation. The components of a phantom are used at the operation described in the component's product structure record.
4. Force operation review. Lets you assign Operation Where Used values to the components. Component line records are created with the **Operation Where Used** field set to \*\*\*. A review flag is set on, forcing the review of the components and entry of valid where used information.

You can use the Item/Line maintenance option on menu AMQM50 to review and change the **Operation Where Used** values for the components of scheduled items.

After an item has gone through schedule release, its bill of material is made up of the components from the top level bill of material (the bill of material from the scheduled item) and components from lower level phantom items. You must provide the operation where each component is used, and the production line location where the component is stored. When the item/line information was entered, a default value for the **Operation Where Used** field may have been assigned to the components of phantom items through the selection of an assignment method.

## Schedule lot sizing factors

You can use schedule lot sizing to control the quantity of an item to be built on the production line. The schedule lot sizing factors (lot size, minimum quantity, and maximum quantity) can be set for any scheduled item on any production line. Different sets of lot sizing factors can be established for the same item on different production lines. If you always manufacture the item in a specific quantity, set the Minimum Lot Size, Standard Lot Size, and Maximum Lot Size to the specific quantity.

Lot sizing parameters should be in multiples of the standard container size that is the specified in the Item Balance file. Specifying a Minimum Lot Size of 93 and a container size of 10 would not be logical, and REP will not allow it.

**Schedule lot size.** You can have the schedule quantity be a multiple of the lot size to meet a batch requirement in your manufacturing process. For example, you produce the scheduled item in lots of 24 because a rack used during assembly holds 24 items. Or, you produce in lots of 12 because that is your sales unit of measure for the item.

**Minimum schedule quantity.** You can have the schedule quantity meet a minimum quantity, so set up costs are spread over a sufficient quantity. Or, set the minimum quantity for a certain time period of supply (for instance, 3 days supply).

**Maximum schedule quantity.** You can limit the schedule quantity to a maximum to prevent overloading at a critical workstation, meet a volume constraint in the manufacturing process, or increase production flexibility by limiting the time that the production line is tied up producing a single product.

## Step 14. Choosing REP operational options

You can choose various options that affect the way the application operates. These options are contained in the Repetitive Control file (REPCTL). They are in addition to those defined during install/tailor. Use option 10 on the REP File Maintenance menu (AMQM50) to choose these options.

- Assign a default batch/lot ID. Unapplied planned issue (IP) transactions may be created when a component is batch/lot controlled and negative inventory balances are allowed at stocking locations. The IP transaction is trying to issue from a stocking location that has no inventory, and, therefore, the batch/lot ID cannot be determined. When this situation occurs, this option lets you choose between assigning a default batch/lot ID of ##### or leaving IP transactions in an unapplied state.
- Prevent schedule quantity and due date changes. You can choose to prevent changes to the quantity and due date of a primed schedule.
- Allow allocated stock for one schedule to be used by another schedule. When you replenish a component by schedule, the component stock at the line location is allocated by specific schedule. This option allows stock allocated to one schedule to be used by another schedule, when the second schedule has no more allocated stock and there is no unallocated stock at the line location.
- Set a tolerance limit for schedule receipt and operation reporting quantities. The schedule receipt or operation reporting transaction is not accepted and an error message is displayed when the transaction quantity exceeds the sum of the open schedule or operation quantity and the tolerance percentage you have defined.
- The open schedule quantity is the number of scheduled items that remain to be produced by the schedule. If schedule receipts are allowed to be posted across multiple schedules (see 6), the open schedule quantity is the number of items remaining to be produced across the schedules. When a schedule receipt transaction is entered, the maximum receipt quantity is calculated by multiplying the open schedule quantity by the tolerance limit and adding the result to the open schedule quantity. A schedule receipt transaction whose quantity is greater than the maximum receipt quantity is not accepted.
- The open operation reporting quantity is the number of scheduled items remaining to be produced at the operation. If operation reporting transactions are allowed to be posted across multiple schedules, the open operation reporting

quantity is the number of items remaining to be produced at that reporting point, across the schedules. When an operation reporting transaction is entered, the maximum operation reporting quantity is calculated by multiplying the open operation reporting quantity by the tolerance limit and adding the result to the open schedule quantity. An operation reporting transaction whose quantity is greater than the maximum operation reporting quantity is not accepted.

- A blank tolerance percentage means the transaction quantity is not checked.
- Set a tolerance limit for schedule scrap quantities. The schedule scrap transaction is not accepted and an error is displayed when the total of all schedule scrap reported (including the transaction quantity) exceeds the sum of the planned scrap quantity and the tolerance percentage.
- The reported scrap quantity is the number of scheduled items that have been reported as scrapped in this operation (including the schedule scrap transaction quantity). If schedule scrap transactions are allowed to be posted across multiple schedules (see 6), the reported scrap quantity is the number of items that have been reported as scrapped in this operation, across the schedules.
- The planned scrap quantity is the number of scheduled items that are anticipated to be scrapped at the operation, based on operation yield. When a schedule scrap transaction can be posted across multiple schedules, the planned scrap quantity is the sum of all planned scrap quantities (at the operation), across multiple schedules.
- When a schedule scrap transaction is entered, the maximum scrap quantity is calculated by multiplying the planned scrap quantity by the tolerance limit and adding the result to the planned scrap quantity. A schedule scrap transaction whose quantity is greater than the maximum scrap quantity is not accepted.
- A blank tolerance percentage means the transaction quantity is not checked.
- Allow schedule receipt, operation reporting, and schedule scrap transactions to be reported across multiple schedules. If you choose to apply these transactions across multiple schedules, then schedules are displayed as groups on the transaction entry panel. If an item has production campaigns, each schedule group represents a campaign. If the item has no production campaigns, a single schedule group is displayed. Schedule groups begin with the schedule having the oldest due date (which may be in the past) and an open quantity. The last schedule in a group is either the last schedule of the production campaign, or the last schedule on the transaction date. Some individual schedules may not be tracked as part of a production campaign. If their due dates fall within a production campaign's span, they are included as part of the schedule group. However, their production and scrap counts are not included in the production campaign counts when the transaction quantity is posted.
- Each schedule group represents the total open quantity for all production schedules in the group. The open scrap quantity is the difference between the total planned scrap and total reported scrap in the schedule group. The transaction quantity is posted to the schedule group, beginning with the first schedule in the group and continuing to the last schedule of the group. The transaction quantity is applied to the first schedule's open quantity and the transaction quantity is reduced. The remaining transaction quantity is applied to the next schedule in the group, until the transaction quantity is reduced to zero. If the transaction quantity is greater than the total open quantity, the remainder is applied to the last schedule in the group.
- Allow schedule receipt, operation reporting, and schedule scrap transactions to be reported against future schedules. If you chose to apply these transactions across multiple schedules, you also can choose to have transaction quantities

applied to future as well as past and current schedules. Future schedules are those schedules whose due dates are beyond the transaction date.

- Allow revision support for schedule receipt (RM), operation reporting (RO), and schedule scrap (SM) transactions, if EPDM is activated.

## **Step 15. Running audit reports for validation**

To validate the information that you enter, run the following audits from menu AMQM20.

- Item Balance Audit
- Item/Line Audit
- Location Audit.

### **Item Balance Audit report**

The Item Balance Audit Report provides a listing of discrepancies between the Item Balance and the Product Structure, Routing, and Item/Line Master files. This audit report also checks each schedule-controlled item to see if:

- A bill of material has been entered
- A routing has been entered
- The primary production line (from the Item Balance record) has been entered in the Item/line file.

All items in the Item Balance file that are coded as schedule-controlled are audited by verifying that a Product Structure record and a Routing record exists for the Item. Error messages are printed if either of these conditions is not satisfied.

The program verifies that for every schedule-controlled item in the Item Balance file, a matching entry with the same Item Number (Scheduled Item) and Primary Production Line (Production Line) exists in the Item/Line master file. If no matching entry is found, an error message is printed.

### **Item/Line Audit report**

The Item/Line Audit report provides an audit function to identify discrepancies in the ITMLIN and CMPLIN files. In addition to the Item/Line Audit Report, the Component/Line Edit List may print to identify CMPLIN records that were added or deleted. The audit function does the following:

- Verifies that all blowthrough components in the product structure are represented with CMPLIN records. If a CMPLIN record is missing, it is added and identified on the Component/Line Edit List.
- Verifies that all CMPLIN records are represented in the single level blowthrough for an item's structure. If a CMPLIN record does not have a corresponding product structure record, the CMPLIN record is deleted and identified on the Component/Line Edit List.
- Verifies the status field in each CMPLIN record. Each CMPLIN record should be at a status 10 if the component operation is not defined in the routing file for the end item, or the location is not defined in the SLDATA file for the warehouse. After these two data elements are analyzed, the CMPLIN status field is set appropriately.

- Verifies the status field in each ITMLIN record. Each ITMLIN record contains a count of the number of CMPLIN records that are at a status 10. If this count field is greater than zero, then the ITMLIN status is set to 10.

For each ITMLIN record the following audits are performed:

- Production line. The production line specified in the ITMLIN record must be defined in the production facility file and must be defined as a production line.
- Item balance. The finished item specified in the ITMLIN record must have a corresponding ITEMPL record.
- Routing. Each finished item must have at least one routing record defined.
- Variance percents. Changeover and flow time variances are calculated from the routing file and compared to the variance percent entered by the user.

For each CMPLIN record the following audits are performed:

- Item balance. The component item specified in the CMPLIN record must have a corresponding ITEMPL record.
- Operation. The operation must be defined for the finished item in the routing file.
- Line location. The line location must be defined in the SLDATA file for the given warehouse.

For each MODATA record the following audits are performed:

- Operation where first used. Each operation where first used in the MODATA file must resolve to a corresponding MOROUT record.

In addition to the listed audits, the program tests the validity of the **Changeover** and **Flow Time Hours** fields in the Item/Line master file. The program compares these values against calculated unit setup and run times from the Routing file. All Routing records selected that match the Alternate Routing Code for the scheduled item (see the previous edit), are processed against a set of rules to determine the unit setup and run hours.

If the Changeover Hours in the Item/Line master file vary by more than plus or minus the Allowable Variance Percent parameter (entered on the Select display) from the calculated Setup Hours adjusted by the time basis code and the prime load code, the program prints the scheduled item number, alternate routing code, production line, changeover hours, calculated unit setup hours, percent setup variance, and a warning message.

Similarly the program compares the flow time hours in the Item/Line master file to a calculated sum of run hours adjusted by the time basis code, standard run labor hours, standard run machine hours and prime load code as appropriate. If the calculated hours vary by more than plus or minus the variance percent parameter (specified on the selection display) the program prints the scheduled item number, alternate routing code, production line, flow time hours, calculated run/unit hours, percent run/unit variance, and a warning message.

**Formulas** . The program calculates the variances from the item/line changeover and flow time hours based on the following calculations. These calculations mirror the PC&C calculations to determine operation duration. The program examines the Routing records associated with the scheduled item.

Base operations (those operations with a blank alternate routing selection code) and any additional operations specified by the alternate routing selection code in the item/line record are used in the calculations of changeover and flow time.

The sums of the setup and run times when compared to the changeover and flow times must be within the allowable variance percentage, specified when the Item/Line Audit is run.

The setup and run sums are calculated in the following manner. For each active Routing record selected, the program performs the following calculations based on the **Time Basis Code (TBC)** field. The time basis code is used to calculate the time per unit. The time basis code values are:

- blank** Hours per unit
- 1** Hours per 10 units
- 2** Hours per 100 units
- 3** Hours per 1000 units
- 4** Hours per 10000 units
- P** Pieces per hour
- H** Hours per lot
- M** Minutes per piece
- C** Cost per piece (outside operations)

The program calculations are summarized in the following table. The following abbreviations are used in this table.

- SULHR** Set Up Labor Hours
- SUCSZ** Set Up Crew Size
- RUNLB** Run Labor Hours
- RUNMC** Run Machine Hours
- ASUHRS** Adjusted Setup Hours
- ARLHRS** Adjusted Run Labor Hours
- ARMHRS** Adjusted Run Machine Hours.

<b>TBC</b>	<b>ASUHRS Adjusted Setup</b>	<b>ARLHRS Run Labor/Unit</b>	<b>ARMHRS Run Machine/Unit</b>
	SULHR/SUCSZ	RUNLB	RUNMC
1	SULHR/SUCSZ	RUNLB/10	RUNMC/10
2	SULHR/SUCSZ	RUNLB/100	RUNMC/100
3	SULHR/SUCSZ	RUNLB/1000	RUNMC/1000
4	SULHR/SUCSZ	RUNLB/10000	RUNMC/10000
P	SULHR/SUCSZ	1/RUNLB	1/RUNMC
H	SULHR/SUCSZ	RUNLB	RUNMC
C	Do Not Process	Do Not Process	Do Not Process
M	(SULHR/SUCSZ)/60	RUNLB/60	RUNMC/60

After the program has calculated the preceding values, it examines the Prime Load Code (PLC) in the Work Center file. The prime load code values are:

- 0** No hours accumulated
- 1** Run machine hours
- 2** Setup labor hours/SCS
- 3** (Setup labor/SCS) and run machine hours

- 4 Run labor hours
- 5 Setup labor/SCS and run labor hours

If the prime load code (PLC) is equal to zero no hours will be accumulated for this operation.

The following adjustments will be made to the previously calculated adjusted setup and run time hours for all operations in work centers where the prime load code (PLC) is not equal to zero:

- The adjusted run time hours (ARUHRS) are adjusted by the value in the **Move Time** field in the Routing record. This value is expressed in standard days. The value in the field is multiplied by 8 and the resulting hours added to the adjusted run time hours.
- The adjusted run time hours (ARUHRS) is increased by the value in the **Standard Queue Time** field in the Work Center file. This value is expressed in standard days. The queue time adjustment is calculated at the time the routings are loaded for the scheduled item. The **Queue Time** field has three integers and two decimals (999.99). The number of queue days is multiplied by 8 and added to the adjusted run time hours. Queue Time is taken once for consecutive operations in the same work center. The operations are loaded in scheduled item/operation sequence order.

After all appropriate adjustments are made, the program uses the prime load code in the Work Center file for each routing to determine which of the calculated values to use for the setup and run time values shown on the report.

PLC	SETUPH Setup Time	RUNTMH Run Labor/Unit	RUNTMH Run Machine/Unit
0	Zero	Zero	Zero
1	Zero	Zero	ARMHRS
2	SULHR	Zero	Zero
3	ASUHRS	Zero	ARMHRS
4	Zero	ARLHRS	Zero
5	SULHR	ARLHRS	Zero

The program adds the calculated values for all routing records for the scheduled item. The resulting values are placed in the SETUPH (**Setup/Crew Hours**) and RUNTMH (**Run/Unit Hours**) fields.

The variance percents are calculated based on the following variables:

- VARPER** Allowable variance percent (input)
- SETUPH** Setup/crew size hours (previously calculated)
- CHGOV** Changeover hours from Item/Line master file
- RUNTMH** Run/unit hours (previously calculated)
- FLWTM** Flow time hours from the Item/Line master file.

The results are placed in the variables VARSUP (**Setup/Crew Variance**) and VARRUN (**Run/Unit Variance**). If SETUPH or RUNTMH are zero, VARSUP or VARRUN is set to zero, to avoid dividing by zero. If VARSUP or VARRUN exceed 999.9, they are shown as 999.9.

- $VARSUP = ABS((CHGOV \text{ divided by } SETUPH) \times 100) - 100$
- $VARRUN = ABS((FLWTM \text{ divided by } RUNTMH) \times 100) - 100$



If VARSUP or VARRUN are greater than VARPER, the record is flagged as an exception and the appropriate warning is printed.

The item/line audit program edits all scheduled items in item/line and verifies that first level components and options are present in the Component/Line file. It also audits all components in the Component/Line file and verifies that they are defined in product structure. If errors are found the report prints the corresponding error message and identifies the product structure or component/line component in error.

To correct these errors use the Work With Item/Line function (Option 3 on the File Maintenance Menu AMQM50). Select the scheduled item and production line based for the component(s) in error. Do not select S-number. In the **Alternate Routing code** field, enter \*\* (all routings). The program corrects the Component/Line file to mirror the correct product structure entries.

The calculated setup and run hours for each operation are accumulated to reach the total setup and total run hours for the item. The total setup and total run hours are compared to the changeover and flow times from the item/line record to see whether they exceed the allowable variance percentage. The setup and run times can be greater or less than the changeover and flow times as long as they fit within the variance percentage (specified when the Item/Line Audit is run).

For released schedules, the Item/Line Audit report also checks if the **Operation Where Used** specified in each component record matches an operation record in the schedule's routing.

## Location Audit report

The Location Audit report checks if the locations in the following files are valid stocking locations.

- Item/Line (ITMLIN)
- Component/Line (CMPLIN)
- Item Balance (ITEMBL)
- Manufacturing Order Master (MOMAST)
- Manufacturing Material Detail (MODATA).

Only controlled warehouses can provide multiple stocking locations for an item. The multiple stocking location must be defined through Location Detail maintenance. Locations are checked only for schedule-controlled items in the Item Balance file, and only for production schedules in the Manufacturing Order Master and Manufacturing Material Detail files.

The first type of exception validates the warehouses and location fields for the scheduled item and its component items in the Item/Line and Component/Line files.

All Item/Line and associated component/line records are processed. For every Scheduled Item number in the Item/Line file, the program determines whether item balance records exist. The program prints an error message if no item balance records are found for the scheduled item.

For all item balance records found meeting the preceding edit criteria, the program verifies that the warehouse stock location in the item balance record is defined for that controlled warehouse in the Location Data file. If no matching entry is found in SLDATA, an error message is printed.

For all item balance records that meet the preceding criteria, the program uses the controlled warehouse to verify that the default delivery location in item/line is defined in the Location Data file. The program prints an error message if no matching entry is found in the SLDATA file. The program prints a warning message if the line location is coded as a supply location.

The program processes all component/line records for this scheduled item and verifies that they are defined in Item Balance file for the matching controlled warehouse. The program prints an error message if a matching Item Balance record is not found for each component processed. If a matching item balance record is found, the program verifies that the warehouse stock location exists in the Location Data file. An error message is printed if a matching record is not found in SLDATA. If the default supply location in item balance is not equal to the component's delivery location (not a JIT item), the program verifies that the supply location (Item Balance's Warehouse Stock Location for the Controlled Warehouse) is not a line location. A warning message is printed if the location is coded as a line location.

For each component processed the program verifies that the **Delivery Location** field in the component/line record is defined in the Location Data file for the matching controlled warehouse. An error message is printed if no matching record is found in SLDATA.

The second audit selects for processing all items in the Manufacturing Order Master file where the order number is prefixed by an S indicating a schedule. The program uses the finished item warehouse and finished item stock location to access the Stock Location file. If no match is found, the program prints an error message.

The third audit selects for processing all Manufacturing order detail records for each order in the Manufacturing Order Master file with an S prefix in the **Order Number** field. The program uses the **Component Item Warehouse** and the **Delivery Location** fields in MODATA to access the Stock Location file. An error message is printed if no matching record is found in SLDATA. If the accessed delivery location is not coded as a line location, the program issues a warning message. The program uses the **Component Item Warehouse** and the **Component Stock Location** fields in MODATA to access the Stock Location file. An error message is printed if no matching record is found in SLDATA. If the accessed location is coded as a Line Location, the program prints a warning message.

If the component stock location and the delivery location in MODATA are the same (JIT item), the program validates that the locations are valid in the Location Data file, but no line location validation is performed.

From Manufacturing Order Master records, the finished item stock location is checked. From Manufacturing Material Detail records, the line location is checked, and should be defined as a production line location. the component stock (supplying) location is also checked, and should not be a production line location.

## Step 16. Defining printer output queues and libraries

You have a choice of printer output queues that you can use to receive your printed output. The printer output queue determines the printer on which the report appears.

You can use the Work with Printer Overrides option on the Cross Application Support (CAS) Maintenance/Change menu (AMZM30) to assign the output queue and printer on which each REP report and listing is printed. When a report is printed, it is sent to

an output queue which is attached to a printer through a print writer. For more information on assigning printer overrides, see the *CAS User's Guide*.

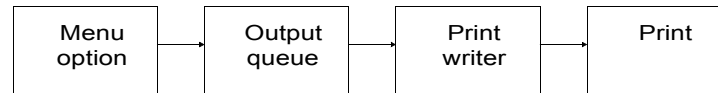


Figure 2-16. Output queue for reports

You can use this menu option to direct each report to the printer that is closest to the department using the report. If several departments print the same report, each person can direct the report to the printer that is closest.

## Bar coding

Documents with bar codes can be printed on normal paper stock, but must be printed on a printer that supports Intelligent Printer Data Stream (IPDS) output. Contact your XA representative for more information on such printers.

The turnaround number representation is printed in bar code. The turnaround number in digit form is nine digits long and is printed just above the bar code, or to one side (usually the left side).

Printing bar code at 6 LPI causes a large area of the document to be taken up by the bar code. As a result, documents with bar codes are printed at 8 LPI. The size of the bar code area is 23 positions wide and 4 lines high, and uses a Code 39 (Code 3 of 9) bar code.

The top line of the bar code should be on the last line of the printed text associated with the bar code. For example, if a document uses two lines to describe a component, the component bar code should begin on the second line. If the bar code began on the first line, IPDS causes the first text line to overprint on the second line.

Two different formats are provided for most documents:

- Format 1 is 132 positions wide.
- Format 2 is 85 positions wide.

The PM&C programs that contain source specifications for bar coding are:

- AMJBD, Worksheets (Shop Packet)
- AMJBE, Pick List
- AMJBF, Labor Tickets.

The REP programs that contain source specifications for bar coding are:

- AMQ3R, Component Return List
- AMQ3T, Pick List
- AMQ3U, Container Labels
- AMQ4J, Production Reporting List

## Step 17. Setting the time horizons

You must define the schedule horizons for reviewing demand and releasing production schedules. You also need to select the key dates that determine how far into the future production schedules are created. Use the Set Schedule Review/

Release Horizon menu option on the Schedule Management menu (AMQM40) to define the schedule horizons for reviewing demand, planning schedules, and releasing production schedules. This should be done for each planning warehouse. These dates are automatically updated each time you run Schedule Entry and Maintenance, Schedule Release, or Demand Extract.

## Production calendar

The production calendar, which is entered using the Work with Calendars option on the IM File Maintenance menu (AMIM70), can be up to five years long. Before you can create the production calendar, the holidays and non-work days are entered into the calendar table for each year. Each time a new year is added, the oldest year is dropped.

A different calendar can be defined for each warehouse and/or production line. Calendars for specific warehouses are identified in Work With Warehouses, and calendars for specific production lines are identified in the PDM WRKCTR or EPDM FACMST file.

Two horizons are used in the REP application, the review horizon and the release horizon. The review horizon determines the dates between which schedules can be planned. The release horizon determines when schedules should be released.

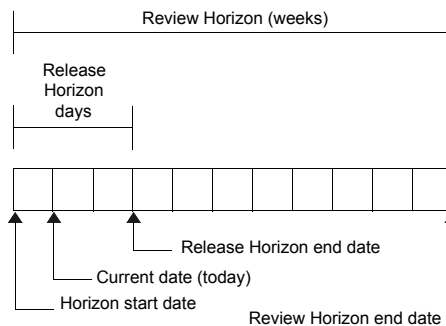


Figure 2-17. Time line and horizon start and end dates

The Horizon Start Date is the first work day in the current week, and the Current Date is today's date. A schedule whose due date is earlier than the current date cannot be released so that work is performed on the schedule; you cannot perform transactions on schedules that are not released.

The Release Horizon End Date determines when schedules are normally released. The release horizon should be at least as long as the longest lead time for any item. Schedules are normally released when their start date is equal to the release horizon end date.

The Review Horizon End Date determines when schedule planning ends. Schedules are planned to meet the demand that falls within the review horizon.

The prior year should be kept in the Calendar file so that any demand or schedules can be processed in REP for the release and review horizons.

## The planning cycle—Entering and Maintaining Schedules

The REP planning cycle allows you to plan and release production schedules. Planning is a key element in executing your production schedules in an orderly fashion. Good planning helps you to create realistic schedules with the resources available.

In MRP II planning systems, you start the planning process by developing production targets that define how you want to run your business. To establish these targets, you must have the ability to control resources such as overtime, capacity, and hiring. Once the targets and resource constraints under which your business operates have been determined, it is your responsibility as planner to implement the plans on an individual item basis.

Normally, you execute item plans through the use of applications such as Master Production Schedule Planning (MPSP) and Material Requirements Planning (MRP). MRP output provides production requirements to manufacturing and purchase order requirements to the purchasing department. The coordination of key departments is ensured, and the product is built in a fashion that meets the plans of the company. At each stage of the process, requirements are tested to ensure they are realistic and effective. (For example, does manufacturing have the resources needed to meet production needs? Does purchasing have the resources to purchase and deliver parts on a timely basis?) If the resources needed to carry out a plan are not balanced, changes are made and a realistic plan developed. Figure 2-18 shows a simple example of the MRP II planning process just described.

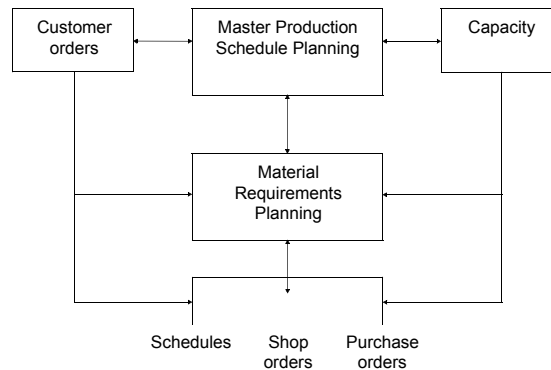


Figure 2-18. Example of an MRP II planning process

In REP, this planning process continues. Schedule requirements are presented as demand to be produced on production lines. The demand can come from Material Requirements Planning, Customer Order Management, and/or a Schedule Demand file provided for data you enter outside of XA. This demand can be analyzed for changes from previous schedules. It can also be analyzed to determine the amount of line utilization that production schedules impose on the shop floor. Using these techniques, you can review and plan your line utilization to help meet your production goals.

You will find additional information on the REP planning cycle in Chapter 1.

## REP to MRP interface

The REP to MRP interface automatically updates MRP files based on scheduling actions taken in REP. When a schedule is entered in REP, a planned schedule is created with a status showing it as not released. Next, MRP planned orders are consumed up the quantity specified for the schedule. Consumption begins with the consume date specified at the time of schedule entry. If a consume date is not specified, the schedule date is used. The consume date is especially useful if you want to consume MRP planned orders with dates prior to the schedule's date. If the schedule due date differs from a planned order due date, the planned order's component requirements are aligned to the new schedule date.

Changes to a schedule quantity also are communicated to MRP's PLNORD and ORDREV files. A quantity increase will cause a planned schedule to be increased on the schedule date and planned orders to be consumed. A quantity decrease will cause the planned schedule to be decreased and a planned order re-created (or increased) on the schedule date. A change to a schedule date is handled as a schedule delete and schedule add. There is no consume date capability with schedule changes.

**Note:** If you reduce or delete a schedule quantity, MRP's planned orders might not be re-created on their original dates if the original consumption spanned multiple dates. This is because the consumption history of the original entry was not saved. Your next MRP generation run will re-create planned orders on their proper dates, based on MRP's planning logic. Before the MRP next planning run and following a REP Extract, the Net Demand column on the Enter and Maintain Schedules display might show net demand (planned orders) on the wrong dates.

## Setting schedule review and release horizon

Normally, you only need to set the number of days in the review and release horizons at the time of installation. You can, however, change them at any time so that you can experiment with changing horizon values or make a permanent change. Use the Set Schedule Review/Release Horizon option on REP menu AMQM40 to change horizon values.

The Schedule Review and Release horizons serve two functions. The Review Horizon controls the amount of demand extracted from MRP, Customer Order Management (COM), and the Schedule Demand file, and influences the period of time over which the smoothing algorithm is used to smooth schedules. The Release Horizon is used to select schedules for release to the shop floor. The horizon ending dates are automatically determined by adding the review horizon value to the system date. The system date is referred to as "today" in the Schedule Review and Release horizon shown in Figure 2-17.

### Schedule review horizon

The review horizon expressed in weeks, begins with the first working day in the current week. The first working day is established by an install/tailoring question common to the Repetitive Production Management, Master Production Schedule Planning, and Forecasting applications. The current week is defined by the system date.

The review horizon end date is the final work day in the week specified by the review horizon. You can enter the number of weeks for the review horizon, or the value can

be calculated from MRP's review horizon. If the MRP horizon value (which is expressed in days) is used, REP converts the MRP value to weeks by:

- Adding the number of days in the MRP review horizon to the first day of the current week to find the last horizon date
- Finding the first day of the week following the last horizon date
- Moving back from that date to determine the last working day of the previous week.

If you enter the Review Horizon instead of using the MRP value, the horizon is specified in weeks, not days. When you calculate the horizon end date, remember that a full week runs from the first work day of a week to the first work day of the next week. The calculation is performed as was previously described, substituting full weeks for work days.

When the Review Horizon end date is calculated, the value is used during Extract Schedule Requirements to determine which schedule requirements to include. The requirement's due date is compared to the Review Horizon end date. If the due date is less than or equal to the review horizon end date, the requirement is extracted as a schedule requirement.

### **Schedule release horizon**

The Schedule Release Horizon expressed in days, begins on the system date on which it is entered. The Schedule Release Horizon ending date is calculated by adding the number of release days you specify to the beginning date. You can either enter the release horizon or use the number of days specified in MRP.

The release ending date determines which schedules are candidates for release to REP. Any schedule whose start date is equal to or less than the release end date appears on the Release Schedule selection display. Using this display, you can confirm the release of the schedule. You can also temporarily override the release end date to view schedules further into the future.

If you use the smoothing function, the schedule release horizon may affect the date where smoothing begins.

## **Analyzing demand**

You can analyze demand by:

1. Determining the source of demand to use to develop schedules
2. Monitoring changes in demand relative to your schedules.

The second point is discussed in "Preparing to enter production schedules" on page 2-93.

### **Determining the source of schedule requirements**

As previously discussed, demand can come from MRP, COM, or the Schedule Demand file (SCHDMD in the figure that follows). You can override the initial demand source for an item using the Extract Source Code in the item balance record. For example, you can use MRP as the primary source of requirements for schedule-controlled subassemblies, but use actual customer orders from COM to schedule

requirements for end items. Items that use features and options must extract demand from COM or the Schedule Demand file.

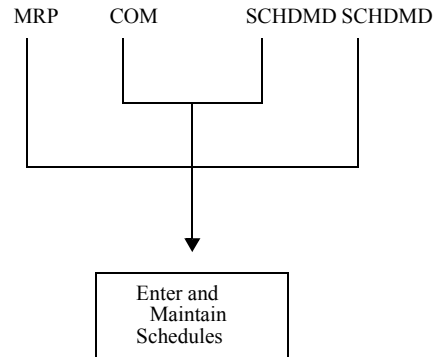


Figure 2-19. Sources of schedule requirements

Requirements that are electronically sent to your system can enter REP by being:

- Entered into COM and used by MPSP/MRP to plan component parts
- Entered into the MPSP Demand Interface file and treated as forecasts capable of creating orders
- Loaded into MRP's Requirements file as manual requirements
- Entered into the Schedule Demand file to supplement COM's customer orders.

**Demand from MRP .** If MRP is installed and interfacing, you should consider it the primary source of requirements for scheduling because MRP accesses all independent (such as customer orders and forecast) and dependent demand (such as generated requirements needed for manufacturing higher level assemblies). MRP is capable of planning your total manufacturing needs.

MRP provides schedule requirements to REP in the form of planned orders, which represent demand that is netted by available inventory and lot sized for manufacturing. In the case of scheduled items, order policy codes A or G and one day of supply usually are used for lot sizing, allowing you to create schedule requirements equal to the net requirements of the item.

Enough component parts to fill the total planned order quantity are allocated. The planned scrap value removed from the order quantity is retained and measured against the actual scrap resulting from the production process. You can review scrap information on the Review Schedule Performance display.

**Steps for analyzing MRP demand.** After the MRP planning run has created planned orders for the raw materials, fabricated items, subassemblies and end items, use the MRP Review and Approve - Order Status display (AMM622) to manage the planned orders and make any adjustments prior to releasing them. The display allows you to Change, Firm, Release, or Cancel planned orders, and to check demand for the item and the availability of its components.

You can use Firm or Change actions to enter a change to the start and due dates of a planned order or firm planned order. You can also change the order quantity, make/buy code, order accounting class, or order reschedule code. The Firm and Change actions allow you to decide when the planned order is built, the quantity to be



produced, and whether a production schedule, manufacturing order, or purchase will be used. The Order Status display shows the action you have taken in the Action column and the order status in the **Type** column. After you have entered changes to a planned order, the display will show Firm in the **Action** column, but the **Type** column will be unchanged.

You can select planned orders and firm planned orders for release. MRP Order Release creates manufacturing and purchase orders and changes the MRP planned orders into scheduled receipts. If the make/buy code is M (Manufacturing) or P (Purchase), the planned order can be selected for release. If the make/buy code is S (Schedule), the planned order cannot be selected for release. Production schedules can be created only through the REP Schedule Entry and Maintenance option.

When you run MRP Order Release (AMMM40, option 5), the date and quantity changes you have made are applied to the planned order and the order status changed to firm planned order. The planned orders you selected for release are changed into scheduled receipts and used to create manufacturing and purchase orders.

Planned and firm planned orders are seen as demand by REP. A schedule can be entered to offset this demand or the **Use Proposed Change** function key can be used to create the schedules.

**Relationship between MRP planned orders and REP planned schedules.** After MRP has calculated an item's net demand, it creates a single planned order on the demand date for the day's net demand quantity. However, the item's Order Policy code can cause multiple planned orders to be created on the date, or cause planned orders to be spread out and created with larger order quantities.

When a schedule is initially entered, it is a planned schedule. A consume date can be entered at this time that determines the first date on which planned orders are replaced by the planned schedule. The default for the consume date is the schedule due date. Planned orders are consumed until the total planned order quantity is equal to the planned schedule quantity; and multiple planned orders may be consumed. As planned orders are consumed, the remaining planned schedule quantity can be less than the next planned order quantity, causing the planned order quantity to be reduced by the last of the planned schedule quantity.

In the following scenarios, assume a schedule is entered for a quantity of 300, a due date of 10/06/00, and a consume date of 10/04/00.

Planned Orders		Planned Schedules		
Due Date	Quantity	Consume date	Due Date	Quantity
10/02/00	100			
10/05/00	125			
10/06/00	75			
10/10/00	125			
10/11/00	75			

Table 2-1. Planned orders before the schedule is entered

Planned Orders		Planned Schedules		
Due Date	Quantity	Consume date	Due Date	Quantity
10/02/00	100			
		10/04/00	10/06/00	300
10/10/00	25			
10/11/00	75			

Table 2-2. Planned orders after the schedule is entered

If a planned schedule quantity is increased, planned orders are consumed beginning on the schedule due date.

Planned Orders		Planned Schedules		
Due Date	Quantity	Consume date	Due Date	Quantity
10/02/00	100			
			10/06/00	330
10/11/00	70			

Table 2-3. Planned orders after the schedule quantity is increased

If a planned schedule quantity is decreased, a planned order is created for the decreased quantity. The planned order has the planned schedule's due date.

Planned Orders		Planned Schedules		
Due Date	Quantity	Consume date	Due Date	Quantity
10/02/00	100			
10/06/00	50			
			10/06/00	280
10/11/00	70			

Table 2-4. Planned orders after the schedule quantity is decreased

Changing a planned schedule due date does not change which planned orders were consumed.

Planned Orders		Planned Schedules		
Due Date	Quantity	Consume date	Due Date	Quantity
10/02/00	100			
10/06/00	50			
			10/08/00	280
10/11/00	70			

Table 2-5. Planned orders after the schedule quantity is decreased and schedule due date also changed

If a planned schedule is deleted, a planned order is created with the planned schedule's quantity and due date.

Planned Orders		Planned Schedules		
Due Date	Quantity	Consume date	Due Date	Quantity
10/02/00	100			
10/06/00	50			

Table 2-6. Planned orders after a planned schedule is deleted

Planned Orders		Planned Schedules		
Due Date	Quantity	Consume date	Due Date	Quantity
10/08/00	280			
10/11/00	70			

Table 2-6. Planned orders after a planned schedule is deleted

During the next MRP planning run, planned schedules are kept, but planned orders are discarded. MRP treats planned schedules like MRP firm planned orders, presuming that you have selected the best manufacturing dates and the optimal quantities. The MRP planning run does not consider the planned schedule's consume date.

Planned Orders		Planned Schedules		
Due Date	Quantity	Consume date	Due Date	Quantity
10/02/00	100			
10/06/00	25			
			10/08/00	25
10/08/00	280			
10/11/00	70			

Table 2-7. Creating another planned schedule

Planned Orders		Planned Schedules		
Due Date	Quantity	Consume date	Due Date	Quantity
10/02/00	100			
10/05/00	125			
10/06/00	75			
10/10/00	100		10/07/00	25
10/11/00	75			

Table 2-8. After the MRP planning run

The MRP planning run:

- Will not change the quantity on a planned or released schedule.
- Will not split a schedule into two schedules: one schedule for the quantity needed on the current due date and another schedule for the quantity needed at a later date.
- Will recommend a new due date for a planned or released schedule, when the material is needed earlier or later than the current due date.
- Will create planned orders to meet the requirements not covered by planned and released schedules.

If the auto-rescheduling option is active for production schedules during an MRP planning run, the due dates for planned and released schedules are changed to the true date of need.

The MRP reports show what is needed and when. REP schedules must be modified to fit the need dates and quantities, yet fit within the constraints of production.

**Demand from COM** . Customer Order Management supplies demand from customer orders by item, S-number, and manufacturing due date to the Enter and Maintain Schedules scheduling function. During the extract function, demand from COM with a

manufacturing due date equal to or less than the Review Horizon end date is combined with demand in the Schedule Demand file, netted against available inventory, and smoothed if applicable.

If you do not use the smoothing function, you can meet the demand supplied from COM with little or no buildup of inventory. To do this, however, you must be able to run your shop in a complete Just-in-Time environment. If your environment is not Just-in-Time and MRP is not installed, you must obtain some of your scheduling requirements through the Schedule Demand file. This allows you to build up any anticipated inventory.

When schedule requirements are extracted from the COM application:

- Customer line items and blanket release line items with manufacturing due dates equal to or less than the last date in the review horizon are extracted.
- The demand from COM and the Schedule Demand file are combined to arrive at total demand.
- Time phased demand is netted with available inventory (on hand inventory less allocations less safety stock).
- Demand by day is summarized for unique feature/option combinations by model line (by s-number and item).
- Net demand is smoothed, if specified for the individual item.

***Demand from the Schedule Demand file*** . As mentioned earlier, the Schedule Demand file can be used to enter scheduling requirements not supplied by COM into REP. If MRP and COM are not installed and interfacing, you can use this file to enter requirements from an alternate source of demand such as a specially written program. Another use for this file is to bypass the XA method of determining scheduling requirements and use your own scheduling system to supply requirements. Requirements from the Schedule Demand file are netted by the available inventory.

The Schedule Demand file is defined in the data file descriptions, but you are responsible for entering and purging information from this file. During the extract process, the information in this file is edited before it is added to net demand. An error flag (ERRFL) is set to 0 when the record has been extracted, which helps you determine which records to purge. Record entry and purge must be done outside of REP.

***Demand for model line items*** . Demand for model line items is summarized by item, S-number, and manufacturing due date by day. This information is shown on the scheduling displays in Enter and Maintain Schedules and the Schedule vs Demand inquiry. When you review the breakdown by feature/option, you can plan the specific configurations you must manufacture each day. In the Schedule vs Demand inquiry, you can use the feature/option information to determine the components available for promise by model line.

**Note:** Demand that comes from MRP in the form of planned orders may appear prior to the REP review horizon start date. This situation occurs when the MRP planning run generates these planned orders on a week prior to the REP demand extract. If the MRP planning horizon start date and the REP review horizon start date are the same and the MRP generation run and REP demand extract are run during the same work week, then no demand prior to the REP review start date appears.

## Maintaining customer manufacturing due dates

You can use the Customer Order Management (COM) application to enter and maintain a manufacturing schedule date for customer line items or blanket release line items.

When the customer order is initially entered, a request date, a manufacturing due date, and a shipment lead time are entered. The request date identifies when the item is to be shipped. The manufacturing due date tells when the item is planned for completion. If a manufacturing due date is not entered, it is calculated by subtracting the shipment lead time (in days) from the request date. The customer order request date and manufacturing due date are the default dates for the line items.

When you enter line items on the Detail Item Entry display, you can change the default request date and manufacturing due date. When you enter a blanket release for a line item on the Enter Blanket Release display, you must enter the release date for each blanket release. If you do not enter a manufacturing due date, it is calculated by subtracting the shipment lead time from the release date.

You can use Maintain Customer Manufacturing Dates on the Schedule Management menu (AMQM40) to assign override manufacturing due dates to the line items and blanket release line items on a customer order. It can be used to match demand from customer orders to the supply from existing production schedules. If production schedules have already been entered, then new customer orders can be matched to the existing supply. If, however, the change you make schedules an item so that the customer request date will not be met, you receive warning messages.

Use the Maintain Customer Manufacturing Dates function to do the following:

- Validate production schedules by comparing demand to schedules on a daily basis
- Determine the production quotas for specific feature/option configurations (S-numbers) on a given date
- Change manufacturing due dates in the customer line item and blanket release line items records to avoid line overloading and meet manufacturing due and customer request dates
- Determine which customer orders can be moved and still meet customer requirements regarding back orders and partial shipments
- Compare production to demand and see the variance by day.

You can also use customer demand to drive production schedules. As customer orders are entered, the demand can be transferred to REP. This approach, however, does not result in level production schedules, and “peaks and valleys” in production can occur. By assigning differing manufacturing due dates to customer order line items and blanket releases, the “peaks and valleys” can be reduced to allow production to meet the demand. This is a form of demand management.

## Extracting schedule requirements

Use the Extract Schedule Requirements option on menu AMQM40 to extract the net demand for schedule-controlled items from MRP, COM, or the Schedule Demand file. The schedule requirements are placed in a schedule requirements work file. You can process this function using the job queue, immediately from the work station, or on demand during the process of entering and maintaining a specific item’s schedule.

You can also extract the demand for a specific item. Function key **F16 EXTRACT DEMAND** is available during Schedule Entry and Maintenance. It causes the item's demand to be extracted from MRP, COM, or the Schedule Demand file.

If MRP is the source of the item's demand, the planned and firm planned orders are extracted and displayed. Only the order due date and quantity are extracted. Changes to planned and firm planned orders may have been entered through MRP Order Review. You must run MRP Order Release before that information is available to be extracted.

The frequency with which you should run this function varies by installation, but you should run it after an MRP generation or when new information is loaded into the Schedule Demand file. Because there are no constraints as to when customer orders are entered, you can run this function for COM as frequently as you want.

## Preparing to enter production schedules

To enter production schedules, you must analyze changing demand patterns in relation to the production schedules already released, production facility utilization, and component availability. REP's Enter and Maintain Schedule function allows you to review an item's latest net demand within the review horizon. This demand pattern is compared to the item's production schedules to indicate how production for that item is meeting demand. In addition, the production schedule you enter is converted to line hours to provide information on the impact of this schedule on the line capacity.

### Selecting schedules to review

When you enter schedule information on the Enter and Maintain Schedules (Select) display (AMQ441), you can access schedules by item, item within line, or item within planner, over a selected horizon. You also can reduce the number of items you access by choosing to review only items with exception messages. You also can specify the range of dates you want to look at. The starting date is the current date.

Consider also if you need to run the Carry Forward and Lot Sizing functions by using the function keys on this display. These functions process all items within a warehouse.

**Proposed change exception flag.** You receive a proposed change exception message when the net demand of an item and the sum of schedule quantities released or pending release for a day are different. You should pay particular attention to this message if you are scheduling to exactly meet demand.

**Production line utilization exception flags.** You receive these exception messages when a production line is either under or over required loading limits. The minimum loading limit is established by adding the shift lengths for a day and multiplying the total by a minimum usage percentage you establish during the tailoring of REP. If line hours are below this value, the line is considered to be underloaded. You also receive an exception message if line hours exceed a level of loading established by adding the required shift lengths for the specific day.

### Summarized schedules by item

When an item is produced on multiple production lines, it is important that you have a recap of the item's scheduling status. The summary display of the Enter and Maintain Schedules function (Display AMQ442) provides a summary by day of net demand by

item, the net demand variance to released schedules, and the line hours utilized across all production lines on which this item is scheduled.

Using the Enter and Maintain Schedules displays, you can review a schedule across multiple production lines, check component availability, and change the sequence in which you produce schedules on a specific line. For model line items, the total demand on the model line for all configurations ordered in COM is shown.

**Note:** If you select to process by item within planner item within line, an item is shown only if net demand or schedules exist for the item. Otherwise, you must select by item to access this display.

**Net demand .** Net demand is the amount of an item you need to produce after you apply available inventory to total demand. In MRP, planned orders are extracted as demand for scheduling. During the planning process, available inventory is applied to MRP requirements (both dependent and independent demand) to arrive at net requirements. The net requirements are then lot-sized according to the item’s order policy code to produce planned orders. These planned orders are requirements to be scheduled and are represented as net demand on the summary display.

In COM, available inventory is applied against the oldest customer orders to determine time-phased net demand. The net demand is then lot-sized according to the item’s order policy code and passed to REP as requirements to be scheduled. Inventory is not applied for model line items, since XA does not keep unique S-number configurations in inventory.

Demand may be extracted from the Schedule Demand file if REP is the source of demand, or if COM is the source and MRP is not interfacing with REP. When demand from COM and REP is extracted, it is netted against available inventory to determine the net requirement. As stated earlier, Net Demand is total net demand for the item and the basis for determining schedule quantities.

**Schedule quantity/Remaining schedule quantity.** Schedule quantity represents the sum of all released or planned schedules for an item on all production lines on a given day. It is the amount of the finished item that you want to put into inventory on a designated day. Remaining schedule quantity is that which remains to be produced on that date. Using **F12** allows you to toggle between Schedule Quantity and Remaining Schedule Quantity on the display.

**Proposed change.** The difference between Net Demand and Schedule Quantity is shown as proposed change, and represents the amount by which you need to change your scheduled quantity so that it meets your net demand requirements exactly. An increase in demand, a change in inventory availability, or a change in quantity scheduled can cause a proposed change. In the following example, a proposed change of 10 appears on the third day. To meet net demand, the schedule quantity on day 3 must be decreased by 10 units, resulting in 590 units. On day 4, demand is not yet scheduled into production. The proposed change shows that a schedule quantity of 610 must be entered to meet demand.

Schedule Date	Net Demand	Schedule Quantity	Proposed Change
Day 1	600	600	0
Day 2	600	600	0
Day 3	590	600	-10
Day 4	610	0	610

**Note:** You can select proposed change by day or all days. If net demand is zero and schedule quantity is, for example, 10, then the proposed change would be -10. Now, if the proposed change is accepted (using **F13 USE PROPOSED CHANGE**), then the schedule would be deleted.

The function key for Use Proposed Change is available during Schedule Entry and Maintenance and allows you to create schedules easily to meet the demand that is displayed. When you enter 1 next to the production dates on which you want to create schedules and press **F13**, the schedules are created. The schedules have the same due date and quantity as the demand. If the item can be lot sized, the demand quantity is divided, and separate schedules are created for the nominal lot size. After the schedules are created, you can change their accounting class and reschedule codes if you wish.

### Proposed change processing

The Use Proposed Change function is available during Schedule Entry and Maintenance. For the specific warehouse and item, it can be applied selectively by date or all dates. The function is applied to all selected schedules regardless of production line. Use Proposed Change effectively matches the total schedule quantity to the total demand.

Use proposed change is applicable when the demand and schedule quantities for a specific date are not equal. For instance, on 11/1/\*\* the demand for item ABC is 300, summarized from the Extract Requirements file (EXTREQ), and the schedules currently in the system for item ABC on that date total only 200. The proposed change would appear as 100. If the reverse were true, and demand was 200 and schedule quantity was 300, the proposed change would appear as 100-. The positive proposed change quantity indicates that the schedule quantity should be increased. Likewise, the negative proposed change quantity indicates the schedule quantity should be decreased. Use the function key to tell REP that you want to accept the proposed change. This increases or decreases schedule quantities as necessary. Use proposed change also will cause schedule lot sizing when the item allows lot sizing.

#### ***Use Proposed Change and lot sizing.***

- Production scheduling is done by warehouse.
- Production schedules are selected for proposed change processing by scheduled item, S-number, and due date. Production line and run sequence number must be considered during proposed change processing.
- The “lowest production line” is the production line that has a schedule with the proper warehouse, finished item, due date, and S-number; and the lowest alphanumeric production line ID. The primary production line is always considered to be lower than any secondary production line.
- The “lowest schedule on a production line” is the schedule with the proper warehouse, production line, finished item, due date, and S-number; and lowest run sequence number.
- The “lowest schedule” is the lowest schedule on the primary production line.
- The “highest schedule” is the highest schedule on the highest production line.

**Note:** Lot sizing only applies to unreleased schedules (sometimes called planned schedules).

#### ***Use Proposed Change and multiple schedules.***



- **For items that cannot be lot sized.** When demand is greater than supply (i.e., proposed change is a positive value):
  - When there are no schedules for the item (on any production line), a new schedule is created on the primary production line with the schedule quantity set equal to the proposed change quantity.
  - When a schedule exists on the primary production line, the first primary schedule is increased by the quantity of the proposed change.
  - When there are no schedules on the primary production line but there are schedules on secondary production lines, the first schedule on the first secondary line is increased by the quantity of the proposed change.

When demand is less than supply (i.e., proposed change is a negative value):

- No schedule quantity can be reduced below the quantity received, or zero.
- When schedules exist on primary or secondary production lines:

Schedules are selected in reverse run sequence, with the highest schedule (on the highest production line) selected first. Additional schedules are selected in reverse run sequence until all schedules on the highest secondary production line have been selected. Selection continues with the next highest production line until all secondary schedules have been selected. Selection then continues with the highest schedule on the primary production line, until all primary schedules have been selected.

When a schedule is selected, the schedule quantity is reduced by the proposed change, down to the greater of the quantity received or zero. Any “excess” proposed change is applied to the next selected schedule, until the proposed change has been exhausted or no further schedules are available for selection. A message is issued if all or part of the change quantity could not be exhausted.

- **For items that can be lot sized.** When demand is greater than supply (i.e., proposed change is a positive value):
  - When there are no schedules for the item (on any production line), a new schedule is created on the primary production line with the schedule quantity set equal to the proposed change quantity. If the schedule quantity exceeds the standard lot quantity, the schedule is lot sized.
  - When schedules exist on the primary production line, the proposed change quantity is used to increase those schedule quantities to the “standard” lot quantity. If this is insufficient to exhaust the proposed schedule quantity, the remainder of the proposed change quantity is lot sized, creating new schedules with the standard lot size.
  - When there are no schedules on the primary production line but there is at least one schedule on a secondary production line, the proposed change quantity is applied to the lowest schedule on the secondary line. If the “standard” lot quantity is exceeded, then the remainder of the proposed change is applied to the next lowest schedule on that secondary line, until the proposed change has been fully applied. If a remainder exists after all existing schedules on the lowest secondary production line have been increased to the standard lot quantity, the remainder of the proposed change quantity is lot sized, creating new schedules with the standard lot size.

When demand is less than supply (i.e., proposed change is a negative value):

- When schedules exist on primary or secondary production lines. Schedules are selected in reverse run sequence, with the highest schedule (on the highest production line) selected first. Additional schedules are selected in

reverse run sequence until all schedules on the highest secondary production line have been selected. Selection continues with the next highest secondary production line until all secondary schedules have been selected. Selection then continues with the highest schedule on the primary production line, until all primary schedules have been selected.

After a schedule is selected, the schedule quantity is reduced by the proposed change. The schedule quantity cannot be reduced below the greater of the quantity received or zero. Any "excess" proposed change is applied to the next selected schedule, until the proposed change has been exhausted or no further schedules are available for selection. A message is issued if all of the change quantity could not be exhausted.

The following examples are for items with a standard lot size of 50.

**Example 1.**

---

Demand	100
Schedule quantity	0 (no schedules exist)
Proposed change quantity	100
Standard lot size	50

Two new planned schedules are created on the primary production line; each having a quantity of 50 (standard lot size).

**Example 2.**

---

Demand	155
Schedule quantity	90 (one schedule for 90 on the primary line)
Proposed change quantity	75
Standard lot size	50
Minimum lot size	30

The proposed change quantity is applied to the primary production line. The schedule on the primary line is increased to a multiple of the standard lot size. The standard lot size is 50, leaving a proposed change quantity of 65. A new schedule is created for the standard lot size of 50, leaving a proposed change quantity of 15. A third schedule is created for 30, the minimum lot size.

**Example 3.**

---

Demand	115
Schedule quantity	40 (one schedule for 40 on a secondary line)
Proposed change quantity	75
Standard lot size	50
Minimum lot size	30

The proposed change quantity is applied to the secondary production line. The existing schedule is increased to the standard lot size of 50, leaving a proposed change quantity of 65. A new schedule is created for the standard lot size of 50,

leaving a proposed change quantity of 15. A third schedule is created for 30, the minimum lot size, on the secondary line. No activity occurs for the primary line.

**Example 4.**

Demand	40
Schedule quantity	250 (five schedules for 50 each; one schedule is underway on the primary production line and has reported that 45 pieces have been completed; two schedules are on the A secondary line and no run sequence numbers have been assigned; the last two schedules are on the B secondary line and have 1 and 2 as their assigned sequence numbers.)
Proposed change quantity	210
Standard lot size	50

The following schedules have their quantity set to zero, in the order shown:

- Secondary line B, schedule with run sequence number 2.
- Secondary line B, schedule with run sequence number 1.
- Secondary line A, highest schedule number.
- Secondary line A, next highest schedule number.

The only remaining schedule on the primary line has its quantity reduced to 45 rather than 40, as it has already reported 45 pieces completed. The proposed change quantity is -5 because no other schedules remain.

If the item is a model line item, the net demand can be viewed by each unique S-number configuration ordered for a given date. By selecting a date for the schedule day, you can schedule production based on final assembly configurations ordered by customer. This information tells you exactly how many units to produce, thereby eliminating the need to build Just in Case (JIC) inventory.

**Production line hours calculations on Display AMQ442**

All production hours calculations shown on the Enter and Maintain Schedules Summary display (AMQ442) represent totals from individual production lines on which an item is scheduled. The example that follows assumes that all production lines are operating one 8-hour shift, and item A is scheduled on lines 1, 2, and 3:

Production Line	Schedule Hours	Line Hours Scheduled	Shift Length	Line Hours Available
1	6	6	8	2
2	2	7	8	1
3	1	5	8	3
Summary	9	18	24	6

The example shows that on a given day, item A has a total of 9 hours of production and is running on lines that have 18 of the 24 total line hours scheduled, leaving 6 hours available for scheduling more work.

**Schedule hours** . Schedule hours are the number of line hours required to complete a schedule. Schedule hours begin with line changeover and end when the last unit on

a schedule is completed. The schedule may take several days to complete, so the schedule hours would be spread across those days.

**Line hours scheduled and Line hours available.** Line hours scheduled show the production load (in hours) for that day on that production line. The line hours available show how much of the production line capacity is available (has not been scheduled). If line hours available shows negative hours, the line is overloaded. Both the line hours scheduled and line hours available change as schedules are added or deleted, or schedule quantities are changed.

Schedule Date	Net Demand	Schedule Quantity	Proposed Change
Day 1	600	600	0
Day 2	600	600	0
Day 3	600	590	-10
Day 4	600	0	600

The following example shows the conversion of schedule quantities to line hours scheduled. It takes an hour to make each unit (flow time) and 120 units are produced each hour (cycle time). The parts for each day's schedule are started on the preceding day. The schedule quantity of 600 on the first day consumes 6 of the 8 line hours available. Another item is made on this line, ahead of this schedule, and uses 2 line hours. The total line hours scheduled are 8 hours (6 hours + 2 hours).

On Day 2 and Day 3, only one item is scheduled on the line. The second day has more line hours scheduled because the parts for the third day's schedule are started on the second day. On Day 4, 8 hours are available on the line, since nothing has been scheduled.

Schedule Date	Schedule Quantity	Schedule Hours	Line Hours Scheduled	Line Hours Available
Day 1	600	6.0	8.0	0.0
Day 2	600	6.0	6.0	2.0
Day 3	590	5.9	4.9	3.1
Day 4	0	0.0	0.0	8.0

A schedule can overload a production line. A schedule for 1,200 units is entered on Day 4 and uses 11 hours of production time: 1 hour on Day 3 to start the schedule and 10 hours on Day 4 to finish making all the parts. The overload is not shifted to any other day, but remains on the schedule due date. To eliminate the overload, the schedule on Day 3 could be increased and the schedule on Day 4 could be decreased.

Schedule Date	Schedule Quantity	Schedule Hours	Line Hours Scheduled	Line Hours Available
Day 1	600	6.0	8.0	0.0
Day 2	600	6.0	6.0	2.0
Day 3	590	5.9	5.9	2.1
Day 4	1200	11.0	10.0	-2.0

You also can solve an overload problem by increasing shift lengths, decreasing the cycle time, changing schedule quantities, optimizing the sequence of schedules, and overlapping the start and end of schedules. See “Calculating schedule hours” on page 2-105 for more information on determining duration of schedules.

The second part of the Summary display converts schedule quantities to line hours. Line hours reflect the amount of time that a production line is dedicated to building an item or items. Through Production Line Variable Capacity maintenance, you can specify how many hours (both preferred and maximum) are available per line for first, second, and third shifts. The comparison of Line Hours Scheduled to Line Hours Available yields a line utilization by day.

## Adding schedules

Schedule Entry and Maintenance is accessed by option 4 on the REP Schedule Management menu (AMQM40). The schedule entry display appears when you use the Schedule Add function key. Using this display, you can create a schedule on a given date, multiple schedules on the same date, or create schedules over a range of dates. Also, for the schedule being created, you can specify an alternate routing, a reschedule code, and a consume date. If EPDM is activated, schedule will default to the current revision based on the schedule start date. For this date, the item line record with the primary process is selected. A function key can be used to select an alternate process if necessary.

### Entering a schedule over a range of dates

If you enter the total schedule quantity for a period of time, the system automatically calculates the number of units you need to build by day. It divides the entered quantity by the number of working days that you specify. The default number of working days is 1. Using this function, you can decrease the time needed to create schedules with the same quantity over a range of dates.

### Determining schedule quantities

Using the schedule entry display, you can specify a quantity with which to start the manufacturing process and have the system calculate the expected output quantity (schedule quantity). The beginning quantity is called the In Quantity, and may be due to a maximum batch quantity that can be produced. The result of the process is the schedule quantity or the amount expected into inventory. The In Quantity is adjusted by the item's cumulative yield (specified in EPDM or PDM) to determine the final schedule quantity.

If you do not use an In Quantity, you can enter a schedule quantity representing the amount you want to receive into inventory. Component requirements are adjusted by yield to provide enough component parts to produce the requested schedule quantity.

### Defining carry forward schedules

A carry forward process keeps a running total of how cumulative receipts compare to cumulative schedules. Schedules can be defined as a part of a production campaign. The carry forward option values are:

- 1 Schedule is not part of a production campaign.
- 2 Schedule is part of a production campaign.
- 3 This schedule is the last schedule in a production campaign.

See “Carry forward function” for more information.

### **Defining the reschedule code**

This code indicates whether this schedule can be rescheduled automatically during the MRP planning run.

- 0** Default to item reschedule code. This is the default setting for the reschedule code.
- 1** Cannot be rescheduled automatically
- 2** Can be scheduled out
- 3** Can be scheduled in
- 4** Can be scheduled both out and in

Primed schedules can be rescheduled automatically only if you answered the tailoring question in REPCTL to allow changes to these schedules.

### **Specifying a consume date**

The MRP planning run creates planned orders to represent production schedules that need to be created. The MRP Planned Order (PLNORD) and Order Review (ORDREV) files are updated with schedule information as schedules are entered. The MRP planned orders are shown in REP as demand, and the consume date determines the starting date on which planned orders are being offset or consumed by the new schedule. If the schedule quantity is greater than the planned order quantity on the consume date, the next planned order is consumed until all of the schedule quantity has been used.

### **Deleting schedules**

You can delete planned schedules using the AMQ445 display. By changing a planned schedule quantity to zero and pressing **Enter**, you delete the schedule. If the schedule is released (status greater than 00), you cannot delete the schedule using this method. Instead, use the Purge Schedules menu option to purge the schedule.

### **Schedule status codes**

REP uses the same codes as manufacturing order processing to indicate the schedule's status. The schedule status codes are:

- 00** Schedule is planned; schedule entered but not released.
- 10** Schedule has not been started; schedule released but no activity reported against it.
- 40** Schedule has been primed; transactions may have occurred.
- 55** Schedule complete; last transaction reported against the schedule.

When a final transaction (last transaction field on transaction record) is entered against a schedule, the schedule's status code is automatically changed to 55 or closed. Late transactions can still be posted to closed schedules as long as the material issued supports the transaction.

## Lot sizing for multiple schedules

The multiple schedules/day function provides the capability to enter and process multiple schedules per day for an item, line, and warehouse. You can create more than one schedule per warehouse, line, schedule date, item and S-number with the use of lot sizing. Key benefits of this function are:

- Assists you in quickly creating multiple schedules per day for an item.
- Creates predetermined lots for a day from an item's daily demand.
- Identifies multiple schedules by schedule number on pertinent displays and reports.

Items approved for lot sizing require some additional information to create multiple schedules.

- The Item Balance (ITEMBL) records for these items are flagged with a YES code in the field for lot sizing. Each item also has a standard container size, stored in the **Quantity per Container** field.
- The Item/Line (ITMLIN) records for these items must have schedule lot size, lot minimum quantity, and lot maximum quantity information supplied. These values must be multiples of the standard container quantity.

**Lot sizing algorithm.** XA uses a lot sizing algorithm to generate scheduled lots. The elements used by the algorithm are:

- The lot size quantity indicates the target quantity, in pieces, for schedules created through lot sizing.
- The lot minimum quantity indicates the least allowable quantity, in pieces, for a schedule created by lot sizing.
- The lot maximum quantity indicates the greatest allowable quantity, in pieces, for a schedule created by lot sizing.
- Lot sizes are rounded to a multiple of the standard container quantity in the Item Balance record.

Following is an example of the algorithm used in lot sizing. Assume the data base contains this information:

---

Schedule lot size	250 - standard lot size to produce
Lot minimum quantity	100 - minimum lot size that can be built
Lot maximum quantity	330 - maximum lot size that can be built
Standard container quantity	10 - multiple quantity to which the schedule is rounded

Use the following table for information used in the lot sizing rules.

Day	1	2	3	4	5	6
Schedule quantity	1000	900	800	700	600	199
Schedule lot size	250	250	250	250	250	0
Number of full lots	4	3	3	2	2	0
Remainder to be spread	0	150	50	200	100	0
Resulting lots	250	300	270	250	300	199
	250	300	270	250	300	
	250	300	260	200		
	250					

**Lot sizing rules** . Only planned schedules (status=00) are eligible to be lot sized.

1. Every lot created will be greater than or equal to the minimum lot size, less than or equal to the maximum lot size, and will be a multiple of the container quantity. The sum of the lots will equal or exceed the original quantity.
2. Divide the unreleased schedule quantity by the standard lot size to get the number of whole lots.
3. If the number of whole lots is zero, create one lot meeting the criteria in rule 1.
4. If the number of whole lots is greater than zero, if the remainder can be prorated without exceeding the maximum lot size, prorate it in multiples of container size. Otherwise, create an additional lot for the remainder meeting the criteria in rule 1.

**Example 1** . On day 3:

1. Divide schedule quantity by schedule lot size to determine full lots.  

$$800 / 250 = 3 \text{ full lots} + 50 \text{ remainder}$$
 (rounded to a multiple of standard container)
2. Prorate any remainder over full lots and add any of its remainder to first lot.  

$$50 / 10 = 5 \text{ containers}$$

$$5 / 3 = 1 \text{ container to each lot} + 2 \text{ remainder}$$
  
 Add 1 container to each lot  
  
 Plus 1 additional container to first 2 lots  
  

$$250 + 10 + 10 = 270$$

$$250 + 10 + 10 = 270$$

$$250 + 10 = 260$$

**Example 2** . On day 4, two lots of 250 are initially created. A remainder of 200 is prorated to create lots of 350 each. Since the maximum lot size is exceeded in the first lot, an additional lot is created instead of prorating the remainder.

$$700 / 250 = 2 \text{ full lots} + 200 \text{ remainder}$$

Prorate any remainder over full lots.

$$200 / 2 = 100$$

$$250 + 100 = 350$$

$$250 + 100 = 350$$



350 exceeds the maximum, so create an additional lot.

**Example 3.** On day 6, the schedule quantity is greater than the minimum lot size and less than the maximum lot size, so no lot sizing occurs. However the rules for minimum, multiple, and maximum are still applied. Applying the standard container size brings the lot size to 200.

## Material check

A component shortage check determines if enough components are available to meet the proposed schedule. Components are tied to an operation through the **Operation Where Used** field defined in the Component/Line file. For each component on a schedule, availability is calculated based on the following criteria:

- Component-required dates are calculated using a build quantity of one and scheduling the item through its routing operations.
- Component-required quantities are calculated using the schedule quantity times the product structure's adjusted quantity per.
- Based on the component-required date, each of the component's scheduled receipts and allocations are time-phased in relation to the component's current availability and quantity requirements.

## Changing schedule quantities

When the schedule quantity is changed, the component quantities must be changed correspondingly. Operation yield is taken into account during this calculation. If the schedule is in process and the schedule quantity is decreased, there may be a sufficient quantity or an overabundance of components already at the line locations or picked and on the way to the production line. The replenishments are adjusted to prevent over-supply.

Many of the changes to schedules are processed by a server program. If this server program is in a Held status or is not active, the schedule is not changed until the server program is released from the Held state or is made active. Use the CAS maintenance menu AMZM30 and the Unattached Job Status menu option to check the status of the server program (AMQ4N). Release or start the server's unattached job to begin processing the schedule changes.

## Sequencing schedules

When you are sequencing schedules, you can display the items to be sequenced by item, by line, or by planner.

When you select a production line and due date, all schedules meeting the selected criteria are shown. The last schedule that was run on the prior day is also shown. If today's first schedule and "yesterday's" last schedule is for the same item, changeover hours will not be included in today's load hours. It is assumed the production line is already setup to produce today's schedule.

When the order of the schedules run is changed, it is your responsibility to maintain the run sequences. If you use mixed model processing, use the same run sequences for all schedules. This results in a changeover time equal to zero once the first schedule is completed.

## Campaign schedule considerations

Since you can only review a single day at a time when you are sequencing schedules, campaign schedules are not apparent. When you sequence schedules, the only processing difference is that a carry forward quantity greater than zero is added to the schedule quantity for subsequent calculations though only the schedule quantity is displayed.

## When schedule hours are updated

Many events can change the number of line hours a schedule uses and also change the load on a particular production line. The REP Schedule Hours (SCHHRS) file tracks schedule hours by line and by day. This file is refreshed when you run the Recalculate Schedules menu option. Schedule hours also are updated when any of the following changes occur:

- A new schedule is added.
- Schedule quantity is changed.
- Changeover hours are changed.
- Flow time hours are changed.
- Pieces/hour rate is changed.
- Run sequence is changed.
- Carry forward quantity is added to schedule.
- Planned schedules are deleted.
- Released schedules are purged.
- Production line variable capacity is changed (and after the recalculate schedules menu option has been run).
- Base production line hours in the production facility record are changed (and after the recalculate schedules menu option has been run).

**Calculating schedule hours** . Schedule hours is the amount of production line hours to be consumed by a schedule. The number of production line hours available (capacity) is the sum of shift lengths for each work day. The key relationships in calculating schedule hours are:

- Changeover hours
- Flow time
- Cycle time
- Schedule quantity
- The maximum amount of overlap the next schedule to be run has with the currently running schedule.

The following figure illustrates the key relationships involved in calculating schedule hours. In the figure, three items (A, B, and C) are scheduled on a production line with seven hours of desired capacity and eight hours of maximum capacity. The difference between desired and maximum shift hours allows a buffer of one hour to handle unanticipated problems on the line.

A total of five A items are produced with a spread of .5 hours between units. As the last two units of A are produced, or one hour before the last A comes off the line, changeover of item B begins. Four units of item B are produced. As the last unit of B is being produced on the line, item C begins production. Item C production time is overlapped by item B for .5 hour, and B overlaps A by one hour.

**A, B, C** Finished units coming off the line.

\*\* Changeover time

— Flow time - cycle time

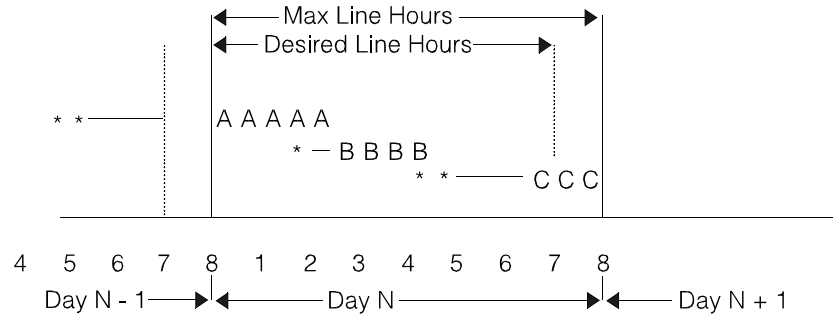


Figure 2-20. Scheduling algorithm

**Calculating line utilization.** Schedule hours, or the amount of line hours of capacity that a schedule consumes, is based on the following equation:

Schedule hours equals:

$$\frac{((\text{Changeover} + (\text{Flow Time} - \text{Cycle Time})) + (\text{Schedule Quantity} \times \text{Cycle Time})) - \text{Overlap}}{\text{Schedule Quantity}}$$

Overlap is the lesser of:

- (Flow Time - Cycle Time) for the schedule running.
- (Changeover + Flow Time - Cycle Time) for the next item scheduled.

The overlap calculation is performed if, using the overlap code in the Work with Item/Line function, you specified that the item's schedules can be overlapped with the preceding schedule. If you did not allow the item's schedules to overlap, then the overlap time is assumed to be zero.

The maximum amount of overlap between the two schedules is calculated. You can reduce the amount of overlap when you sequence the schedules.

Changeover hours are added only if the preceding schedule is for a different item.

For the preceding example, assume that overlap is allowed on all the items shown. This table shows how overlap is calculated for items A, B, and C.

Item	Change over	Flow Time	Cycle Time	Potential Overlap	Status
A	1.0	2.0	.5	2.5	First scheduled
B	.5	1.0	.5	1.0	Running
C	1.0	2.0	.5	2.5	Next scheduled

This table shows the impact of overlap on the schedule hours calculation.

Item	Change over	+	(Flow Time - Cycle Time)	+	(Sched Qty x Cycle Time)	-	Overlap	=	Sched Hrs	=	Line Hrs Day N (Today)	Line Hrs Day N-1 (Yesterday)
A	1.0	+	(2.0 - .5)	+	(5 x .5)	-	0.0	=	5.0	=	2.5	2.5
B	.5	+	(1.0 - .5)	+	(4 x .5)	-	1.0	=	2.0	=	2.0	0
C	1.0	+	(2.0 - .5)	+	(3 x .5)	-	.5	=	3.5	=	3.5	0
Totals								=	10.5	=	8.0	2.5

Here is another way of describing the scheduled hours calculation:

**Step 1. Schedule quantity x cycle time** . The result of this calculation is the amount of hours a line is dedicated to having completed units roll off the end of that line. This calculation also indicates if the schedule is realistic—whether the schedule quantity, considering the cycle time, can be produced within the number of line hours allotted. If the schedule hours exceed line hours, an exception message is issued. For item A, a schedule quantity of five units consumes 2.5 hours (5 x .5) of the line hours available.

**Step 2. Changeover + (flow time - cycle time) - overlap**. The result of this calculation is added to the result in step 1 to determine an item's total schedule hours: changeover time (1.0 hour, the length of time the line is down for setup), plus flow time less one cycle time (2.0 hours - .5 hours), less overlap (0.0 hours), the example assumes there is no overlap with the previous day's schedule.

The resulting schedule hours for A, or the amount of time that item A's schedule consumes, is 5 hours, which is the combined results of these two steps. If you specified in the Work With Item/Line function that the first schedule of the day started with cycle time, then 2.5 hours are assigned to today's line loading, while changeover and flow time are assigned to the previous day's line loading.

In the example in Figure 2-20, 8.0 hours are assigned to today's line loading, while 2.5 hours are assigned to the previous day's loading.

**Highlighting exceptions** . When you review the displays that show schedule and line hours, you receive a warning message to alert you to the following exception situations:

- Planned line hours are less than the schedule hours.
- Maximum line hours are less than schedule hours.
- Schedule hours are less than the minimum line hours.

**Determining schedule start and stop times** . Scheduling identifies a schedule's start and stop times so that component material requirements for the schedule can be estimated more accurately. In particular, end-to-end scheduling is concerned with those schedules that may overlap multiple days of production (such as a schedule that starts on day N-1 and is completed on day N). In the example in Figure 2-20, the component material is either initially required at the line on day N-1, or on both days N-1 and N, depending on when the schedule starts (or finishes), the time between operations, production line capacity by day, and the operations to which materials are assigned.

Two fields are assigned to the schedule in the MOMAST file: Start Time and Stop Time. The start time field is based on the day a schedule begins. The stop time field is

based on the day the schedule ends (or is due). Both field times are calculated in relation to the line hours available on the production line. A start time of 1.5 means that a schedule is planned to begin 1.5 hours into the work day. Material required at the first operation should be available at the beginning of this day.

The stop time for the last day or the day the schedule is due is based on the number of hours into the day that a schedule ends. If a schedule is planned to end 6.5 hours into the day, the stop time would contain the value 6.5. If the production line is only scheduled for 6 hours that day, then the schedule would be forced to end at 6.0 hours, or the end of the last shift.

The first step in determining start and stop times is to retrieve the previous schedule stop time. The last schedule's stop time is the starting point to determine when the next schedule should begin. From the stop time, overlap hours are deducted to reach the next schedule start time and to determine the start day. The balance of the schedule hours are then forward scheduled from the last schedule start time to reach the stop time and the due date. If the stop time exceeds the schedule's due date, the stop time is forced to the end of the last shift on the due date.

One variation to this scheduling technique is used for the first schedule of the day. If the stop time calculated by forward scheduling from the previous schedule's stop time results in part of the new schedule being planned before the due date, then the first cycle time (first unit to be completed) will be moved to the due date so that all units are planned for completion on the due date. The cycle hours (quantity x cycle time) are forward scheduled from the beginning of the due date while the remaining schedule hours are scheduled back from the beginning of the due date. All of these hours less overlap are included in the line hours on the Schedule Entry and Maintenance display.

In the previous illustration, the start and stop times are calculated as follows:

Item	Start Date	Start Time	Due Date	End Time
A	N-1	4.5	N	2.5
B	N	1.5	N	4.5
C	N	4.0	N	7.0

Note that the schedule for Item C's end time is forced back to 7.0—the desired number of shift hours for the due date. If the desired shift length for the line on day N is extended to 8.0 hours, then the ending time for C would be 8.0 hours.

### Determining component required dates

Within a production schedule that involves multiple operations, a component's required date is determined by the start date for the operation which is associated with the component. The operation's start date is determined by its place in the overall production sequence. Therefore, the component's required date is the same as the start date of the operation. The **Operation Where Used** field in the CMPLIN file indicates which operation is associated with a component. For example, all components with operation 10 in their **Operation Where Used** field must be at the production line when operation 10 is scheduled to begin.

When the system calculates operation start dates within a production schedule, it compares the total routing time (sum of the setup and run duration, move, and queue times for all operations) to the item/line time (sum of changeover and flow time). Other

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parameters are also considered, such as first schedule start option, schedule sequence on Day N, etc. For example, if 5 items must be completed on April 10 and the total item/line time is 2 days, the system assigns April 10 to cycle time, then counts back two days to arrive at a start date of April 8.

In an ideal schedule of operations, routing time would equal item/line time. If the item/line time is short, all components for all operations could be required on the first day of the schedule. If the flow time were long, the first component for the first operation could be needed several days or weeks before the last component of the last operation.

In reality, routing time and item/line time are often not equal, as illustrated in Figures 2-21 and 2-22. When this occurs, it indicates that you may need to set up more appropriate changeover and/or flow times for the production item. In the example illustrated, 5 finished items are required on Day N. Notice that the first item of a schedule is completed as part of the flow time while the remaining items are completed in corresponding periods of the cycle time (in this example, 4 items in 4 periods).

As shown in the figure that follows, when the routing total is less than the item/line total, operations scheduling is calculated forward from the start of changeover time. The time for each operation is added until the next day is reached. The component required dates for later operations fall on later days. Operation times continue to be added until the start dates (and corresponding component required dates) for all operations have been determined.

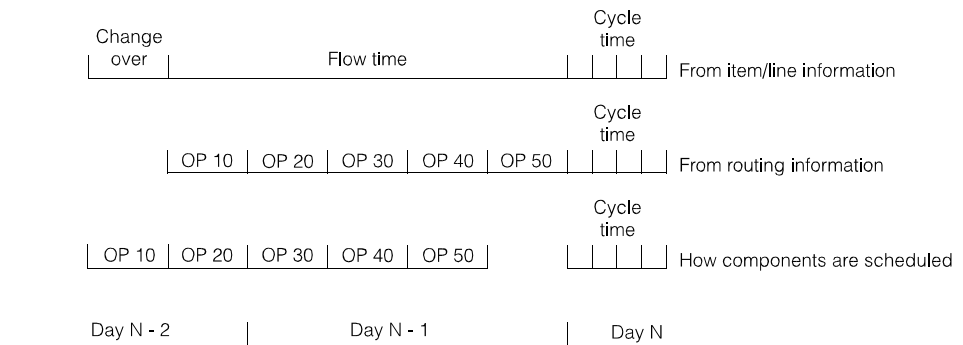


Figure 2-21. Schedule when operations total is less than changeover plus flow.

As shown in the figure that follows, when routing time is greater than the item/line time, operation scheduling is calculated backward from the end of the changeover/flow period. The system subtracts the operation time for the last operation from the end of the changeover/flow time. If an operation's start day is pushed back to an earlier day, the corresponding component required date is also pushed to that day. The system subtracts time for each operation until the beginning of the changeover/flow period is reached. If more operations remain, they are all assigned the changeover start date.

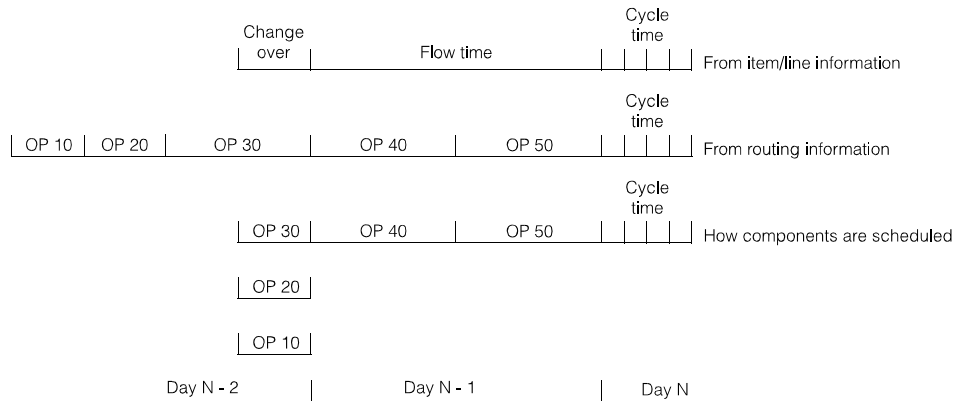


Figure 2-22. Schedule when operations total exceeds changeover plus flow time.

### Recalculating schedule hours

The system recalculates the Schedule hours for all schedules on the selected date and production line whenever any of the values used to calculate schedule hours are changed for any of the schedules due. Recalculation is necessary since start and end times are calculated in the schedule hours calculation routine, and changing the end time for any schedule affects all subsequent schedules.

You also should run the Recalculate Schedules menu option when you change shift lengths on a production line or alter information on a schedule outside of the Enter and Maintain Schedule option.

### Available to Promise (ATP)

REP's available to promise information (accessed in Schedule vs Demand Inquiry) tells you what quantities of an item remain uncommitted, that is, not needed to meet the current demand. The system calculates the quantities at the time of the inquiry, using current inventory, demand, and production information.

#### Available to promise in REP

In REP, available to promise assumes that no items are available for other uses as long as any demand within the horizon is not covered by on hand inventory and projected receipts. In calculating ATP, the system surveys demand to the end of the ATP horizon (defined in the following example). If demand exceeds projected supply in the future, the system reserves inventory to cover that demand before it shows any quantities as available.

For example, the demand for an item exceeds the supply on days 16 and 17. The demand is equal to supply on day 15, and demand is less than supply on days 13 and 14. The system subtracts the uncovered (unmet) demand on days 16 and 17 from the excess supply on day 14 before it shows an available quantity on day 14. If the excess supply on day 14 is not enough to cover the excess demand on days 16 and 17, the system subtracts the remaining demand from the excess on day 13. Therefore, even though supply exceeds demand on day 14, no items are available to promise because all of the excess on day 14 is needed to cover future demand.

## Available to promise horizon

The system calculates ATP quantities by day for up to three years. The system stops calculating ATP at the end of significant information or at the three year limit, whichever comes first. For each item, the system stops calculating on the last day containing one of the following kinds of information:

- Cumulative Material Lead Time (CMLT) time fence
- Demand time fence
- Last customer order
- Last option backlog for an item
- Last open order (manufacturing or purchasing)
- Last manufacturing allocation (if you are viewing a component item)
- Last firm planned order. Planned orders may appear within the horizon, but they do not affect the length of the horizon.

As information for an item changes, the length of the ATP horizon can also change.

**Note:** For an option item, the system uses the option item's Lead Time Adjustment (ACDXVA) to schedule its start date earlier than the due date of its parent.

## Schedule vs demand quantities in ATP

To calculate the demand for each period, the system takes information from the following sources:

- Customer orders for end items and component items
- Optional backlog for option items
- Manufacturing allocations for component items
- MRP dependent demand for component items
- User defined demand from the Schedule Demand Interface file.

The system gets information about expected receipts from the following sources:

- Open manufacturing schedules and orders from the Manufacturing Order Master (MOMAST) file.
- If MRP is not installed, schedules that have not been released and manufacturing orders with a status code of 00.
- Open purchase orders from the Purchase Order Master (POMAST) file.
- Purchase order blanket releases from the Purchase Order Blanket (POBLKT) file.
- Firm planned orders and planned orders from the Planned Order (PLNORD) file, which is maintained through MRP.

**Note:** The system gets information about planned orders only if their due date is on or after the Demand Time Fence date. The Demand time fence identifies a no-change or frozen planning zone for the item based on the number of days you enter.

## How to calculate available to promise

The system calculates Available-to-Promise (ATP) quantities in three steps:

1. Calculate projected ending inventory (PEI) for each day.
2. Calculate the unmet future demand (UFD) for each day.
3. Calculate ATP for each day.

**Note:** In this discussion on ATP, a period can be equivalent to a day.



The calculation uses the following kinds of information:

- Demand** The total customer backlog and manufacturing allocations due in each day. It can also include generated requirements, if MRP/MPSP is installed. If MRP/MPSP is not installed, user defined demand can be extracted from the Schedule Demand Interface file.
- Supply/Expected Receipts** Total expected receipts during the day, including open, firm planned, planned orders, and schedules.
- Projected ending inventory (PEI)** Beginning inventory balance plus supply minus demand for the day.
- Unmet Future Demand (UFD)** The amount of demand that is not covered by supply in the next day and all future days. For a specific day, UFD is the required starting inventory of the next day.
- Required starting inventory (RSI)** Demand minus supply plus the unmet future demand (UFD). This is the amount of inventory needed to meet a specific days demand plus any shortage in coverage against future demand. The calculation for RSI in a day is demand minus supply plus UFD. The RSI for this day is the UFD for the previous day.
- Available to promise (ATP)** Projected ending inventory (PEI) minus the unmet future demand (UFD) for the day.

This table shows a full set of ATP information and calculated results for a horizon of ten days. The item has a past due demand of 325 and no on-hand inventory. Following This table, each step in the calculation of ATP is shown.

On hand = 0

Type	Past Due	Days									
		1	2	3	4	5	6	7	8	9	10
Demand	325	---	---	---	20	---	---	30	840	---	6
Supply		400	---	---	---	345	---	---	843	---	---
PEI	(-325)	75	75	75	55	400	400	370	373	373	367
RSI		<0	20	20	20	<0	33	33	3	6	6
UFD		20	20	20	0	33	33	3	6	6	0
ATP		55	55	55	55	367	367	367	367	367	367

**Step 1. Calculate the projected ending inventory .** The information needed for calculating the projected ending inventory is shown in This table. Projected ending inventory (PEI) = PEI for previous day - demand for the day + supply for the day:

On hand = 0

Type	Past Due	Days									
		1	2	3	4	5	6	7	8	9	10
Demand	325	---	---	---	20	---	---	30	840	---	6
Supply		400	---	---	---	345	---	---	843	---	---

Type	Past Due	Days									
		1	2	3	4	5	6	7	8	9	10
PEI	(-325)	75	75	75	55	400	400	370	373	373	367

The past due demand is 325; on-hand inventory is zero. The overdue demand is added to demand for day 1. Therefore, the PEI for day 1 is:

$$\begin{array}{r}
 0 \text{ on-hand inventory} \\
 - 325 \text{ demand in day 1, including overdue demand} \\
 + 400 \text{ supply in day 1} \\
 \hline
 75 \text{ projected ending inventory for day 1}
 \end{array}$$

The PEI for day 2 is:

$$\begin{array}{r}
 75 \text{ previous PEI} \\
 - 0 \text{ demand in day 2} \\
 + 0 \text{ supply in day 2} \\
 \hline
 75 \text{ projected inventory for day 2}
 \end{array}$$

**Step 2. Calculate the UFD and RSI.** This step determines how much inventory must be reserved to cover demand that is not met in future days (Unmet Future Demand). It requires calculating a required starting inventory (RSI) for each day as the basis for the unmet future demand (UFD). The calculation begins with the last day in the horizon. Calculating the UFD starting at the end of the horizon means that large demands in later days commits (reserves) inventory in earlier days until all later demand is covered.

The calculation begins with the last day showing demand and works back to the present day. The required starting inventory for a day becomes the unmet future demand of the previous day. For example, in the following figure, RSI of 6 in day 10 becomes the UFD for day 9.

**Note:** The UFD for the last day is always zero, since no demand exists past this day.

This table shows the information used for step 2 of the ATP calculations:

On hand = 0

Type	Past due	Days									
		1	2	3	4	5	6	7	8	9	10
Demand	325	---	---	---	20	---	---	30	840	---	6
Supply		400	---	---	---	345	---	---	843	---	---
RSI		<0	20	20	20	<0	33	33	3	6	6
UFD		20	20	20	0	33	33	3	6	6	0

In the following figure, the unmet future demand quantity for day 10 (the last day) is zero.

The required starting inventory (RSI) for day 10 is:

$$\begin{array}{r}
 6 \quad \text{demand for day 10} \\
 - 0 \quad \text{supply for day 10} \\
 + 0 \quad \text{unmet future demand} \\
 \hline
 6 \quad \text{required starting inventory (RSI) for day 10}
 \end{array}$$

To satisfy demand in day 10, there should be a required starting inventory of six units. The RSI of six units becomes the unmet future demand for day 9.

The required starting inventory for day 9 is:

$$\begin{array}{r}
 0 \quad \text{demand for day 9} \\
 - 0 \quad \text{supply for day 9} \\
 + 6 \quad \text{unmet future demand} \\
 \hline
 6 \quad \text{required starting inventory (RSI) for day 9}
 \end{array}$$

The RSI for day 8 is:

$$\begin{array}{r}
 840 \quad \text{demand for day 8} \\
 - 843 \quad \text{supply for day 8} \\
 + 6 \quad \text{unmet future demand} \\
 \hline
 3 \quad \text{required starting day for day 8}
 \end{array}$$

**Note:** In day 5, the RSI is less than 0 (supply exceeds demand and UFD). In this situation, the UFD of day 4 is shown as 0 and not as a negative value.

**Step 3: Calculating available to promise.** The available to promise for a day is the projected ending inventory (PEI) for the day minus the unmet future demand (UFD) for the day.

This table shows the information needed to calculate the available to promise quantities per day:

On hand = 0

Type	Past due	Days									
		1	2	3	4	5	6	7	8	9	10
PEI	(-325)	75	75	75	55	400	400	370	373	373	367
UFD		20	20	20	0	33	33	3	6	6	0
ATP		55	55	55	55	367	367	367	367	367	367

Available to promise for day 6 is:

$$\begin{array}{r}
 400 \quad \text{projected ending inventory for day 6} \\
 - 33 \quad \text{unmet future demand for day 6} \\
 \hline
 367 \quad \text{Available to promise for day 6}
 \end{array}$$

Negative available to promise quantities are shown as appropriate to indicate that your inventory plus current and planned production is not enough to meet known demand. Additional demand increases the imbalance.

---

## The execution cycle—Releasing and Tracking Schedules

This section describes the execution cycle concepts and activities.

### Execution cycle activities

The activities you perform during the execution cycle involve running the production schedules created during the planning cycle.

#### Activities to perform before running a production schedule

- Check component availability, using the Material Check function in the Enter and Maintain Schedules option on the Schedule Management menu (AMQM40).
- Allocate critical components, using the Allocation function in the Released Schedule maintenance option of the File Maintenance menu (AMQM50). (This applies to components using schedule-based replenishments.)
- Determine the components needed to begin the production run, using the Prime Production Lines option on the Material Management menu (AMQM30).
- Print Pick Lists to determine which components need to be replenished at the production line, using the Print Pick List option on the Material Management menu (AMQM30).
- Report components that have been transferred to the production line, using the Enter Transactions option on the Material Management menu (AMQM30).

#### Activities to perform after starting a production schedule

- If you are not using auto-replenishments, report the need for component replenishments at the production line. Enter Replenishment transactions when empty parts containers are returned to the store room or when a line location has a low stock level. You can enter transactions in any of the following three ways:
  - Enter the transactions directly through the Enter Transactions option on the Material Management menu (AMQM30).
  - Collect transactions through an offline device. Save the transactions onto a diskette, then restore them onto the system for processing, using the Enter Transactions From Offline Files option on the Material Management menu (AMQM30).
  - Collect transactions through a shop floor terminal used by the PM&C application. The transactions are sent to the system and processed by the PM&C application.
- Print Pick Lists to determine which components need to be replenished at the production line, using the Print Pick List option on the Material Management menu (AMQM30).
- Report components that have been transferred to the production line, using the Enter Transactions option on the Material Management menu (AMQM30).
- Report the number of scheduled items completed, using the Enter Transactions option on the Material Management menu (AMQM30).

- Print the Transaction Register, using the Print Transaction Register option on the Material Management menu (AMQM30).

### **Other activities you can initiate while running a schedule**

- Change the schedule quantity, using the Enter and Maintain Schedules option on the Schedule Management menu (AMQM40), if you chose this option in REP Control File maintenance.
- Maintain the schedule's operations and components using the Released Schedule maintenance option on the File Maintenance menu (AMQM50).
- Increase or decrease component allocations at the supplying location, using the Released Schedule maintenance option on the File Maintenance menu (AMQM50).
- Substitute one component for another, using the Released Schedule maintenance option on the File Maintenance menu (AMQM50).
- Report scrap, using the Enter Transactions option on the Material Management menu (AMQM30). You can scrap a partially completed unit which causes the material and labor already in the partially completed unit to be charged as scrap against the schedule. You can scrap components damaged during an operation or report faulty components drawn from stock.
- Report the status (up or down) of the production line, using the Enter Transactions option on the Material Management menu (AMQM30).
- Correct error and unapplied transactions, using the Enter Transactions option on the Material Management menu (AMQM30). Transactions are edited as they are entered, and those without errors are immediately posted. If your system is tailored to never accept a negative on-hand balance, a transaction which would cause a negative on-hand balance becomes an unapplied transaction. These unapplied transactions are not posted until the on-hand balance at the location is corrected. If your system is tailored to accept a negative on-hand balance once and you currently have a negative on-hand balance, a transaction which would cause the negative on-hand balance to become further negative will become an unapplied transaction. Transactions with errors are not posted. These errors must be corrected before you can close the batch.

### **Activities to tear down the line when the schedule is complete**

- Print an Excess Stock Report, using the Print Component Return List option on the Material Management menu (AMQM30). The report lists the components at the production line locations that are not allocated.
- Enter TW transactions to return components to their original or another stocking location, using the Enter Transactions option on the Material Management menu (AMQM30).

### **Activities performed periodically**

- Cost the value of Work-In-Process (WIP), using the WIP Costing option on the Reports menu (AMQM20). The material, labor, and overhead costs for the units on the production line are calculated and added to the WIP costs for all open manufacturing orders and production schedules.
- Purge completed schedules, using the Purge Schedules option on the Schedule Management menu (AMQM40).

## Activities you can perform at any time

- Print a summary of production schedule line load, using the Production Schedules option on the Reports menu (AMQM20). You can review the line load for each schedule by planner, production line, or item.
- Review or print schedule performance, using the Schedule Performance option on the Inquiry menu (AMQM10) or the Reports menu (AMQM20). You can review the performance of schedules based on the number of units scheduled, completed, and scrapped.
- Review or print released schedules, using the Released Schedules option on the Inquiry menu (AMQM10) or the Reports menu (AMQM20). You can review the operations and components used in released schedules.
- Maintain production facility records, using either EPDM or if PDM is installed, the Production Facility maintenance option on the REP File Maintenance menu (AMQM50). You can maintain the records that define the manufacturing characteristics of production lines, work stations, and work centers.
- Maintain stock locations, using the Location Detail, Batch/Lot Numbers, and Batch/Lot Quality Control Status options on the File Maintenance menu (AMQM50). You can add or delete stock locations, change their characteristics, and change the batch/lot ID and quality control status for an item in a location. These changes will not affect released schedules.
- Maintain the Item Balance records using the File Maintenance menu (AMQM50). You can add or delete items in a warehouse, change lead times, and change the REP control information.
- Maintain item records, using the Item Master maintenance option on the IM File Maintenance menu (AMIM70). You can add or delete items, and change the control information that effects the lot sizing of demand passed to REP.
- Maintain routings, using either EPDM or PDM. You can add or delete routings, or change routings and their operations. You also can change both the base and variable of production lines.
- Maintain bills of material, using either EPDM or PDM. You can add or delete bills of material, or change bills of material and their components.
- Maintain production line layouts, using the Work With Item/Line option on the File Maintenance menu (AMQM50). You change the changeover, flow times, and production rate for an item on a production line. You also can change the line locations that receive components and the maximum level of stock at the locations.
- Recalculate schedule line loads, using the Recalculate Schedules option on the Schedule Management menu (AMQM40). If you change the base capacity of a production line or change the production calendar from the Work with Calendars option on the IM File Maintenance menu (AMIM70), you should recalculate the schedule line loads to determine the effects of the changes you made.
- Change REP's operational options, using the Control File option on the File Maintenance menu (AMQM50). You can choose to: assign a default batch/lot ID for planned issue transactions; prevent changes to schedule quantity and due date on released schedules; allow stock allocated to a schedule to be used by another schedule; set tolerance limits for quantities reported by schedule receipt, operation reporting, and schedule scrap transactions; and allow schedule receipt, operation reporting, and schedule scrap transactions to be posted across multiple schedules.

For each file that you can maintain, inquiries and reports are available to show you the information in each file. You can run these inquiries and reports at any time.

## Released schedules editing

When you release a schedule, REP performs the following edit checks:

- All characters in the S-number are valid. Valid characters are 0-9, A-Z, and blanks.
- If the bill of material option for this item is YES:
  - If required by the item, that an option is selected for particular feature numbers.
  - The feature/option selected is a valid option for the feature number.
- The bill of material has at least one active component.
- At least one routing operation exists for either the standard routing or alternate routing (if selected).
- The **Operation Where Used** routing of components, feature options, and phantom components is valid.
- The delivery locations for all components exist and are valid production line locations.
- The supply stock locations for all components are valid.

## Effect of alternate operations on schedule release

An alternate routing code can be specified for a schedule. During Schedule Release, the additional operations are selected and added to the routing. The components associated with the alternate operations are also selected. If an alternate operation is not selected, the associated components are not added to the schedule's bill of material.

## Priming the production lines

After you release a schedule, you can begin production on the schedule. You need to get components to the production line and start the replenishment cycle.

The Prime Production Lines option on the Material Management menu (AMQM30) allows you to initially stock the line and start the replenishment cycle for one or more production schedules. You can select schedules for priming by warehouse, production line, item, or planner, or by schedule number. For example, if you are a production planner, you can review all of the schedules on a specific production line for which you are responsible and select the schedules you want to start.

Plan to prime a production schedule well before you actually begin the first operation. This allows time to pick the materials and stage them on the production line.

## Pick list

After the production schedule is primed, the next step is to generate a pick list.

The Print Pick List option on the Material Management menu (AMQM30) allows you to select which warehouse, location, and components should be analyzed for potential replenishment. It is important to know that the selection criteria (warehouse, finished item, component, schedule number, etc.) is used to select which warehouse, component, and delivery locations are to be analyzed. For example, selecting a specific schedule does not mean that this schedule will be the only schedule analyzed. In this scenario, if multiple schedules exist at the selected schedule's locations, all schedules at that location will be analyzed for potential replenishment.

The pick list reads the Component Status (CMPSTS) file, and based on selection criteria, analyzes each warehouse, component, and line location selected for processing. The analysis process will attempt to move all necessary components needed to complete the schedule. Component location controls in the Location/Component (CMPLOC) file can limit the movement quantities. If multiple schedules are competing for these limited quantities and the components are schedule-based, a distribution algorithm is used to provide the best possible application of the quantities for the competing schedules.

The distribution algorithm operates with the following priority and manner:

1. All manual reported quantity needs are satisfied.
2. All past and current required dates are satisfied. If the movement quantity cannot satisfy all of the past and current required dates, the algorithm will distribute based on remaining hours of supply.
3. All future required dates are satisfied. If the movement quantity cannot satisfy all of the future required dates, the algorithm will distribute based on remaining hours of supply.

**Note:** If the warehouse does not have sufficient components to meet the movement quantity, the pick list will satisfy each replenishment request on a first-come, first-served basis.

In generating the pick list, the system determines what components are needed and then searches for these components. The system looks for the oldest FIFO date and the lowest batch lot. The following is the order in which the availability for these components is determined:

1. Discrete allocations.
2. Line location for this component with last used FIFO date/batch lot.
3. Line location for this component for any FIFO date/batch lot.
4. In-transit pending replenishments for this component/delivery location with last used FIFO date/batch lot.
5. In-transit pending replenishments for this component/delivery location in any FIFO date/batch lot.
6. Default supply location with last used FIFO date/batch lot.
7. Default supply location for any FIFO date/batch lot.
8. Any stocking location for the last FIFO date/batch/lot transferred in FIFO date order, if you selected FIFO date integrity on the Inventory Management



questionnaire. If none, any stocking location for the last batch/lot in alphabetical order.

9. Any stocking location for any available inventory FIFO date transferred in FIFO date order, if you selected FIFO date integrity on the Inventory Management questionnaire. If none, any stocking location for any available inventory in alphabetical order.

As available components are found, they are allocated for use. The pick list prints information describing the movement of components from one location to another. The pick list does not print information describing the allocation of components when they do not need to be moved (because they are already at or in transit to, the line location).

### Pick list bar codes

Bar codes can be printed on the pick list—if you selected the interface to REP when you answered the PM&C install/tailor questionnaire, and activated the interface later. You must use an IPDS printer to print the pick list with bar codes.

Each bar code printed on the pick list represents a turnaround number, which identifies the replenishment being picked and transferred to the line. The bar code can be scanned using a wand for rapid input of the turnaround number, and the pick quantities entered through the data collection terminal's keyboard. The turnaround number is also numerically printed just above the bar code.

## Online update (interactive) vs batch update (offline and PM&C)

You can enter REP transactions into the system directly, or collect transactions and enter them as an entire transaction batch. Transactions entered directly (interactively) are posted immediately. After each transaction has passed the edits, your files are immediately updated and you can see the effects of the transactions in reports and inquiries. If you enter transactions as a batch, they can be posted as soon as the entire batch has been loaded onto the system, or the batch can be submitted to the job queue for later posting.

To enter transactions interactively, you can use either of two options on the Material Management menu (AMQM30):

- Enter Transactions
- Enter Transactions from Offline Files (using interactive updating).

From the Enter Transactions menu option, you can enter, change, correct, or reverse transactions in a batch; and you can suspend or close the batch of transactions. In the Enter Transactions from Offline Files menu option, you load transactions from a disk or diskette file and update your files immediately afterwards. The transaction batch has a suspended status when the updating has been completed.

To enter transactions in batch mode, you can use the Enter Transactions from Offline Files option on the Material Management menu (AMQM30), and submit the updating to a batch job queue for later processing. When the updating is completed, the transactions reside in a suspended transaction batch.

You can also use shop floor data collection terminals and the PM&C application to collect and post REP transactions. Your files are updated by the collected transactions. After transactions are posted, they reside in the PM&C application and

any necessary corrections must be made through that application. Refer to the *PM&C User's Guide* for a description of the processing and correction of REP transactions.

## Allocating components

### Supply location

After you enter and release a schedule, you may want to reserve or allocate the specific components that you want used on the schedule. You can allocate, ahead of time, components in specific locations and also the specific batch/lots. Use the Released Schedules option on the File Maintenance menu (AMQM50) to display the schedule. Select the components for which you want allocations. On the Component Change display (AMQ5B5), use **F10** to select the Discrete Allocation display (AMQ5B7), which shows you the locations with component stock. You can then choose the locations and quantities you want allocated to the schedule.

Later, when you run the pick list, the component stock locations are checked to see if any stock has been previously allocated. If allocations exist, the stock in these locations are used to supply the production line location. If the allocated quantities cannot satisfy the replenishment quantity, other locations are also used to supply the component.

Allocations at the supply location are reduced by the replenishment quantity that prints on the pick list, regardless of the quantity actually picked (or transferred), during the CL processing. If you allocate more material at supply locations than the quantity that the schedule still needs to be replenished, then these extra allocations are not removed until the schedule is purged or a last transaction is entered. In addition, these extra allocations will prevent other schedules from being replenished with the material.

**Note:** Discrete allocations cannot be used for location-based replenishment components.

### Line location

**CL transaction.** When a component transfer to the line (CL) transaction is entered, the allocated quantity for the schedule/component/line location is incremented by the transfer quantity. This is based on the following:

- If the quantity actually picked (or transferred) is equal to or less than the replenishment quantity, then the quantity is allocated to the schedule. If the quantity is less than the replenishment quantity, there is a chance that the in-transit pending replenishments will not be transferred. The in-transit quantity not transferred would be examined again during another pick list cycle.
- If the quantity actually picked (or transferred) is greater than the replenishment quantity, then the replenishment quantity is allocated to the schedule. The remaining quantity will be made available at the line location for other schedules.

An error message is issued if available inventory at the line does not exist and you attempt to reverse a CL transaction.

If you are in entry mode, reduce the transaction quantity. If you are in review mode, the available inventory is not sufficient to satisfy this transaction. In order to continue, you must transfer more material to the line location.

**Note:** Available inventory is the line location quantity minus the quantity required for all other schedules.

**CN transaction.** When a component return to stores (CN) transaction is entered, allocations for that schedule/component/line location are decremented by the amount of the return quantity.

An error message is issued if the available inventory at the line does not exist and you attempt to enter a CN transaction.

If you are in entry mode, reduce the transaction quantity. If you are in review mode, the available inventory is not sufficient to satisfy this transaction. In order to continue, you must transfer more material to the line location.

**SC transaction.** When a component scrap (SC) transaction is entered, the allocated quantity for the schedule/component is decremented by the scrapped quantity. The SC transaction allows you to enter the scrap quantity and select the line location and transferred replenishment. The scrap quantity cannot be greater than the replenishment quantity.

An error message is issued if one of the following conditions exists:

- Available inventory at the line does not exist and you attempt to enter a SC transaction.
- You are tailored for non-negative and the line location quantity minus all other schedule allocations are less than the transaction quantity.

If you are in entry mode, reduce the transaction quantity. If you are in review mode, the available inventory is not sufficient to satisfy this transaction. In order to continue, you must transfer more material to the line location.

**Last transaction.** When the production receipt (RM) transaction is entered with the last transaction equal to Yes, all allocations relating to the schedule are removed. Also, MODATA requirements are backed out of CMPSTS for this schedule. If you report a RM transaction after a last transaction, the IP transactions are generated for the components as follows:

- If the total required quantity for the component is available at the line, an IP transaction will be generated for the total required quantity.
- If the available at the line is less than what is required, an IP will be generated for the total available quantity at the line. An unapplied IP is generated for the difference between the required quantity and location quantity. If tailored for negative always, unapplied transactions will not occur.

If you reverse the last transaction, the allocations to be added back to the schedule (up to the available quantity at the line) are calculated as follows:

- Picked minus (backflushed plus returned), if picked is less than the replenishment quantity.
- Replenishment minus (backflushed plus returned), if picked is greater than the replenishment quantity.

**Reporting of production.** If a Production Receipt (RM), Scheduled Scrap (SM), or Operation Reporting (RO) transaction is entered, the required quantity of each component is subtracted from the allocations.

When the planned issue (IP) transaction for the component is generated, the allocated quantity in the SLQNTY record and the schedule for the SLALLO record is reduced for the line location.

When components are backflushed by an RM, RO, or SM transaction, the component quantity used is calculated, the replenishment record with the earliest time stamp is found, and the quantity used is updated. If the quantity used is equal to the replenishment quantity, the record status is changed to completed (status 40). If the component quantity used is greater than the remaining quantity in the replenishment, the next replenishment record is also updated. If another replenishment record is not found, the current replenishment record will be updated with the full amount. Replenishments are used in the order in which they are transferred to the line.

If more than the allocated quantity for a component is backflushed, only the amount allocated to that schedule will be subtracted from the allocated in the SLALLO record and SLQNTY record.

## Unattached jobs

The production RM, RO, and SM transactions backflush material and standard labor costs. Typically these types of transaction can require more time than expected due to the backflushing process. To improve your productivity and reduce the response time to a minimum, an unattached job (UJOB) is used to perform the processing.

Unattached jobs (UJOBS) are run in the batch subsystem and are connected to transaction entry through a data queue. When you enter a transaction that passes the edits, an entry is sent to the UJOB's data queue and a fresh display presented, allowing you to enter new transactions. The UJOB monitors the data queue and when a data queue record is found, the UJOB scans the transaction file for unposted transactions. All unposted transactions are processed while you continue to enter more transactions. There is a time delay before the effects of a backflush transaction can be seen on the REP inquiries and reports. The delay is dependent on the level of activity on the system and the system size. You can see which transactions are waiting to be posted by selecting **F09 DATA QUEUE STATUS** on the Transaction Batch Status display (AMQ34K).

## Replenishing the line

As finished items are built, components are used up (consumed) at the line locations. A signal occurs for the need for more components, either through manual or electronic KANBAN. When you print the pick list, it shows the components that are not available at the line, the components that need replenishing, and the locations that supply the production line. The components are picked and moved to the line locations, and Component Transfer transactions tell the system that the parts have reached the line locations. These elements make up the replenishment cycle. The line locations continue to be replenished until a sufficient number of components have been sent to the production line to manufacture the scheduled quantity of the finished item, and to cover any reported component and schedule scrap.

## Replenishment (RL) transactions

Replenishment transactions can be entered by schedule or by location:

You use the Replenishment by Schedule (RLS) transaction to report component usage at a line location for a selected schedule. You can select a specific schedule number or you need to know the following:

- Warehouse
- Production line
- Scheduled item number
- Schedule date
- S-number.

You use the Replenishment by Location (RLL) transaction to report component usage at a line location. To select the line location, you need to know the following:

- Warehouse
- Production line
- Line location
- Component item number
- Component user sequence number.

## Component Transfer to Line (CL) transactions

You use the Component Transfer to Line transaction to report component movement from the supply location to the line location. To report the components that have been transferred, you need to know the pick list number that is assigned to the replenishments.

## Schedule Receipt (RM) transactions

Schedule Receipt transactions are used to report finished items at the end of the production line. They account for the usage of components. These transactions:

- Calculate the required quantity of each component used to build the reported number of completed units.
- Issue that quantity to the production schedule.
- Lower the on-hand balances at the line locations.
- Deallocate the required quantity of each component from the schedule at the line location.

## Operation Reporting (RO) transactions

Operation Reporting transactions also account for the usage of components. However, they account for the usage only from the reporting operation back to the previous reporting point or the first operation.

## Component Scrap (SC) or Schedule Scrap (SM) Transactions

When components or a partially completed unit of the scheduled item are damaged, the loss is reported through Component Scrap (SC) or Schedule Scrap (SM) transactions. Component scrap transactions indirectly affect replenishments. When components are scrapped, containers are emptied quicker and replenishments are needed earlier. Unless component scrap is reported periodically, replenishments are

ended when enough components have been sent to the production line to cover the finished item's scheduled quantity. Through timely reporting of component scrap, you can avoid shutting down the production line due to a lack of a component.

Schedule scrap should not be confused with component scrap. Schedule scrap is a loss of units being produced, and component scrap is a loss of a component at an operation.

Schedule scrap can be planned for through the operation yield factor. Operation yield is defined as the ratio (expressed as a percentage) of the number of units expected to complete the operation compared to the number of units beginning the operation. If only 4 out of 5 units complete the operation, the operation yield is 80%.

Operation yield is used primarily by industries where loss occurs as a product moves through each stage or operation. Because units are expected to be lost at the operation, the quantity of components used at later operations is reduced. Should you experience higher than expected yield at an operation, you may not have sufficient components at later operations. You can use the Released Schedule maintenance option on the File Maintenance menu (AMQM50) to change the expected operation yield to the actual yield. The number of components used by later operations will be increased. If you experience significantly lower yield at an operation, you can also change the operation's yield and free up some of the components used at later operations.

## Replenishment cutoff

Production schedules specify the quantity of finished items to be produced. Based on the schedule quantity, the quantity needed of each component is calculated, and includes the anticipated scrap due to operation yield.

Only the number of units needed to meet the scheduled quantity should be started at the first operation. If 100 units are scheduled and the cumulative yield for all operations is 80%, then 125 units must be started ( $125 \times .8 = 100$ ). After the last unit is started, and proceeds down the assembly line, component replenishments are stopped at each succeeding operation. The replenishment cycle determines when the cutoff occurs by comparing quantity of components sent to the production line with the total quantity needed to produce the schedule quantity, plus any reported component or schedule scrap. When the quantity sent to the line equals the quantity needed, the component is no longer replenished and the operation can no longer be performed.

When the replenishment basis is schedule controlled, replenishment cutoff occurs. You can use the Work With Location/Component option on menu AMQM70 to display the components in locations that are replenished by schedule. Replenishment of these components is cut off when enough parts have been sent to the production line to make the desired quantity of the scheduled item. You also can use the Work with Location/Component option to choose whether to limit the run-out quantity to only the quantity needed to finish out the schedule or to send a last, standard quantity of the component to the line location at cutoff.

## Replenishment processing

The tracking of replenishments is carefully controlled. The major points you should know about replenishment are:

- Replenishments are created when a pick list is processed.
- Replenishments appearing on the pick list show the date they are needed.

- Each schedule-based replenishment is for a specific schedule, component, batch/lot, FIFO date, supply location, and line location.
- Each location-based replenishment is for a specific component, required date, batch/lot, FIFO date, supply location, and line location.
- Replenishments are used in the order in which they are transferred to the line location.
- When the replenishment quantity is completely used or returned, the replenishment is completed.
- Only replenishments that have been transferred to a line location and have not been completely used up can be returned to the supplying location.
- Batch/lots with an expired shelf life cannot be used, they must be sent to Quality Control (QC) for inspection. If the batch/lot is at a line location when its shelf life expires, it must be returned to a QC location.

The Replenishment file is used to control the movement of components between the supply and line locations. Each record tracks a specific replenishment.

If the flow time for a schedule is greater than a day (for example, it takes longer than a day to produce a unit of the finished item) a need date is calculated for each component replenishment and the replenishment is shown on the pick list when that date is reached.

When you print a pick list, open replenishments are generated, the supply location is determined, the replenishment record changed to a picked status and printed on the pick list. If the replenishment could not be satisfied from a single location, additional replenishment records are created for each supplying location. Each record identifies the part to be picked, the specific FIFO date and batch/lot, and the schedule it will be used on, the supplying location, and the line location where it will be delivered. Each replenishment appears on a single pick list, unless it is location-based.

**Replenishment status codes.** REP uses the following replenishment status codes to indicate each replenishment record's status:

- 20** Replenishment record has been printed on pick list.
- 30** Component has been moved to the line; CL transaction has been entered and material is used.
- 40** Completed replenishment; RM or RO transactions have been entered and all of the replenishment quantity has been used or returned.

## Component transfer to the line (CL) transaction

When the parts have been picked and moved to the line locations, a component transfer to line (CL) transaction time stamps the replenishment records and changes the status to transferred (status 30). Several transferred replenishment records for a component can be at a line location.

To enter the transfer transaction, select CL transaction and enter the pick list number. The component transfer transactions for the selected pick list are displayed. Each transaction shows the replenishment quantity being transferred from the supply location to the line location. If you followed the pick list and picked the number of parts shown, you can press **Enter** and the system processes all of the CL transactions on the pick list.

## Skipping CL transactions on the selected pick list

If you select a pick list to process component transfers and you do not want to process a CL transaction against a particular replenishment on the pick list, you can skip the replenishment by changing the containers and pieces quantity on these CL transactions to zero.

If replenishments on the pick list have not been picked and sent to the line location, you can change the container pieces quantity on these transactions to zero. These transactions are then ignored when the other CL transactions are processed and appear again with their previous replenishment quantity.

## Quantity picked less than replenishment quantity

If you do not want to send the full replenishment quantity, you can decrease the quantity picked and only send that amount to the line location. The quantity that was not picked will be examined during the next pick list.

## Quantity picked greater than replenishment quantity

If you pick more than the replenishment quantity (quantity that appeared on the pick list), the quantity sent to the line location is increased. The quantity sent to the line will be equal to amount you picked. However, only the replenishment quantity will be allocated to the schedule. The amount over picked will be available for use by other schedules. The on-hand quantity at the supply location is reduced by the extra amount picked.

For example, assume a CL transaction was entered for a quantity of 75. That overrides the picked quantity of 50, and the replenishment quantity of 50. The allocations for the supply location will be reduced by 50 and allocations for the line location will be 50. This condition occurred because the replenishment quantity is less than the picked quantity and therefore, the available quantity at the line will be 25.

## Cancel CL transaction

If a component appears on the pick list and you do not want it to be examined during the next pick list, enter 1 in the transaction's Cancel Replenishment Code (when doing the CL transaction). The amount entered for the CL transaction will be transferred, but no manual replenishment is created for the amount not transferred.

## Final transfer for a pick list

The pick list remains open until a CL transaction has been processed for each picked replenishment, or until you indicate that the final CL transaction for the pick list has been entered. If any picked replenishment records exist after the final transfer is indicated, new requirements are created for the unpicked quantity.

## Component Return to Stores (CN) transactions

When you print a Component Return List, replenishment records with a transferred status are selected, and printed. Replenishments that still appear on a pick list are not shown on the Component Return List. The quantity to be returned cannot be greater



than the difference between the picked or required (whichever is greater) and the quantity used. Each replenishment can appear on only one Component Return List.

The Component Return List remains open until a Component Return transaction is entered for each replenishment, or until you indicate that the final return has been entered. If any transferred replenishment records exist after final return is indicated, they are released from the Component Return List and can be selected on a new Component Return List. The quantity available for return can change between the time the Component Return List is printed and the time you enter a Component Return transaction, because of the change in the issued quantity. Schedule Receipt, Operation Reporting, and Schedule Scrap transactions can affect the quantity issued. You should enter the Component Return transactions as soon as possible after the Component Return List is printed.

Print a Component Return List, when you want to remove defective material from a line location and you want to replace it. By using the Return to Stores function, the pick list will recognize that replacement material is required at the line. The defective material should be moved to a line location that is not defined in the Location/Component (CMPLOC) file. This prevents the pick list from selecting the same material for the next pick list printed.

## Primary and secondary transactions

Some transactions are made up of a primary transaction and many secondary transactions. For example, when you enter a Schedule Receipt transaction, many secondary or Planned Issue transactions can be generated. The Schedule Receipt is the primary transaction and shows the quantity of the finished item that was received. Secondary Planned Issue transactions are generated to show the quantities of the components used to produce the finished items.

The following primary transactions can generate secondary transactions:

- Operation Reporting
- Schedule Receipt
- Schedule Scrap

## Reporting completed items

As finished items roll off the end of the production line, a Schedule Receipt transaction is entered to record the quantity completed. The components used to build the completed items are backflushed from the line locations, reducing the location's on-hand balance, and issuing the components to the schedule where the component's costs are added to the schedule's material cost.

Schedule Receipt transactions are entered through the Enter Transactions option on the Material Management menu (AMQM30).

When the last unit of the finished item comes off the line, you enter the last Schedule Receipt transaction and indicate that this is the last transaction for the schedule. The schedule status is set to completed. When a last transaction is reported against a schedule, all component allocations for that schedule are released.

## Reporting partially completed items

When an operation is designated as a reporting point, you must report the number of good units of the scheduled item produced at the operation. When you enter an Operation Reporting transaction, the material and standard labor costs used to build the units are calculated and charged to the schedule. The costs are calculated for the reporting operation and all prior operations, up to the preceding reporting point. If this operation is the first reporting point in the routing, costs are calculated from the reporting operation back to the first operation.

You can use a reporting point to monitor the number of parts produced through the operation. When it takes longer than a shift or a day to produce the item, reporting points can be set at intervals equivalent to a shift or a day. To enter an Operation Reporting transaction use the Enter Transactions option on Material Management menu (AMQM30).

## Reporting scrap

During the manufacturing process some components or partially completed units may be damaged and must be reported as scrapped. Defective materials may also have been withdrawn from stock. Three different transactions are used to record the scrap that occurs.

You use the Enter Transactions option on the Material Management menu (AMQM30) to enter Schedule Scrap transactions and report the scrapping of partially completed units of the scheduled item. You can select a specific schedule number, or you need to know the following:

- Warehouse
- Line
- Scheduled item
- Scheduled date
- S-number.
- Operation number.

The materials and standard labor used to build the scrapped units are calculated and charged to the schedule as scrap costs.

You use the Enter Transactions option on the Material Management menu (AMQM30) to enter Component Scrap transaction and report the scrapping of components that were damaged during the manufacturing process. To select the component, you should know the following:

- Warehouse
- Line location
- Component item number
- Component user sequence number
- Batch/lot
- FIFO date
- Schedule number.

The component cost is charged to the schedule as scrap.

You use the Enter IM Transactions option on the Material Management menu (AMQM30) to enter Scrap from Stock transaction and report defective components

that were delivered to the production line. To select the component, you should know the following:

- Warehouse
- Line location
- Component item number
- Batch/lot
- FIFO date.

The scrap cost is charged to the store room.

### **By-product scrap**

If a Schedule Receipt or Operation Reporting transaction generates by-product and then a schedule scrap transaction is entered, the by-product will not be scrapped.

A Component Scrap transaction must be used to scrap by-product.

## **Reporting line status**

You can report the status of a production line through the Production Status transaction. This transaction collects various types of information for your later analysis. For example, you can enter a Production Status transaction each time a production line is started or stopped. Using the Reference and Reason Code fields you can briefly describe the cause of the status change. The transaction can be saved in the Inventory Transaction History file, so you can later use System i Query (a decision support utility) to determine the number of times the line was stopped and the cause of each stoppage.

The Production Status transaction lets you enter information that you can use as an audit trail to track the status of a production line, or the performance of a crew or shift. The production line, shift, and crew are entered along with the quantity produced.

### **Production status transaction**

The Production Status transaction lets you identify:

- The warehouse, production line, time, and date
- The new line status (either line started, or line stopped)
- The cause of the status change through the Reference and Reason Code fields
- The shift and crew involved
- Any quantity that needs to be tracked.

The transaction allows you to use any field for any purpose you choose. Edits are provided, but only issue warning messages. Your transaction is always accepted. Production schedule information is not affected by the transaction. The transaction is printed on the Transaction Register, and you can use the printed report as a hard copy audit trail. If you selected Inventory Transaction History tracking when you answered the Inventory Management questionnaire, the Production Status transactions are also saved in the Inventory Transaction History file (IMHIST). The records in this history file can be archived and, later, restored back onto the system for analysis through System i Query.

## Entering transactions from offline files

Transactions are normally entered at a work station, but can also be entered from offline diskette or disk files. Use the Enter Transactions from Offline Files option on the Material Management menu (AMQM30) to enter offline transactions into the REP application. Refer to Appendix A in this manual for information about the offline file layouts and loading data from offline files.

There are two record types (A and B) in the diskette file, with the B record type being a continuation for the A record type. For each A record type, there must be a matching B record type. For example, both record types require the same values in the Sequence Number and Transaction Code fields, and the Active Record Code in each record type must be A for active. Together, the A and B records form a single transaction.

Disk files containing REP transactions can also be entered through the Enter Transactions from Offline Files option. The disk file must already exist on disk and contain the REP transactions. Disk files use only a single record type, and each record represents an individual transaction.

Not all fields are used by each REP transaction. Only the fields shown on the transaction entry display for the specific transaction type need to be entered.

The transaction codes shown in the following table are:

- CL - Component transfer to line
- CN - Component return to stores
- IP - Planned manufacturing issue
- PS - Production status
- RL - Replenishment
- RO - Operation reporting
- RM - Schedule receipt
- SC - Component scrap
- SM - Schedule scrap.

<b>Field Name</b>	<b>RL</b>	<b>CL</b>	<b>CN</b>	<b>RM</b>	<b>RO</b>	<b>SM</b>	<b>SC</b>	<b>PS</b>	<b>IP</b>
PLINE - Production line	R	-	-	R	R	R	R	R	R
FITEM - Schedule item number	R	-	-	R	R	R	R	-	R
SNMBR - S-number	R	-	-	R	R	R	R	-	R
ODUDT - Schedule due date	R	-	-	R	R	R	R	-	R
ORDNO - Schedule number	R	-	-	R	R	R	R	-	R
HOUSE - Warehouse	R	-	-	R	R	R	R	R	R
CITEM - Component	R	-	-	-	-	-	R	-	R
USRSQ - User sequence number	R	-	-	-	-	-	R	-	R
TRNDT - Transaction date	R	O	O	R	R	R	R	R	R
QCNTR - Transaction quantity (containers)	R	R	R	R	R	R	R	-	R
QPIEC - Transaction quantity (pieces)	R	R	R	R	R	R	R	R	R
SLOCN - Supply (stock) location	-	-	-	R	-	-	(1)	-	
LBNHO - Batch/Lot number	-	-	-	R	-	-	R	-	R
FDATE - FIFO date	-	-	-	R	-	-	R	-	R
DLOCN - Delivery (line) location	R	-	-	-	-	-	R	-	R
OPSEQ - Operation sequence number	-	-	-	-	R	R	-	-	
SHIFT - Shift	-	-	-	R	R	R	R	R	
LINCD - Line status	-	-	-	-	-	-	-	R	
CREWN - Crew	-	-	-	R	R	R	R	R	
PRORT - Priority code	R	-	-	-	-	-	-	-	
REWRK - Rework flag	-	-	-	R	-	-	-	-	
PLIST - Pick list number	-	R	-	-	-	-	-	-	R
RLIST - Return list number	-	-	R	-	-	-	-	-	
PNREF - Pick list reference number	-	R	-	-	-	-	-	-	R
RNREF - Return list reference number	-	-	R	-	-	-	-	-	
REASN - Reason code	R	O	O	R	R	R	R	R	
REFNO - Reference number	R	O	O	R	R	R	R	R	
TIMCD - Time code (duration or clock)	-	-	-	-	-	-	-	R	
CNLRP - Cancel replenishment code	-	0	-	-	-	-	-	-	
LSTTR - Last transaction reported	-	-	-	R	-	-	-	-	
RSPFA -Resupply code	-	-	O	-	-	-	-	-	
MSQNO - MODATA Low Level Sequence Number	R	-	-	-	-	-	-	-	R

Legend:

R=Required, O=Optional

(1)=If the line location is a JIT location (manually replenished location) enter the line location here.

Three severe errors can prevent a transaction from being accepted:

- Transaction code is not valid.
- Nonnumeric data is found in a numeric field.
- Record type is missing.

When you enter offline transactions, you can choose to accept all transactions without severe errors or to not accept any transactions if any severe errors are found. If you accept all transactions without severe errors, the transactions with severe errors are dropped and must be entered later on another diskette after they have been corrected.

If a transaction is accepted, it is edited and written to a REP transaction batch. If the transaction passes all of the edits, it is immediately posted. If the transaction does not pass all of the edits, it is flagged as an error transaction and saved in the transaction batch for later correction. A transaction that can cause a location on-hand balance to become negative may be flagged as an unapplied transaction (if you are tailored not to go negative). Both error and unapplied transactions can be later corrected through the Enter Transactions option on the Material Management menu (AMQM30).

## Entering transactions through PM&C

REP transactions can be collected from shop floor data collection terminals through the PM&C application. Bar coded turnaround documents are printed by REP and used to enter the transactions. The shop floor transactions are edited and posted by PM&C. Transactions not passing the edits are marked as error transactions and corrected through the Maintain Transactions option on the PM&C Transaction Processing menu (AMJM30). Posted transactions are printed on the PM&C Transaction Register, and can be written to the Inventory Transaction History file. The effects of the posted transactions can be seen through the REP inquiries and reports.

If post to oldest schedule is active and transactions are being reported via data collection, new transaction types (RX, RY, and SX) are used for the RM, RO, and SM transactions.

## Entering IM transactions

Transactions affecting production schedules are normally entered through the Enter Transactions option on the Material Management menu (AMQM30). When transactions affecting production schedules are entered through IM, certain restrictions apply.

Some IM transactions are for manufacturing or purchase orders and cannot be used with production schedules (for example, a schedule number cannot be entered as the order number):

<b>IU</b>	Unplanned component issue
<b>PC</b>	Pick complete by manufacturing order
<b>RD</b>	Purchase order receipt to dock
<b>RI</b>	Purchase order receipt to inspection
<b>RM</b>	Production receipt
<b>RP</b>	Purchase order receipt to stock
<b>RS</b>	Component return to stock
<b>SC</b>	Manufacturing component scrap
<b>SM</b>	Manufacturing order scrap
<b>SP</b>	Purchase order scrap

Some Inventory Management transactions can only be entered through the Inventory Management application:

<b>CA</b>	Cost adjustment
<b>CR</b>	Average cost replacement
<b>CS</b>	Standard cost replacement
<b>IP</b>	Planned manufacturing issue

Issue, receipt, and transfer transactions entered through IM can affect the replenishment and backflush cycles in the REP application.

Because replenishment processing is carefully controlled, only REP transactions should be used to move materials to and from the production line. Using IM transactions to move materials can cause difficulties in replenishment processing. You should only use these IM transactions.

- To move material to JIT line locations, use one of the following:
  - Purchase Receipt
  - Interwarehouse Transfer
  - Miscellaneous Receipt.
- To move material out of a JIT line location, use a Interwarehouse Transfer.
- To issue uncontrolled floor stock materials to the shop floor, use a Miscellaneous Issue.
- To remove defective materials from any line location, use Scrap from Stock.

All Inventory Management issue or transfer transactions from a line location, or adjustment transactions to a line location, are flagged by a warning message at the time the transaction is entered.

Receipts and transfers to line locations cause a buildup of stock that is not allocated to a specific schedule or group of schedules. The next time stock is needed, this available stock is allocated to the schedules. Because the stock is already at the stock location, it is not shown on the pick list.

All Inventory Management receipt or transfer transactions to a line location are flagged by a warning message at the time the transaction is entered.

## Correcting transactions

When transactions are entered, they are edited for completeness. If they pass the initial error edits, they are sent to an unattached job (UJOB) for posting. If they fail the edit, they are placed in the batch file with a status code of U, to be corrected. When the transaction is processed in UJOB, any secondary transactions generated and found in error are designated as unapplied, with a status code of U. Transactions marked with U must be corrected before the batch can be closed and a transaction register printed. Once the source of the error is corrected, the transaction can be retrieved from the batch and re-edited.

Transactions entered successfully through online entry, offline files, or PM&C are posted immediately after they are received. Use the Review Summary display (AMQ34J) from the Enter Transactions option on the Material Management menu (AMQM30) to see the error and unapplied transactions in a transaction batch. Use **F08 SHOW ALL/EXCEPTIONS**, which changes the display and shows you only the error and unapplied transactions. In this way, you can see all of the unposted transactions that need your attention.

To produce a hard copy of the unapplied transactions, you can print the Released Schedules report from the Reports menu (AMQM20). An option of this report allows you to print only those transactions that are unapplied or are in error.

## Sources of transaction errors

The primary cause of errors is most likely due to not processing transactions on a timely basis. To reduce the potential for errors, you need to place good operating procedures in the following areas:

1. Build to a schedule. Everything that is built must be done under the authorization of a schedule; that is, a schedule entered through the Enter and Maintain Schedules option on the Schedule Management menu (AMQM40).
2. Prime the line. Priming sets up records for material to be printed on a pick list. Priming can occur at the time of schedule release or at some later point.
3. Run the pick list on a timely basis. The pick list allocates material at the line, or material that is in process of being picked (see pipeline allocations), or from supply locations.
4. Transfer material to a line location on a timely basis. Material must exist at the line if a schedule is to be built, especially if you do not allow inventory balances to go negative. Allow schedules to borrow from each other if it doesn't matter which schedule gets a particular set of parts. Location based replenishment is generally a looser method of issuing and backflushing parts. Location based components pool their stock and will borrow components from each other.
5. Process Component Return Lists quickly. Do not create a Component Return List and leave it unprocessed for any period of time. Other transactions can change the stock quantities in the line location, which may cause errors when the return list finally is processed.
6. Report material receipts on a timely basis.
7. Batch lots. A component with a negative quantity required is a by-product. When the by-product is batch/lot controlled, the (negative) IP transaction generated during the backflush function does not have a batch/lot identifier. The planned issue can be treated as an unapplied transaction with a blank batch/lot ID; or posted to the line location, using the default batch/lot ID. A processing option in the REP Control file determines which action is taken. If the planned issue is posted with the default batch/lot ID, the by-product must be assigned a correct batch/lot ID, using Location maintenance. If the planned issue is unapplied, entering a batch/lot ID allows the transaction to be corrected and posted.

**Reversing transactions** . Posted transactions reside in a transaction batch until the batch is closed and the Transaction Register run. To correct a posted transaction that has not been printed, you must reverse the transaction to remove its effects on the item's and location's information. Then you must enter a new transaction with the correct transaction information.

When you reverse a primary transaction, all secondary transactions are reversed. If a secondary transaction is in error or is unapplied, the transaction is shown as reversed.

Use the Enter Transactions option on the Material Management menu (AMQM30) to review the transactions that have been entered. Select the transaction you want to reverse and enter an **R** into the **REV** (Reversal Code) field. The transaction is now reversed. Use **F19 RETURN TO SELECT** to select the same transaction type, and enter a new transaction with the correct information. Reversed transactions are



considered “deleted” transactions and are printed when the Transaction Register is run for the transaction batch.

You cannot reverse a transaction in these situations:

1. When a replenishment request transaction has been entered and appears on a pick list. The parts may already have been picked and may be on their way to the line location. When the picked replenishment is shown on the Component Transfer to Line display, the quantity transferred should be set to zero.
2. When a component return transaction has been entered and the quantity returned is less than the quantity at the location. The location still contains stock and another Component Return List is run, showing the location again. The original component return transaction cannot be reversed. Instead, when the component returns on the second Component Return List are shown, a negative quantity should be entered.
3. A Production Status transaction reports when a production line is down, and when it is back up again. Use another Production Status transaction to show that the line status has changed.

## Negative transactions

When the Transaction Register is run, the transactions in closed batches are printed and the transactions removed from the system. These transactions cannot be reversed. But, you can correct the item and location information by entering two transactions into another batch. The first transaction is entered with the same information as the original transaction, except the quantity is reversed. If the original quantity is 100 units, the new transaction is entered with a quantity of -100 (minus 100 units). This transaction reverses the effects of the previously posted transaction. The second transaction is entered with the correct information. Both transactions are printed when the Transaction Register is run for the transaction batch.

Negative transactions can be used for all transaction types except:

- Component transfers
- Component returns
- Production status.

**Note:** In many products, different batch/lots of a component are not mixed in the same production run. When different batch/lots (or components with different FIFO dates) are used in the same production run, a receipt transaction will report the use of component batch/lots and/or FIFO dates correctly. If the receipt transaction is later reversed, the component batch/lots and FIFO dates are back out correctly. However, when a receipt transaction with a negative quantity is used to offset (back out) a previous receipt transaction, the negative receipt is not tied to the original receipt. The same component batch/lots and FIFO dates might not be selected, which may result in inaccurate component counts at the line locations.

Component transfers and returns move materials to and from the production line. They can be used as complementary transactions. Material that has been moved to the line using a Component Transfer transaction can be moved back to the storeroom using a Component Return transaction. The Component Return allows you to specify the components and quantities to be returned.

The Component Return transaction can be used to move excess material back to the storeroom. If, later, additional material is needed at the production line, the Component Transfer transaction can be used to move the material to the line. You

should not enter a Component Transfer or Component Return transaction with negative quantities, instead you should use the complementary transaction.

## Transaction Register

The REP Transaction Register is a written record of the transactions that have been entered. It serves as an audit trail by showing the movement of material and the changes to material costs.

The Transaction Register is printed in three sections, showing the error, deleted, and posted transactions. Error transactions are those that could not be posted due to an error. The transactions are printed along with a message identifying the error. Deleted transactions are those which have been entered and later reversed or deleted. Posted transactions have updated the IM and REP files. Every transaction that was entered is printed, including replenishment transactions. The last page of the Transaction Register shows the count of each transaction type that was in error, was reversed, or was posted.

Planned issue transactions with a batch/lot ID of ##### and FIFO date equal to the transaction date can be created during backflushing when the batch/lot controlled component has a zero or negative inventory balance at the line location. You can correct the batch/lot ID and FIFO date, using Location maintenance, or by entering miscellaneous issue and receipt transactions to remove the inventory with the default batch/lot ID and replace it with stock that has the desired batch/lot ID and FIFO date.

### Transaction history

As transactions are printed on the REP Transaction Register, they can also be saved in the Inventory Transaction History (IMHIST) file. If you chose to save inventory transactions during IM install/tailor, the REP transactions are also saved.

All transaction types are saved that show:

- Material movement
- Costs changes
- Production line status changes.

Planned Issue transactions with a batch/lot ID of ##### can be created during backflushing when the batch/lot controlled component has a negative inventory balance at the line location. You can use the transaction history inquiry to locate these transactions and enter miscellaneous issue and receipt transactions to correct them.

**Replenishments not written to IMHIST** . Replenishment transactions are not saved. They signal the need for material, but do not cause material to be moved.

### Transaction history inquiries

A number of Transaction History inquiries are available through the REP Inquiry menu (AMQM10) and the IM Transaction History menu (AMIM80). You can choose to review inventory transactions by:

- **Item**. All transactions for the item are shown. The transactions show when the item was received and issued, and when its cost has been adjusted. The item may have been purchased or manufactured, issued as a component, inspected, or scrapped.

- **Item and batch/lot.** All transactions for the item and batch/lot are shown. The transactions show when the batch/lot of the item was received and issued. The item's batch/lot may have been purchased or manufactured, issued as a component, inspected, or scrapped.
- **Order or schedule number.** All transactions for the purchase order, manufacturing order, or production schedule are shown. For a purchase order, the transactions show when items were received and inspected. The quantities received, rejected, and scrapped are also shown. For a manufacturing order or production schedule, the transactions show when components were issued and the finished item received. The scrapping of finished items or components is also shown.
- **Production line.** All transactions for the production line are shown. The transactions show when components were transferred or issued, and when finished items were received. The quantities completed at operation reporting points are shown, and the scrapping of finished items or components.

You can also choose a range of transaction, or posting, dates; to narrow the number of transactions shown.

From the transaction summary displays, you can select individual transactions and show the transaction's detailed information.

Production Status transactions are saved in the Inventory Transaction History file to allow you to see when the status (up or down) of a production line was changed. These transactions are not shown through the Transaction History inquiry displays. You can use System i Query to show or print these transactions.

For further information on Transaction History inquiries, see the *Inventory Management User's Guide*.

## Transaction history reports

You can print several Inventory Transaction History reports through the IM Transaction History menu (AMIM80). You can print the following reports:

- **Transaction History.** The Transaction History report shows you the inventory transactions you selected. Your selection can be general or specific. Optional report limits allow you to select a range of the following:
  - Warehouses
  - Item numbers
  - Transaction or posting dates
  - Order or schedule numbers
  - Transaction types.

The quantity and cost for each transaction is shown, along with the resulting change to the on-hand balance. The stock location and batch/lot affected are also shown.

- **Transaction Analysis.** The Transaction Analysis report shows you in summary and detail form the cost changes caused by each transaction. Receipt, issue, and cost adjustment transactions are shown on the summary report. All transactions are shown on the detail report.
- **Batch/Lot Review.** The Batch/Lot Review report is similar to the Transaction History report. In addition to the optional report limits from the Transaction History report, you can also select by batch/lot and reason code. Additional information

related to batches or lots is shown. The transaction effect on the item's on-hand balance is not shown.

For further information on Transaction History reports, see the *Inventory Management User's Guide*.

## Transaction history save and purge

Inventory Transaction History records tend to accumulate rapidly. When the volume of records is too high, you can purge some of the transaction history records. You select, by date and warehouse, the records you want to purge; and, you can print the transactions before they are purged.

You can also save the purged records to tape. An Archive control record is created each time you save a set of transaction history records.

For further information on Transaction History Save and Purge, see the *Inventory Management User's Guide*.

## Restoring saved history

If you want to see the saved transactions again, they can be restored onto the system again. Archive control records are shown, and allow you to select the set of saved records you want to restore. The saved transactions are restored from tape onto the system, and can be merged with the current history transactions to appear on the Transaction History inquiries and reports.

For further information on restoring Transaction History, see the *Inventory Management User's Guide*.

## Deleting history archives

When a set of transaction history records that were saved to tape are no longer needed, their Archive Control record can be deleted. After the archive record is deleted, the set of transaction history records associated with the archive record cannot be restored onto the system.

For further information on deleting Transaction History Archive Records, see the *Inventory Management User's Guide*.

## Manufacturing history files

You can choose, through the IM and REP install/tailor questionnaire, to retain schedule information after schedules are purged. Schedule history files are used to save the records from the purged schedules. The information is saved in the following files:

- MOHDMD (Manufacturing Order History Demand) - used to save purged demand records from the DMDREF file.
- MOHDTA (Manufacturing Order History Materials) - used to save purged schedule component records from the MODATA file.
- MOHMST (Manufacturing Order History Master) - used to save purged schedule master records from the MOMAST file.

- MOHRTG (Manufacturing Order History Operations) - used to save purged schedule routing records from the MOROUT file.

During the purge of schedules, the associated records are added to the history files. The information in these files is strictly for the queries and reports you provide. Use and maintenance of these files is your responsibility. You should view and copy this history file using the IM Manufacturing Order History (AMIMA0) menu. You should periodically copy to tape and purge records in these files to reduce the disk storage used.

## Line teardown

### Reducing parts at the production line and line teardown

When a schedule is completed, you may want to move some of the component stock at the line back to the store room. Or, you may find that you have too many components at the production line while a schedule is running.

You can print an Excess Stock Report to identify the parts that are on the production line. You can select the components to be printed by entering a range of warehouses, production lines, line locations, and finished items; and be as general or specific as you want. For example, you can select a range of line locations used to build a specific item on a certain production line in a selected warehouse. Or, you can choose to print the components in all locations on all production lines.

## Late reporting

Transactions are normally entered until the schedule is completed. On the last production receipt transaction, you can indicate that the transaction is the last one to be entered. At this point, the production schedule is considered complete. Component stock at the line is released for another schedule. A completed schedule will not prevent you from entering late transactions. You can continue to enter transactions against schedules even after you entered a production receipt with the “last transaction” status. You can also enter transactions against schedules for prior days. Any transactions you enter are considered “late reporting.”

If you entered a “last transaction” and also enter later production receipt transactions, the available component stock at the line locations will be reduced. That is, any component stock not reserved for a schedule running on the production line will be reduced by the late production receipt transaction.

If you did not enter a “last transaction,” the component stock (replenished by schedule) is still allocated to the schedule and cannot be used by other production schedules. Purging the schedule will release the reserved stock.

## Maintaining released schedules

You can maintain the schedules you have released through the Released Schedules option on the REP File Maintenance menu (AMQM50). The following functions are provided:

- Production schedule information can be changed.
- An operation, and its associated components can be activated or deactivated.
- Operations can be added or deleted, and operation information changed.

- Operation descriptions can be added, changed, or deleted.
- Components can be added or deleted, and component information changed.
- Components can be allocated at the supply location for use on the production schedule. Or component allocations can be changed or removed.
- A component can be substituted for another component.

On the Select display (AMQ5B1) you choose the schedule you want to maintain. Enter the warehouse, finished item number, production line, schedule date, and S-number (if required for the finished item). If you are unsure of the item number, production line, or S-number, you can use the search facility to identify the missing information. If you know the schedule number, you can enter it instead of the other identifying information. Otherwise, a list of schedules appears so you can select a schedule. The Schedule Structure display appears next.

The Schedule Structure display (AMQ5B2) shows you the operations and components used by the production schedule. They are shown in operation and component sequence. You can visualize the production line and the flow of components through the order of the operations and the components used by each operation. From this display you can choose the activities you want to perform:

- Change schedule information
- Select the existing operations and components you want to change or delete
- Add an operation
- Add a component
- Substitute a component.

If the schedule has many operations and components, you can use the Position To window to locate a schedule record rapidly.

To choose existing operations or components, enter **1** in the **SEL** (select) column. Each operation and component will be shown to you in the order they appear on the Structure display. In this way, you can choose multiple records to maintain in one pass. Should you decide to select other records while you are maintaining a record you previously chose, use **F19 RETURN TO SELECT** to come back to the Structure display and change your selections. The records you have chosen, and have not yet maintained, appear again on the Structure display with **1** in the **SEL** column.

Both active and inactive operations and components are shown on the Structure display. Inactive operations or components are not used in the manufacturing process. Components usually have the same status as the operation where they are used, but an active operation can have inactive components. If you change an active operation to inactive status, all components used in the operation are changed to inactive status. When an operation is changed to active, all associated components are also made active.

## Changing production schedule information

Costs and identifying information can be changed on the Schedule Summary display (AMQ5B3). The schedule cost totals for setup, labor, issue, unit, overhead, and scrap can be changed; along with the receipt cost for this period and the receipt cost for this schedule. The information identifying the responsible planner, department, customer job number, reference number, and engineering drawing number can be changed. If you want to change the information that controls the order in which the schedule is run and the duration of the schedule, you can use the Enter and Maintain Schedules

option or the Sequence Schedules option on the Schedule Management menu (AMQM40).

## Changing operation information or deleting operations

After you select an operation on the Schedule Structure Select display, the operation appears on the Operation Change display (AMQ5B10). You can change the standard hours and rates, operation status, processing information, and identifying information. You can also delete the operation.

The standard hours and cost rates for setup, run labor, and run machine can be changed. You can also change identifying information such as the operation description, work station or work center, rework status, department, process sheet, tool number, reporting point, accounting class, time basis code, and operation run quantity.

You can change the operation status to inactive or active, and all of the components used in the operation will be changed to the same status. If you change the operation yield, the number of components needed by this operation and all following operations are recalculated. When the status or yield of an operation is changed, the number of run hours is changed for that operation and all following operations are affected. The schedule's cumulative yield and all operation start dates are recalculated. As a result, the required quantity for each component is changed as well as the initial date at which it is needed.

When an operation is inactive and then activated, you must go to transaction entry and enter RL transactions to start the Replenishment process. This is not necessary for components that are set up for auto-replenishment or electronic KANBAN.

An operation selected on the Schedule Structure display appears in change mode when it is shown. You can use **F20 DELETE OPERATION** to delete the operation. You must use the function key twice before the operation is deleted. Operations that have recorded costs are not deleted; the operation and its components are changed to an inactive status.

On the Operations Change display, you can use **F22** to maintain the operation description records.

## Adding operations

New operations are added to the schedule's routing by using **F06 ADD OPERATIONS** on the Schedule Structure Select display, causing the Operations Add display (AMQ5B9) to appear. An existing operation can be copied and used as a starting point, or you can enter all of the operation information. To copy from an existing operation, specify the item number and operation sequence number of the operation and use **F23 COPY OPERATION**. The Operations Add display appears again with the copied information.

When an operation is added, deleted, or changed, the schedule's cumulative yield and total duration can be affected. As a result, the yield through each operation, the operation start dates, the required quantity and initial need date for each component may be recalculated.

On the Operations Add display, you can use **F22** to enter operation description records.

## Adding, changing, or deleting operation descriptions

The Additional Operation Description display (AMQ5B11) shows you the additional description records for the operation. These records allow you to describe in fuller detail the steps to be performed and any other relevant information. You can include information on setup and maintenance procedures, tooling, tolerances, inspection and testing criteria and methods, or required operator skills.

You can change any line by typing over the information that is shown. At the bottom of the display, you can enter a sequence number and 1 or 2 to add or delete a specific operation description record. When you initially enter operation description records, you should not assign consecutive sequence numbers. Leave sufficient room between sequence numbers so you can add additional records in the future.

## Changing component information, or deleting components

After you select a component on the Schedule Structure Select display, it appears on the Component Change display (AMQ5B5). You can change information that affects the component date of initial need and the quantity required, or descriptive information such as the component description and the customer job number.

Changing the operation where the component is used also changes the initial date that the component is needed. The new component required date is equal to the new operation start date. You can also change the date on which the component is needed.

When you change the quantity used per completed unit (Quantity Per), the required component quantity is recalculated. The following formulas are used:

- Quantity Needed = Schedule Quantity x Quantity Per
- Planned Scrap % = 100 % - Operation Yield %
- Quantity Planned Scrap = Quantity Needed x Planned Scrap %
- Quantity Required = Quantity Needed + Quantity Planned Scrap.

You can see that the Quantity Required is the sum of the component quantity needed to produce good units, and the component quantity used in units anticipated to be scrapped at the operation.

The Quantity Required is also affected by changes in the status and yield of previous operations, and the yield of the operation where the component is used. When previous operations are added or deleted, changed to an active or inactive status, or change their operation yield, the cumulative yield for the routing is changed, along with the completion yield at each operation following the changed operation. These changes require the cumulative routing yield, and cumulative yield through each operation to be recalculated. The formulas that follow are modified to take into account changes to cumulative yield caused by changes to previous operations.

$$\text{Adjusted Quantity Per} = \text{Quantity Per} \times \text{Cum Yield for Prev Oper} / \text{Cum Yield for All Operations}$$

$$\text{Quantity Required} = \text{Schedule Quantity} \times \text{Adjusted Quantity Per}$$

A component selected on the Schedule Structure Select display appears in change mode when it is shown. You can use **F20 DELETE COMPONENT** to delete the component. You must use the function key twice before the component is deleted. Components that have recorded costs or issues are not deleted; the component is changed to an inactive status.



On the Component Change display, you can use **F10 ALLOCATIONS** to maintain the supply location allocations for the component. (This is not allowed for location-based replenishments.)

## Adding components

New components are added to the schedule's bill of material by using the **F05 ADD COMPONENT** function key on the Schedule Structure display. The Component Add display (AMQ5B4) appears and lets you enter the new component information.

If the component is already used in the schedule's bill of material a unique user sequence number must be entered. The user sequence number allows the system to select individual component records, even when the component is used multiple times in the bill of material.

The Quantity Per is used to calculate the component's quantity required, taking into account the yield at the operation where the component is used, the cumulative yield through the previous operation, and the cumulative routing yield.

On the Component Add display, you can use **F10 ALLOCATIONS** to add supply location allocations for the new component.

## Substituting components

If the substitution is a permanent change, update the bill of material prior to component substitution in Released Schedule Maintenance.

A cut-off quantity identifies how many units of the scheduled item are produced using the old component. After the cut-off quantity is completed, the new component is used. Both components appear in the schedule structure. The old component appears as still active, and the new component shows as not active.

If a zero cut-off quantity is used, a warning message is issued. If bypassed, the new component immediately appears as active, and the old component appears as inactive.

## Changing or deleting component allocations

Component allocations are used to reserve stock at a supply location for use by a schedule. The stock is allocated to a specific component (and user sequence) of the schedule. Each component can have a separate allocation of stock. And, when a component appears in the schedule's bill of material more than once, a unique supply can be set up for each usage of the component. Each component may require a different batch/lot of the component.

## Purge completed schedules

Schedule purge is used to remove information for schedules that are past due (that is, a schedule with a due date earlier than the current date). The schedules may have been completed, may be part of a campaign that is wholly or partially complete, or may have been entered but never run.

Schedules should be purged on a periodic basis. The frequency that schedules are purged should be based on a number of factors:

- The number of schedules run each day and the number of records associated with each schedule versus the disk capacity you want to use to store schedules.
- The length of time before the last transaction for a schedule is entered (how late is the last transaction).
- Whether you chose to reuse data entry batches.

If you did not choose during install/tailor to reuse data entry batches (REUSE = NO) after they have been posted, the batches remain in a Finished status until you perform a backup. Should you need to recover files, these finished batches allow you to post the transactions you entered since the last backup without having to enter the transactions again. The backup process also saves a file (RPLMNT) that is needed to start the reprocessing of the finished transactions after you perform a recovery. Schedule purge removes records from this file and can prevent you from reposting the transactions for the purged schedules. If you chose to not reuse data entry batches, you should always purge schedules immediately after you have performed the backup.

Before selecting schedule purge, you should ensure that all transactions (for the schedules to be purged) have been processed, and that all master files have been updated properly. You should do this before performing any necessary backup.

You can use the Purge Schedules menu option to purge all schedules older than a given date, or to select the specific schedules to be purged. If you choose to allow campaign schedules to be partially purged, the individual schedules of the campaign with a due date equal or prior to the purge date entered can be purged.

Planned schedules and released schedules without reported activity can also be purged through the Schedule Entry and Maintenance menu option. Changing the schedule quantity to zero causes these schedules to be deleted. The purged records are not saved to the Manufacturing Order History files.

## Purging by date

When you purge schedules by date, the date last used to purge schedules is shown and you enter a new purge date.

You can also enter a specific warehouse or include all warehouses in your purge. To purge schedules by date for another warehouse, you must complete the processing cycle before entering a new warehouse ID.

All schedules for the warehouse specified with due date equal to or earlier than the purge date are removed. Schedules do not have to be in a completed status. Entire campaign schedules are purged if the last day of the campaign is equal or prior to the purge date. Partial purging of a campaign schedule is allowed; individual days of a campaign are purged if they have a due date equal or prior to the purge date.

## Purge by schedule

If you choose to select schedules individually for purge, schedules can be chosen by entering the warehouse, production line, item, schedule due date (from/to), and S-number. All schedules matching the selection criteria entered are shown. If the last day of a campaign meets the selection criteria, only the last day of the campaign is shown. If the campaign is selected for purge, then all schedules in the campaign are purged. Individual days of a campaign are shown if their due date is equal or prior to the purge date, and partial purging of campaign schedules has been selected.

On displays AMQ4A3 and AMQ4A4, you can specify a range of schedules to purge by entering in the starting due date and ending due date in the **SCHED DATE FROM and TO** fields. You must type in at least one date. A message will be displayed if both the **FROM and TO** fields are blank. If you select a future schedule on display AMQ4A4 that has costs associated with it, you will receive a warning message. You can ignore the message and continue, or you can decide to remove your selection for this schedule.

You can enter **1** in the **SEL** (select) field next to the schedule you want to select for purging, or you can leave the **SEL** field blank to not select the schedule for purge. The status of each schedule and campaign is checked, and if the schedule or campaign has not been completed, a warning message is issued. You can press **Enter** to select the schedule for purge, or blank the **SEL** field to not select the schedule for purge.

Schedule purge removes schedule related records from the following files:

- Component Status (CMPSTS)
- Demand Reference (DMDREF)
- Schedule Materials (MODATA)
- Schedule Operations (MOROUT)
- Schedule Replenishments (RPLMNT)
- Schedule Hours (SCHHRS)
- Location Allocations (SLALLO)
- Location Quantity (SLQNTY)
- Pending Available Allocations (PAALLO)
- Pending Available Quantity (PAQNTY)

Replenishment records are used to control the transfer of components to the production line, and their possible return to the supplying location. The status of a replenishment identifies the activities that have taken place. Some replenishments may not have been completed when their schedule is purged. If the replenishment is for a schedule that is being completely purged, the replenishment record is deleted. Any allocations against the supplying location are removed, and any material remaining at the production line location is freed to be used by other production schedules.

If a campaign schedule is being partially purged, the following processing (based on the replenishment status) takes place.

- Picked replenishment (status 20): The replenishment has been printed on a pick list. The component parts are being picked and moved to the line location.
  - A picked replenishment record is left unchanged. When the material is moved to the line location and a CL transaction is entered, the material is available for use by all schedules.
- Cancelled replenishment: The replenishment was printed on a pick list and a Component Transfer transaction entered with a zero quantity and marked to be cancelled. The cancelled replenishments are deleted.

A schedule cannot be purged if one of the following conditions exists:

- One of the schedule's components appears on a pick list. You must enter a Component Transfer to Line (CL) transaction to receive the component at the line location or enter a CL transaction with a zero quantity to cancel the replenishment.
- The schedule has transactions which are in error in PM&C. The transactions must be corrected through PM&C first.

- There are RM, RO, or SM transactions that have not been processed by the UJOB. The UJOB must be made active to allow the transactions to be processed.
- The schedule has unapplied IP transactions that must be resolved first.

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## Other REP activities

### Supporting manufacturing orders for scheduled-controlled items

Planned orders for schedule-controlled items can be changed to firm planned manufacturing orders and approved for release through MRP Order Release/Review. They are handled by IM, CRP, and PC&C in the same way as any manufacturing order. A manufacturing order may also be entered directly through IM for a schedule-controlled item. A warning or error message is issued when:

- A planned order is approved for (IM) order release in MRP
- A firm planned order is entered through MRP for (IM) order release
- A manufacturing order is entered through IM for a schedule-controlled item. The message states that the item is a schedule-controlled item, but the release is allowed.

When the manufacturing or planned order for the schedule-controlled item is released, the needed job shop routing may be different from the REP routing. You can modify the retrieved REP routing through Open Operation Maintenance. Although not probable, if the job shop bill of material differs from the REP bill of material, the retrieved REP bill of material can be modified through Material Detail File Maintenance.

If the auto-release function of MRP is used, scheduled controlled items are bypassed (not released) by this function.

Any planned order in MRP for a schedule-controlled item that has been approved for release as a manufacturing or purchase order is ignored by REP when it extracts demand from MRP. REP demand extract also ignores any customer order line item demand if it has been released as a manufacturing order. The manufacturing order number is placed in the line item record when the order is released. The Customer Orders Inquiry display (AMBO32) shows the manufacturing order number and provides the ability to track the status of the customer order

- **MRP** allows release of a manufacturing order only after the order has been manually approved for release. Issues an informational message at the time of approval that the release is for a scheduled controlled item. You need to modify the retrieved routing by using Open Operation Maintenance in PC&C. You can use alternate routings to release the routing correctly the first time.
- **IM** allows release of manufacturing orders for scheduled controlled items after issuing an informational message that the item is schedule-controlled. The message is issued for manufacturing order entry and order entry per customer order. Routings are changed as needed in open operation maintenance in PC&C.
- **CRP** ignores planned orders and released schedules for schedule-controlled items. It includes manufacturing orders for scheduled controlled items.
- **PC&C** schedules are omitted from the work list generation while open manufacturing orders are included.
- **REP**:

- Planned orders tagged for release as manufacturing orders in MRP are ignored.
- Demand extract ignores any customer line item with a manufacturing order number. These customer orders are flagged when you take the IM option to create manufacturing orders per customer order. The manufacturing order number is placed in the customer line item record. When performing the extract, only scheduled controlled items are read, and so any customer line item that has a manufacturing order is omitted.
- No easy way exists to flag a customer line item record if the line item is covered by a manufacturing order that includes other line item demand. In this situation, you must update the customer line item through a user-written program.
- **COM** Customer Orders Inquiry display (AMB032) shows the manufacturing order number so you can track the status of a customer order number.

## Schedule costing

The following definitions apply to schedule costing:

- **Average actual material cost per unit:** The sum of actual material costs to date divided by the total quantity complete to date for this operation.
- **Average standard labor, machine, and overhead cost per unit:** The sum of setup labor cost, run labor cost, machine cost, and overhead cost divided by the total quantity complete to date for this operation.
- **Total cost per unit for this operation:** The average actual material cost per unit plus the average standard labor cost, machine cost, and overhead cost per unit.
- **Total cumulative cost per unit through this operation:** The sum of total cost per unit for each operation through the current operation.
- **Schedule cost:** The cumulative sum of material, labor, machine, and overhead costs for all operations.

Run hours are stored in the routing record for each operation and need to be converted based on the Time Basis Code stored in the Routing record.

The Time Basis Code (TBC) values in the Routing record are:

<b>blank</b>	Hours per unit
<b>1</b>	Hours per 10 units
<b>2</b>	Hours per 100 units
<b>3</b>	Hours per 1000 units
<b>4</b>	Hours per 10000 units
<b>P</b>	Pieces per hour
<b>H</b>	Hours per lot size
<b>M</b>	Minutes per piece
<b>C</b>	Cost per piece (outside operations)

The determination of run and machine hours for each operation use the following definitions and calculations:

<b>RUNLB</b>	Run labor hours in routing
<b>RUNMC</b>	Run machine hours in routing
<b>RLHRS</b>	Run labor hours (calculated)
<b>RMHRS</b>	Run machine Hours (calculated)
<b>LOTSZ</b>	Standard lot size

**ORQTY** Order quantity.

<b>TBC</b>	<b>RLHRS (Run Labor Hours)</b>	<b>RMHRS (Run Machine Hours)</b>
blank	$RUNLB \times ORQTY$	$RUNMC \times ORQTY$
1	$(RUNLB/10) \times ORQTY$	$(RUNMC/10) \times ORQTY$
2	$(RUNLB/100) \times ORQTY$	$(RUNMC/100) \times ORQTY$
3	$(RUNLB/1000) \times ORQTY$	$(RUNMC/1000) \times ORQTY$
4	$(RUNLB/10000) \times ORQTY$	$(RUNMC/10000) \times ORQTY$
P	$(LOTSZ/RUNLB) \times ORQTY$	$(LOTSZ/RUNMC) \times ORQTY$
H	$(RUNLB/LOTSZ) \times ORQTY$	$(RUNMC/LOTSZ) \times ORQTY$
M	$(RUNLB/60) \times ORQTY$	$(RUNMC/60) \times ORQTY$
C	Do not process	Do not process

If the routing record is coded with a Time Basis Code of P (Pieces per Hour) and the Run Labor or Run Machine Hours are equal to zero, a warning message is printed. The Run Labor and/or Run Machine hours printed on the report will be set to zero.

If the routing record is coded with a Time Basis Code of H (Hours per Lot) or P (Pieces per Hour) and the Standard Lot Size on the Item Master B record is equal to zero, or no Item Master B record is found, a warning message is printed. The Standard Lot Size will be set equal to one.

## WIP costing formulas

Because the Work In Process Total Sheet (AMVQ20) reports WIP as setup, labor, overhead, materials, purchases, and miscellaneous costs and can distinguish between standard and actual costs, the in process cost is added as a separate column and labeled as an estimated cost based on the user defined Units in Process quantity in the operations of the Routing. The material costs are deducted (material costs are included in the raw material stock valuation until they are backflushed or scrapped). The WIP Total sheet deducts the WIP material value from the component material cost in inventory.

Calculated material costs for partially completed units are not included, as these costs would have to be subtracted from the calculated WIP total in order to prevent double counting the material cost already reflected in the stock valuation.

The files ROUTNG and MOROUT include the following field—**P-Unit** (number of partially completed units). The **P-Unit** field is the standard number of units in process at this operation (the operation run quantity).

The **P-Unit** field is initialized to the value in the routing at schedule release time and can be edited through Released Schedule Maintenance. This field then can be used to estimate the number of units on the line at the time the report was run. WIP cost for active schedules (Order Status 40 or higher in MOMAST) can then be costed using standard labor and overhead rates in MOROUT.

To calculate labor and overhead content of partially completed units on production lines, select from MOMAST records those active scheduled orders that have not been completed (OSTAT\$ 40).

For the following example, schedule S000001 has a status of 40 (Line has been primed) and calls for producing 100 units of end item A. Item A has the following product structure:

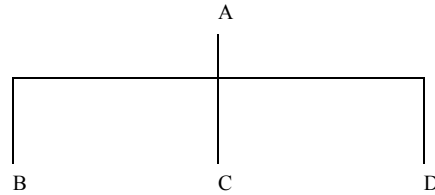


Figure 2-23. Product structure for A

The routing selected for the scheduled item is defined as follows:

**Oper**      Operation sequence number  
**P-Units**    Number of partially completed units (user-defined)  
**TBC**        Time basis code.

Operation	Description	P-Units	TBC	Components Used
0010	Machining			B & C
0020	Finishing		H	B
0030	Drilling			B & D
0040	Heat Treat		H	B
0050	Final Assembly			B, C & D

Select from MOMAST records active scheduled orders that have not been completed (OSTAT\$ 40). The program processes all MOROUT records for partially completed orders. MOROUT records are selected if the **ACREC** field is equal to A (active).

Labor and Overhead costing are calculated based on:

Field	Description	File
ORQTY	Order Quantity	MOMAST
TQCTD	Total Quantity Complete to Date	MOROUT
PCQTY	Partially Completed Quantity	Calculated
ACTFL	Activity Flag for Daily Schedule	MOROUT
SSLHR	Standard Setup Labor Hours	MOROUT
SSMHR	Standard Setup Machine Hours	MOROUT
SRLHR	Standard Run Labor Hours	MOROUT
SRMHR	Standard Run Machine Hours	MOROUT
SUCSZ	Setup Crew Size	ROUTNG/RTGHDR
TBCOD	Time Basis Code	ROUTNG/RTGHDR
SSLR	Standard Setup Labor Rate	WRKCTR/FACMST
SMR	Standard Machine Rate	WRKCTR/FACMST
SRLR	Standard Run Labor Rate	WRKCTR/FACMST
SOCOD	Standard Overhead Code	WRKCTR/FACMST
SOVER	Standard Overhead Rate/Percent	WRKCTR/FACMST
SSLCST	Standard Setup Labor Cost	Calculated
SRLCST	Standard Run Labor Cost	Calculated
SMCST	Standard Machine Cost	Calculated

Labor and Overhead calculations use the Time Basis Code in the corresponding Routing record to adjust the Standard Hours in the Routing record. The overhead rates are stored in the corresponding Work Center record. The program retrieves MOROUT records if the Active Flag is active.

The Standard Labor Cost, Standard Machine Cost and Standard Overhead Cost are calculated as follows:

Standard labor cost	Standard labor cost + Run labor cost
Setup labor cost	SSLHR x SSLR
Run labor cost	SRLHR x SRLR
Standard machine cost	Setup machine cost + Run machine cost
Setup machine cost	SSMHR/SCS x SMR
Run machine cost	SRMHR x SMR
Standard overhead costs	<b>If SOCOD = A</b> SMCST x (SOVER/100) <b>If SOCOD = B</b> (SRLCST + SSLCST) x (SOVER/100) <b>If SOCOD = C</b> SMRHS x SOVER <b>If SOCOD = D</b> SLHRX x SOVER



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The calculated standard labor, machine and overhead costs are extended by the Partially Completed Quantity for each operation which is calculated as follows:

- If  $ORQTY - TQCTD > 0$  and  $ORQTY - TQCTD \geq P\text{-Unit}$  then  $PCQTY = P\text{-Unit}$
- If  $ORQTY - TQCTD > 0$  and  $ORQTY - TQCTD < P\text{-Unit}$  then  $PCQTY = ORQTY - TQCTD$
- If  $ORQTY - TQCTD$  is equal or less than 0 then  $PCQTY = 0$ .

The costs shown on the report are cumulative for all partially completed operations. In the example:

Oper	Description	Labor Costs	Machin e Costs	Overhd Costs	P-Units	Unit Cum Cost	Extd Cost
0010	Machining	0	10	5	15	15	75
0020	Finishing	3	2	2	10	15+7	220
0030	Drilling	4	2	2	12	22+8	360
0040	Heat Treat	2	1	1	5	30+4	170
0050	Assembly	2	0	1	5	34+3	185

## REP recovery procedures

In order to properly recover your files, you need the following documentation, printed since your last backup:

- Application Log
- Released orders and schedules audit reports
- REP Prime Production Lines Audit report
- REP Transaction Rerun Guide
- Inventory transaction registers
- Manufacturing and purchasing file maintenance audit listings.

You should use the Application Log to assist you in repeating the steps that reconstruct your files. You must perform these steps in the proper sequence. Should they be performed in a different sequence, your files may contain information different from what was in your files prior to performing recovery. For example, entering schedules, releasing schedules, priming production lines, posting transactions, and file maintenance must be performed in the same sequence as they originally occurred to produce the same effects on your files. Actions by other applications (for example, Enterprise Product Data Management, Inventory Management, Customer Order Management, Production Control and Costing, Production Monitoring and Control, Purchasing, and Material Requirements Planning) also affect your files and should also be properly sequenced.

### Removing transaction batches after they have been processed

If you delete your data entry transactions before backing up your files (you answered Y to question X02: DO YOU WANT ENTRY TRANSACTIONS TO BE DELETED FROM THE SYSTEM BEFORE BACKING UP YOUR FILES? in the questionnaire), the data entry files are recovered along with the master files. After they are recovered, they appear as they did at the time of the last backup. All transaction batches they contain must be posted again. Any batches entered since the backup must be entered again.

## **Not removing transaction batches after they have been processed**

If you do not delete your data entry transactions before backing up your files (you answered N to question X02: DO YOU WANT ENTRY TRANSACTIONS TO BE DELETED FROM THE SYSTEM BEFORE BACKING UP YOUR FILES? in the questionnaire), the recover files operation also produces a rerun guide for the REP transaction file.

Batches that were closed with a status of CLOSED, UPDATE, or FINISH at the time of the restore operation are changed to RECOVER status. As the batch status is being changed, a data entry rerun log is printed and shows the time and date the batches were originally closed. Using this guide, you can process the batches in the sequence in which they were originally closed.

## **Selecting batches for re-processing**

Transaction batches are placed in RECOVER(y) status after the recovery of master files. These batches should be selected for re-processing in the order shown on the application data entry rerun log.

To select the batches for re-processing, use the Enter Transactions option on the Material Management menu (AMQM30). Each batch is posted after being selected.

Any errors detected during posting are printed on the Recover Transaction Batches listing. The information in each error transaction, or the condition that caused the transaction to be in error, must be corrected before the transaction can be properly posted.

## **Unique transaction situations**

When you select transaction batches to be re-processed and any R (Reverse) transactions are found in the batch, the R transactions are not re-processed. Any batch that contains only R transactions is shown as FINISH(ed) on the display; the whole batch is not re-processed.

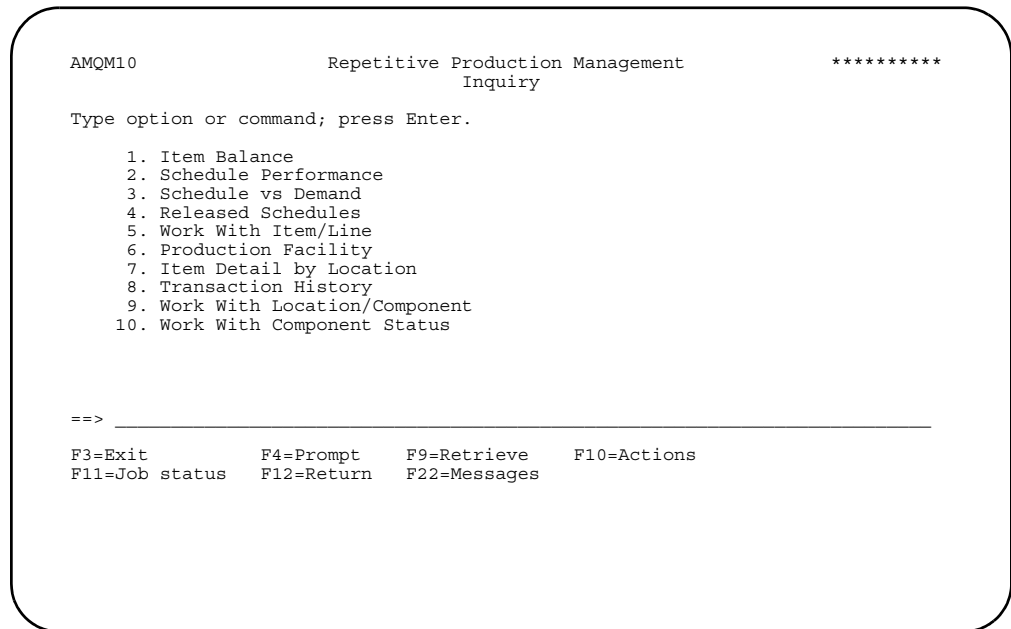
## **Additional activities after recovery**

After you have completed the recovery processing of transaction batches, you should establish your material plan again. If you have MRP installed, you should perform a full generation planning run to create planned orders based on your new item balances. You should also extract schedule requirements and review your production schedules to ensure that the supply meets the newly calculated demand.

## Chapter 3. Inquiry

An inquiry is a request for information to be shown on the display. When you select option 1 on the Repetitive Production Management Main Menu (AMQM00), the Inquiry menu (AMQM10) appears. This menu has options to allow you to review information about schedules, production lines, and items.

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**Option 8. Item Balance.** Shows schedule related information, on-hand and on-order quantity, usage and issue status, and year-to-date and month-to-date cost information.

**Option 9. Schedule Performance.** Determines the over-completion and under-completion status of schedules.

**Option 10. Schedule vs Demand.** Shows how the production plan is meeting scheduled demand, and calculates the item's available-to-promise quantity.

**Option 11. Released Schedules.** Shows released schedule information, component and routing information, and the schedule structure.

**Option 12. Work With Item/Line.** Shows you the Work With Item/Line Definitions panels so you can define or review what products are to be built, and which production lines are used to build these products.

**Option 13. Production Facility.** Shows production line, work station, and work center information, and standard costs, standard capacity hours, and variable capacity hours. This option is not available if EPDM is activated.

**Option 14. Item Detail by Location.** Shows information about items at production line or stock locations.

**Option 15. Transaction History.** Shows transactions processed within the REP and IM applications.

**Option 16. Work With Location/Component.** Shows you the Work With Location/Component Definitions panels so you can define or review what mode of replenishment is used at a location and specify or review other replenishment controls.

**Option 17. Work With Component Status.** Shows you the Work With Component Status panels so you can review the replenishment cycle controlled by the Location Component Status file. At the component level, this file tracks how much is needed, how much has been supplied, how much has been used, and what is being replenished.

## Option 1. Item Balance (AMQM10)

Use this option to see information about an item in the Item Balance file. You can review schedule-related information such as maximum containers, primary production line, and stock location. Additional displays are provided to show the on-hand quantity and on-order quantity status, the usage and issue status, and the year-to-date and month-to-date cost information.

**What information you need:**

- The item number for each inquiry
- The warehouse number

**What reports are printed:** None.

**What forms you need:** None.

The basic steps to do an inquire about item balances follow each display.

### AMQ1A1—Item Balance (Select)

Use this display to select a specific item number and warehouse for which you want to review Item Balance information.

This display appears when you select option 1 on menu AMQM10.

```
DATE **/**/**          ITEM BALANCE          SELECT  AMQ1A1  **
WH aA3  ITEM aaaaaaaaaA15 *****
                                           F24 END OF JOB      +
```

#### What to do

To inquire into the Item Balance file, type in the warehouse and the item number and press **Enter**. Go to display AMQ1A2.

#### Function keys

F24 END OF JOB shows you the Repetitive Production Management Inquiry menu (AMQM10) again, so you can choose another inquiry or end inquiry activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WH (Warehouse) (HOUSE) [?]**. This field contains the value of the default planning warehouse. Type in the code of the warehouse from which components are issued and the finished items received.

**ITEM (ITNBR) [?]**. Type in the item number that you want to view. The field that follows is a description of the item used on inquiries and reports

## AMQ1A2—Item Balance, Repetitive Manufacturing (Inquiry)

Use this display to show information for a specific item/warehouse combination. You can review other information for the item on subsequent displays. You can change the item number and warehouse on any of the displays.

This display appears after you enter a valid warehouse and item number on display AMQ1A1.

```

DATE **/**/**                ITEM BALANCE                INQUIRY  AMQ1A2  **
                             REPETITIVE MANUFACTURING

WH aA3  ITEM aaaaaaaaaaA15  *****

SCHEDULE CONTROL CODE  *                EXTRACT SOURCE CODE  *
                                           CARRY FORWARD        *
                                           SMOOTHING CODE       *
                                           SMOOTHING START DATE  **/**/**
                                           LOT SIZING CODE       *

PRIMARY PRODUCTION LINE *****          SCHEDULE GROUP        *****

WAREHOUSE LOCATION      *****          QUANTITY PER CONTAINER *, ***, ***. ***
                             CONTAINER DESCRIPTION *****

                                           F02 NEXT DISPLAY
                                           F03 PREVIOUS DISPLAY
                                           F24 END OF JOB
                                                                 +
    
```

### What to do

- To look at information from the Item Balance file for the item number you typed in, press **Enter**. This display appears again with the information for the selected item. If errors occur, the errors are highlighted.
- To look at detail Item Balance information, use **F02** and go to display AMQ1A3.
- To look at Item Balance quantity information, press **Enter** and go to display AMQ1A4.
- To look at REP information for another item, type in a warehouse and an item number and press **Enter**.

## Function keys

F02 NEXT DISPLAY shows you the Item Balance, Detail display (AMQ1A3).

F03 PREVIOUS DISPLAY shows you the Item Balance, Select display (AMQ1A1).

F24 END OF JOB shows you the Repetitive Production Management Inquiry menu (AMQM10) again so you can choose another inquiry or end inquiry activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WH (Warehouse) (HOUSE) [?]**. This field contains the value of the default planning warehouse. Type in the code of the warehouse from which components are issued and the finished items received.

**ITEM (ITNBR) [?]**. Type in the item number that you want to view. The field that follows is a description of the item used on inquiries and reports.

**SCHEDULE CONTROL CODE**. The code indicates if an item is schedule controlled. The code is shown as N (No) if order controlled, or Y (Yes) if schedule controlled.

**EXTRACT SOURCE CODE (EXTCD)**. The code shows the override extract source of demand for the item during schedule extract.

**blank** No override. If MRP is installed, then MRP is the primary extract source; if Customer Order Management (COM) is installed, then COM is used. If neither MRP nor COM is installed, then the Schedule Demand file is used.

- 1 MRP only.
- 2 COM and the Schedule Demand file.
- 3 Schedule Demand (Interface) file.

**CARRY FORWARD (CFWCD)**. The code specifies how the carry forward function applies to this schedule.

- 1 Schedule is not part of a production campaign.
- 2 Schedule is part of a production campaign.
- 3 Schedule is the last schedule in a production campaign.

**SMOOTHING CODE (SMHCD)**. The code specifies if and how smoothing is applied to an item in production.

**blank** No smoothing

- 1 REP Schedule Release Horizon plus one work day used to begin smoothing
- 2 The date where net demand is used to begin smoothing Net demand is determined by applying available inventory to time-phased demand.

**SMOOTHING START DATE (SMHDT)**. A specific date you want smoothing to begin. This date is an override to the Smoothing Code. This date is used if it is greater than the system date.

**LOT SIZING (LOTZ)**. This code indicates if this item can have multiple schedules per day (lots) created automatically.

**Y** Yes, item can have multiple schedules per day (lots).  
**N** No, item cannot have multiple schedules per day (lots).

**PRIMARY PRODUCTION LINE (PRLIN).** The production line where the item is usually manufactured.

**SCHEDULE GROUP (SCHGP).** A user-defined code used to group schedules. The code can also identify items that have similar manufacturing characteristics.

**WAREHOUSE LOCATION (WHSLC).** The default location from which parts are taken to supply production line requirements.

**QUANTITY PER CONTAINER (CONQT).** The quantity of an item stored in a full standard container.

**CONTAINER DESCRIPTION (CONDS).** A user-defined description of the standard container used for an item.

## AMQ1A3—Item Balance, Detail (Inquiry)

Use this display to review detail information for a specific item and warehouse.

The heading above the Cost fields will appear as MONTH-TO-DATE or PERIOD-TO-DATE, depending on how you answered the question about the accounting year during application tailoring.

The **STANDARD COST**, **USAGE COST**, and **SALES COST** fields will not appear if you do not have the appropriate security authorization.

This display appears after you use **F02 NEXT DISPLAY** on display AMQ1A2.

DATE **/**/**	ITEM BALANCE DETAIL	INQUIRY	AMQ1A3 **
WH aA3	ITEM aaaaaaaaaaA15	*****	ACTIVITY CODE *
ITEM CLASS ****	VENDOR *****	STANDARD COST **,**,**,**,**,**	
WH LOC *****	FLR STOCK *	BACKFLUSH *	
-- LEAD TIME --	ORDER POINT *,**,**,**,**	PERIOD-TO-DATE	
CODE *	SAFETY STOCK *,**,**,**,**	USAGE COST *,**,**,**,**,**,**	
MFG ***.*	FIXED ORD QTY *,**,**,**,**	SALES COST *,**,**,**,**,**,**	
VAR MFG ***.*	PURCHASE U/M **	SALES AMT *,**,**,**,**,**,**	
ADJ MFG ***.*	U/M CONV. **,**,**,**,**		
AVG MFG ***.*		YEAR-TO-DATE	
CUM MFG ***.*	CYCLE COUNT	USAGE COST *,**,**,**,**,**,**	
REV PUR ***.*	CODE *	SALES COST *,**,**,**,**,**,**	
VEN PUR ***.*	DATE NEXT COUNT **/**/**	SALES AMT *,**,**,**,**,**,**	
SAF PUR ***.*	TRANS COMPARE *,**,**		
PUR ***.*		AVG SALES *,**,**,**,**,**,**	
ADJ PUR **	DATE LAST SALE *****		
AVG PUR ***.*	DATE LAST USE *****	ITEM ACCOUNTING CLASS ***	
CMLT MATL ***.*	DATE LAST MAINT **/**/**		
		F02 NEXT DISPLAY	
		F03 PREVIOUS DISPLAY	
		F24 END OF JOB	



## What to do

- To look at detail Item Balance information for the selected item, press **Enter**. This display appears again with the information for that item. If errors occur, the errors are highlighted.
- To look at quantity information for this item, use **F02** and go to display AMQ1A4.
- To look at detail Item Balance information for another item, type in a warehouse and an item number and press **Enter**.

## Function keys

F02 NEXT DISPLAY shows you the next display (AMQ1A4).

F03 PREVIOUS DISPLAY shows you the previous display (AMQ1A2).

F24 END OF JOB shows you the Repetitive Production Management Inquiry menu (AMQM10) again so you can choose another inquiry or end inquiry activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

The **WH** and **ITEM** fields on this display are optional. All other fields are for information only.

**WH (Warehouse) (HOUSE) [?]**. This field contains the value of the default planning warehouse. Type in the code of the warehouse from which components are issued and the finished items received.

**ITEM (ITNBR) [?]**. Type in the item number that you want to view. The field following is a description of the item used on inquiries and reports.

**ACTIVITY CODE (ACREC)**. The present status of the record shown.

<b>A</b>	Active
<b>D</b>	Deleted
<b>S</b>	Suspend

**ITEM CLASS (ITCLS)**. The user-defined classification of items into groups.

**VENDOR (VNDNR)**. The number of the primary vendor supplying this item.

**STANDARD COST (STDUC)**. The sum of the standard purchase, labor, and overhead unit costs for this item and lower levels for this item.

**WH LOC (WHSLC)**. The default location from which parts are taken to supply production line requirements.

**FLR STOCK (FLSTK)**. The code indicates if an item is classified as floor stock.

<b>blank</b>	Not floor stock
<b>C</b>	Controlled floor stock item
<b>U</b>	Uncontrolled floor stock item

**BACKFLUSH (BFFL).** The code that identifies whether component backflushing for controlled floor stock items is done using the component quantity per adjusted for yield or the standard component quantity per.

- 0** Use the value of the backflush code for the warehouse.
- 1** Use adjusted quantity per to backflush (default).
- 2** Use standard quantity per to backflush.

**LEAD TIME CODE (LTCOD).** The code indicates whether manufacturing or purchasing lead times will be used in determining production schedules for MRP. An M indicates manufacturing lead time, and P indicates purchasing lead time.

**LEAD TIME MFG (LTMAN).** The standard lead time for one standard lot size of the item.

**LEAD TIME VAR MFG (LTVAM).** The portion of total manufacturing lead time that depends on the quantity produced.

**LEAD TIME ADJ MFG (LTDAM).** The portion of total lead time required for quantity-independent activities.

**LEAD TIME AVG MFG (LTMAV).** The average number of days between order start date and order completion date.

**LEAD TIME CUM MFG (CMFLT).** The composite lead time when all purchased items are assumed in stock.

**LEAD TIME REV PUR (LTREV).** The number of days between the release of a requisition and release of an order to the vendor.

**LEAD TIME VEN PUR (LTVEN).** The maximum number of days the vendor needs to deliver this item.

**LEAD TIME SAF PUR (LTSAF).** The number of days allocated for unexpected delays.

**LEAD TIME PUR (LTPUR).** The number of days between creation of a requisition and receipt of an item at the dock.

**LEAD TIME ADJ PUR (LTADP).** The portion of total purchase lead time required for order review, order processing, and dock-to-stock activities.

**LEAD TIME AVG PUR (LTPAV).** The average number of days between order start date and order completion date.

**LEAD TIME CMLT MAT (CMTLT).** The time required to produce a standard lot size when starting with no materials on hand.

**ORDER POINT (ORDPT).** The quantity of an item below which a reorder will be initiated.

**SAFETY STOCK (SAFTY).** The quantity of an item stocked that is more than the expected demand to meet unexpected increases in demand or late delivery.

**FIXED ORD QTY (FXORQ).** The quantity of an item to be ordered when the quantity available falls below the order point. The fixed order quantity is user-maintained and overrides the economic order quantity calculated by the system.

**USAGE COST (CSTMO).** The cost of items sold and the cost of items removed from stock but not sold.

**PURCHASE U/M (PURUM).** The purchase unit of measure, if different from the stocking unit of measure.

**SALES COST (CAMMO).** Item cost amount for the period or month to date.

**U/M CONV. (UMCNV).** The numeric factor used to convert one purchase unit of measure of the item to stocking units of the item.

**SALES AMOUNT (AMSMO).** Amount of sales for the item.

**CYCLE COUNT CODE (CCODE).** The code indicates if an item is to be cycle counted and the frequency of the count, if counted.

- |          |                      |
|----------|----------------------|
| <b>0</b> | No timed cycle count |
| <b>1</b> | Monthly              |
| <b>2</b> | Quarterly            |
| <b>3</b> | Semi-annually        |
| <b>4</b> | On demand            |

**DATE NEXT COUNT (NXCDT).** The scheduled date of the next cycle count of the item.

**CYCLE COUNT TRANS COMPARE (CCOMP).** The number of transactions after which the item should be flagged for cycle counting.

**DATE LAST SALE (DOFLS).** The date of the last sale for the item.

**DATE LAST USE (DOFLU).** The date the item was transferred from stock for any reason.

**DATE LAST MAINT (MDATE).** The last date any change was made to this record.

**YEAR-TO-DATE USAGE COST (CSTYR).** The cost of items sold and the cost of items removed from stock but not sold year to date.

**YEAR-TO-DATE SALES COST (CAMYR).** Item cost amount for the year to date.

**YEAR-TO-DATE SALES AMOUNT (AMSYR).** Item sales amount for the year to date.

**AVERAGE SALES (AVSAL).** The average value of the quantity sold per month or period. A weighted average based on the previous month's or period's value and the inventory averaging factor.

**ITEM ACCOUNTING CLASS (ITAC).** Class, defined by your company, to group or classify items for accounting purposes.

## AMQ1A4—Item Balance, Quantities (Inquiry)

Use this display to review quantity detail information for an item/warehouse combination.

The heading above the cost fields appears as MONTH-TO-DATE or PERIOD-TO-DATE, depending on how you answered the question about the accounting year during application tailoring.

This display appears after you use **F02 NEXT DISPLAY** on AMQ1A3.

```

DATE **/**/**                ITEM BALANCE                INQUIRY    AMQ1A4  **
                              QUANTITIES

WH xa3  ITEM aaaaaaaaaaA15  *****

      QUANTITIES                MONTH-TO-DATE                YEAR-TO-DATE
ON HAND      *,***,***.***-  SOLD      *,***,***.***-  SOLD      *,***,***.***-
ON ORDER PROD *,***,***.***-  ISSUE     *,***,***.***-  ISSUE     *,***,***.***-
ON ORDER PUR *,***,***.***-  REC       *,***,***.***-  USAGE     *,***,***.***-
ALLOCATED    *,***,***.***-  ADJ       *,***,***.***-
PCK/LST REQ  *,***,***.***-  USAGE    *,***,***.***-
BEGIN INV    *,***,***.***-

                              DATE LAST ACTIVITY ISSUED      **/**/**
                              DATE LAST AFFECTING QTY ON HAND **/**/**

                              AVERAGE MONTH END BALANCE *,***,***.***.***
                              ESTIMATED ANNUAL USAGE      *,***,***.***.***

                                                    F02 NEXT DISPLAY
                                                    F03 PREVIOUS DISPLAY
                                                    F24 END OF JOB
                                                    +
    
```

### What to do

- To look at quantity information for the selected item, press **Enter**. This display appears again with the information for that item. If errors occur, the errors are highlighted.
- To look at quantity information for another item, type in a warehouse and an item number and press **Enter**.

### Function keys

F02 NEXT DISPLAY shows you the next display (AMQ1A5).

F03 PREVIOUS DISPLAY shows you the previous display (AMQ1A3).

F24 END OF JOB shows you the Repetitive Production Management Inquiry menu (AMQM10) again so you can choose another inquiry or end inquiry activity.

### Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

The **WAREHOUSE** and **ITEM** fields on this display are optional. The remaining fields are for information only.

**WH (Warehouse) (FITWH) [?]**. This field contains the value of the default planning warehouse. Type in the code of the warehouse from which components are issued and the finished items received.

**ITEM (ITNBR) [?]**. Type in the item number that you want to view. The field following is a description of the item used on inquiries and reports.

**QUANTITIES ON HAND (MOHTQ)**. The quantity of the item now in stock.

**MONTH-TO-DATE SOLD (QTSMO)**. The quantity of the item sold this period or month to date.

**YEAR-TO-DATE SOLD (QTSYR)**. The quantity of the item sold so far this year.

**QUANTITIES ON ORDER PROD (MPRPQ)**. The total quantity of the item that is currently on order from manufacturing.

**MONTH-TO-DATE ISSUE (ISSMO)**. The quantity of the item issued this period or month to date.

**YEAR-TO-DATE ISSUE (ISSYR)**. The quantity of the item issued this year to date.

**QUANTITIES ON ORDER PUR (MPUPQ)**. The total quantity of the item that is currently on order through purchasing.

**MONTH-TO-DATE REC (RECMO)**. The quantity of the item received this period or month to date.

**YEAR-TO-DATE USAGE (USEYR)**. The quantity of the item used year to date.

**QUANTITIES ALLOCATED (MALQT)**. The quantity currently reserved at the location.

**MONTH-TO-DATE ADJ (ADJMO)**. The sum of the adjustments (changes) made to the quantity of the item this period or month to date.

**QUANTITIES PCK/LST REQ (Pick List Requirements) (PLREQ)**. The total quantity of this item reserved to be picked for customer orders.

**MONTH-TO-DATE USAGE (USEMO)**. The quantity of the item used this period or month to date.

**QUANTITIES BEGIN INV (Beginning Inventory) (BEGIN)**. The quantity of the item that was on hand at the beginning of the period or month.

**DATE LAST ACTIVITY ISSUED (LACDT)**. The last date this item was issued.

**LAST DATE AFFECTING QTY ON HAND (LDQOH)**. The last date the quantity on hand for this item was changed.

**AVERAGE MONTH END BALANCE (AVMEB).** The average value of quantity on hand at period or month end closing. A weighted average based on the previous period's or month's value and the inventory averaging factor.

**ESTIMATED ANNUAL USAGE (EAANU).** The estimated or actual quantity of an item for a one-year period.

## AMQ1A5—Item Balance, Planning Information (Inquiry)

Use this display to review planning detail information for an item/warehouse combination.

This display appears after you use **F02 NEXT DISPLAY** on AMQ1A4.

```

DATE **/**/**                ITEM BALANCE                INQUIRY    AMQ1A5  **
                             PLANNING INFORMATION

WH aA3  ITEM aaaaaaaaaaaaA15 *****
MASTER SCHEDULE ITEM CODE *      PRODUCT FAMILY PLANNER *****
MINIMUM QTY          *****.***  MPS PLANNING SOURCE CODE *
MAXIMUM QTY          *****.***  DAYS SUPPLY                ***
MULTIPLE QTY         *****.***  FORECASTING CODE          *
MASTER LEVEL ITEM CODE *      MASTER LEVEL FCST CODE    *
ORDER POLICY CODE    *      NO OF PERIODS              ***
MASTER LEVEL PRINT CODE *     DAYS/PERIOD                ***
MAX # LINES/ITEM     *      FORECAST QTY                *****
PERIOD INTERVAL CODE *      FIRM TIME FENCE            ***
COMBINE REQUIREMENTS CODE *    AUTH TIME FENCE           ***
INCLUDE INVENTORY BALANCE *   AUTO RELEASE CODE         *
SHRINKAGE            .***     CONTRACT REQUIRED CODE      *
PRBRK CONV FACTOR    *****.*** ITEM RESCHEDULE CODE      *
PLAN CUSTOMER ORDER CODE *    RESCHEDULE FROZEN ZONE   ****
PLAN EXPECTED ORDER CODE *    MIN DAYS TO RESCHEDULE  ****
PLANNING PROFILE ID  *****  DEMAND TIME FENCE         ***
RESOURCE NUMBER      *****  RESOURCE PROFILE BLD CODE *
                             F02 NEXT DISPLAY
                             F03 PREVIOUS DISPLAY
                             F24 END OF JOB

```

### What to do

- To look at planning information for the selected item, press **Enter**. This display appears again with the information for that item. If errors occur, the errors are highlighted.
- To look at planning information for another item, type in a warehouse and an item number and press **Enter**.

### Function keys

F02 NEXT DISPLAY shows you the first display (AMQ1A2) again.

F03 PREVIOUS DISPLAY shows you the previous display (AMQ1A4).

F24 END OF JOB shows you the Repetitive Production Management Inquiry menu (AMQM10) again so you can choose another inquiry or end inquiry activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

The **WH** and **ITEM** fields on this display are optional. The remaining fields are for information only.

**WH (Warehouse) (FITWH) [?]**. This field contains the value of the default planning warehouse. Type in the code of the warehouse from which components are issued and the finished items received.

**ITEM (ITNBR) [?]**. Type in the item number that you want to view. The field following is a description of the item used on inquiries and reports.

**MASTER SCHEDULE ITEM CODE (MSCOD)**. The code used by MPSP (if installed and interfacing) to indicate if this item is a master scheduled item. If M is used, MPSP plans orders for the item and ignores any requirements generated or entered for it in MRP. MRP uses the orders created by MPSP during the MRP planning run, based on a run-time option in MRP. The available codes are:

**blank** Not a master scheduled item  
**M** Master scheduled item  
**P** Production family

If the code is blank, FCST (if installed and interfacing) uses the forecasting code to determine whether the item is forecast and whether the forecast is passed to MRP/MPSP.

If the code is M, all item type codes are valid, except for F (Feature) or 0 (Phantom). If the code is P, the only valid master level item code is blank and the only valid item type code is 0 (Phantom). Refer to AMVT02 for a definition of the item type codes.

**MINIMUM QTY (MINQ)**. The minimum order quantity of the item. Any planned order generated by MRP and MPSP that is for a quantity less than the minimum indicated is increased to this minimum number. The default is 0.

**Note:** This field is used only by MRP and MPSP (if installed and interfacing).

**MAXIMUM QTY (MAXQ)**. The maximum planned order quantity. If the planned order quantity generated by MRP or MPSP exceeds this maximum, an exception is created to notify the planner, who may want to adjust the order quantity.

**Note:** This field is used only by MRP and MPSP (if installed and interfacing).

**MULTIPLE QTY (MULQ)**. The factor used by MRP and MPSP (if installed and interfacing) to increase a planned order to a multiple of this quantity. For example, if the planned order was originally for a quantity of 16 and the multiple quantity factor was 20, the planned order would be increased to 20. If the original quantity was 35, the planned order would be increased to 40.

**Note:** This field is used only by MRP and MPSP (if installed and interfacing).

**MASTER LEVEL ITEM CODE (MLIC)**. The code used by MRP (if installed and interfacing) to indicate if this item is a master level item and, if so, which requirements to use when planning orders.

The available codes are:

- blank** Not a master level item (MLI).
- M** Multiple source MLI. Both planner-entered (manual, held, and propagated) and generated requirements cause planned orders to be created for this item.
- S** Single source MLI. Only planner-entered requirements cause planned orders to be created.

**ORDER POLICY CODE (ORDP).** The code used to identify the order policy to be used to plan replenishment orders for this item. The available codes are:

- A** Discrete order quantity
- B** Order point, order quantity
- C** Order point, order up to level
- D** Fixed quantity
- F** Part period balancing – standard cost
- G** Time periods of supply
- H** Discrete above a minimum quantity
- I** Part period balancing – current cost
- Z** User option

**Note:** If MRP or MPSP are installed and interfacing with IM, items with an order policy code of B or C are not planned. IM processes only codes B and C on the Reorder report. If MRP is not installed, IM processes all codes as B.

Refer to the *Material Requirements Planning User's Guide* and the *Master Production Schedule Planning User's Guide* for a detailed explanation of order policy codes.

**MASTER LEVEL PRINT CODE (MLPC).** The code used by MRP (if installed and interfacing) to indicate if this item is printed on MRP MLI reports during master level planning runs. The available codes are:

- blank** Always printed.
- L** Printed only if this item's level was planned.
- S** Service usage. Is not printed on MRP MLI reports.

**MAX # LINES/ITEM (MXLN).** The code used to indicate the maximum number of lines to be printed for this item on the MRP Requirements Planning Report and the MPSP Master Schedule Planning Report. The available codes are:

- blank** 1 page per item
- A** All detail

**PERIOD INTERVAL CODE (PDIN).** The code used by MRP (if installed and interfacing) to indicate how requirements detail is presented on the Requirements Planning report. The available codes are:

- 0** Print full detail.
- 1** Summarize according to the first set of print intervals.
- 2** Summarize according to the second set of print intervals.
- 3** Summarize according to the third set of print intervals.

**Note:** This code corresponds to the print intervals defined on MRP Period Interval display, AMM120.

**COMBINE REQUIREMENTS CODE (CMRQ).** The code used by MRP (if installed and interfacing) to indicate if requirements for this item are to be combined during the MRP Requirements Planning run.



**Note:** You are not able to use the pegged-to-requirements function for any items that have combined requirements.

The four combine interval sizes and the five price break literals are defined on MRP Period Interval display, AMM120. Codes 5 through 9 (price break literals) combine requirements according to the fourth period interval.

The price break literals refer to the price break unit of measure constants printed on the MRP Purchase Planning report. The available codes are:

- 0 Do not combine requirements
- 1 Combine interval 1
- 2 Combine interval 2
- 3 Combine interval 3
- 4 Combine interval 4
- 5 Price break literal 5
- 6 Price break literal 6
- 7 Price break literal 7
- 8 Price break literal 8
- 9 Price break literal 9.

**INCLUDE INVENTORY BALANCE (ININ).** One of the following codes:

- 1 Yes. Include inventory balance of this item/warehouse in MRP planning runs.
- 0 No. Do not include inventory balance of this item/warehouse in MRP planning runs. This is the default.

**SHRINKAGE (SHFC).** The value used by MRP and MPSP (if installed and interfacing) as a multiplier to adjust gross requirements not covered by on-hand quantity to reflect expected material losses.

**PRBRK CONV FACTOR (Price Break Conversion Factor) (PBCF).** The factor used by MRP (if installed and interfacing) to convert planning units to purchase units. The factor is described by the price break literal assigned to this item (see "COMBINE REQUIREMENTS CODE (CMRQ)" on page 3-14).

**PLAN CUSTOMER ORDER CODE (CTPO).** One of the following codes:

- 1 Create planned orders equal to all customer orders that fall after the MRP current date.
- 2 Create planned orders for all orders that fall after the release date.
- 3 Create planned orders for all orders that fall after the review date.
- 4 Do not create any planned orders.
- 5 Create planned orders equal to all customer orders that fall after MRP start date.

**PLAN EXPECTED ORDER CODE (ETPO).** One of the following codes:

- blank** Use the value in the Warehouse Master file.
- 0 Do not use expected customer orders in planning.
- A Use only type A (Make) expected customer orders in planning.
- B Use type A (Make) and type B (Buy) expected customer orders in planning.

- C** Use type A (Make), type B (Buy), and type C (Firm) expected customer orders in planning.
- D** Use type A (Make), type B (Buy), type C (Firm), and type D (Plan) expected customer orders in planning.

**PLANNING PROFILE ID.** Identifier for the purchase planning profile.

**RESOURCE NUMBER (RSCNO).** The user-defined number used by MPSP (if installed and interfacing) to identify this item as a critical resource.

**PRODUCT FAMILY PLANNER (PFPLN).** The user-defined identifier of the person responsible for planning the replenishment strategy for these production families.

**MPS PLANNING SOURCE CODE (MSSR).** The code used by MPSP (if installed and interfacing) to indicate the kind of demand used for generating the master production schedule for this item. The available codes are:

- blank** Not used in MPS planning
- B** Blended demand (the greater of forecasted demand or customer orders)
- C** Customer orders only
- D** Blended demand (planned orders created for each customer order)
- E** Forecasts ignored (planned orders created for each customer order)
- F** Forecasts only
- M** Manually entered firm planned orders
- P** Item production plan

**DAYS SUPPLY (NODS).** The number of days of supply that one order provides. The available codes are:

- 1** Once a week
- 2** Two times per production planning period
- 3** One time per production planning period
- 4** One time per work day.

This field is used only by MRP and MPSP (if installed and interfacing) if the order policy code is G for this item.

**FORECASTING CODE (FCSC).** The code used to control forecasting for this item in this warehouse. The available codes are:

- 0** Do not forecast this item.
- 1** Forecast but do not pass to MRP/MPSP.
- 2** Pass only forecast to MRP/MPSP.
- 3** Pass both forecast and requirement to MRP/MPSP.

**MASTER LEVEL FCST CODE (Master Level Forecast Code) (MLFC).** The code used by MRP (if installed and interfacing) to indicate if the master level item is to be forecasted. This code applies only to forecasts propagated in MRP. The available codes are:

- 0** Do not propagate forecast for this item.
- 1** Propagate forecast for this item.
- 2** Propagate requirements equal to forecast for this item.

**NO OF PERIODS (Number of Forecast Periods) (FRPD).** The number of periods over which this item is to be forecasted in MRP.

**Note:** This field is used only if MRP is installed and interfacing, and applies only to forecasts generated in MRP.

**DAYS/PERIOD (Days per Forecast Period) (PDDY).** The number of days to be contained in each MRP forecast period.

**Note:** This field is used only if MRP is installed and interfacing, and applies only to forecasts generated in MRP.

**FORECAST QTY (FRQTY).** The forecast quantity per time period.

**FIRM TIME FENCE (FTIM).** The number of days during which orders can be placed and purchase can be committed. The established time fence is used with the auto release function. This field is used for standard purchase orders and for requisitions.

**AUTH TIME FENCE (ATIM).** The number of days during which orders can be intended and payment for vendor raw materials can be committed. The established time fence is used with the auto release function. This field is used for standard purchase orders and for requisitions.

**AUTO RELEASE CODE (ATRL).** A code used to define the conditions under which purchase orders or requisitions for this item can be automatically released. One of the following codes appears:

- 0 Do not automatically release requisitions or purchase orders. This is the default.
- 1 Automatically release requisitions without generating a purchase order.
- 2 Automatically release held single purchase orders requiring manual release, if the planned order is within the FIRM horizon.
- 3 Automatically release single purchase orders not requiring manual release, if the planned order is within the FIRM horizon.
- 4 Automatically release held blanket purchase orders requiring manual release, if the planned order is within the FIRM or AUTHORIZED horizon.
- 5 Automatically release blanket purchase orders not requiring manual release, if the planned order is within the FIRM or AUTHORIZED horizon.
- 6 Automatically release held fixed blanket purchase orders if the planned order is within the FIRM or AUTHORIZED horizon. The hold from print code must be manually removed in Purchasing before the purchase order is available for printing. A fixed blanket order must already exist with this option.
- 7 Automatically release blanket purchase orders if the planned order is within the FIRM or AUTHORIZED horizon. The purchase orders are available for automatic selection during the purchase order print process. A fixed blanket order must already exist with this option.

**CONTRACT REQUIRED CODE (ARCI).** Contract code used in Auto Release item override. If the selected items must be handled differently, you can specify conditions for individual items:

- 0 Default. Uses the value in MRP control information.
- 1 Contract required.
- 2 Contract not required; expired contract prevents release.
- 3 Contract not required; expired contract gives warning only.
- 4 Contract not required; any contracts are ignored (no message).

**ITEM RESCHEDULE CODE (ITRC).** Code used to indicate whether or not orders for the item (by item/warehouse) can be rescheduled automatically by the system.

- 0** Default to warehouse reschedule code. This is the default.
- 1** Cannot be rescheduled automatically
- 2** Can be scheduled out
- 3** Can be scheduled in
- 4** Can be scheduled both out and in

**RESCHEDULE FROZEN ZONE (RSFZ).** Number of days within which production schedules will not be rescheduled, by item/warehouse.

**MIN DAYS TO RESCHEDULE (MIND).** Specifies the minimum number of days that an order can move in order for it to be rescheduled automatically by the system. The default is 0.

**DEMAND TIME FENCE(DMDFN).** The number of days that are used by MPSP (if installed and interfacing) as a frozen planning zone in the MPSP master production schedule for this item. During this period, blended demand does not include forecasts until the periods after the fence date, and only customer orders are considered as demand. Any changes to the production schedule during the frozen period should be avoided because they can seriously affect production schedules. This number of days can equal the final assembly lead time (FALT) for this item. The system uses this number to calculate the demand time fence date in the master production schedule for this item.

**RESOURCE PROFILE BLD CODE (RSCBF).** The code used by MPSP (if installed and interfacing) to indicate which items or production families can have resource profiles generated. The available codes are:

- Y** Build profile
- N** Do not build profile.



## What to do

To select schedules for inquiry, type in a warehouse or leave blank for all warehouses. Type in **1** to select by line, **2** to select by item, or **3** to select by planner. Press **Enter** and go to display AMQ492.

## Function keys

F24 END OF JOB shows you the Inquiry menu (AMQM10) again, so you can choose another option or end this activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WAREHOUSE (FITWH) [?]**. This field contains the value of the default planning warehouse. Type in a specific warehouse code to review schedules for that warehouse, or make the field blank to review schedules for all warehouses.

**REVIEW SCHEDULES (RTVCD)**. Required. Type in **1**, **2**, or **3** to select how you want to review schedule performance:

- 1** By line
- 2** By item
- 3** By planner

**LINE (PLINE) [?]**. Type in the production line you want to review.

**ITEM (FITEM) [?]**. Type in an item number to select schedule information for a specific item.

**PLANNER (PLANN)**. Type in the code of the person responsible for planning and scheduling this finished item.

**HIGHLIGHT % COMPLETE LESS THAN (CMPPC)**. Type in a percentage to highlight schedules below a specified completion level.

## AMQ492—Review Schedule Performance Summary (Inquiry)

Use this display to review a summary of schedule performance data for an item produced on several lines, for all items on a line, or for all items assigned to a planner.

Existing schedules from the period are totaled. If any percent complete value is less than the value you entered on display AMQ491, the percent complete value is highlighted. To review the daily detail for an item shown, enter a **1** in the **SEL** field.

This display appears after you enter a production line, item, or planner on display AMQ491.

DATE **/**/**	REVIEW SCHEDULE PERFORMANCE SUMMARY	INQUIRY AMQ492 **
WH ***	REVIEW BY *****	% COMPLETE LESS THAN ***
SEL WH LINE ITEM	----- SCHEDULE	CURRENT/PERIOD -----
N *** *****	*****	COMPLETE VARIANCE % CMP
N *** *****	*****	*****
N *** *****	*****	*****
N *** *****	*****	*****
N *** *****	*****	*****
N *** *****	*****	*****
N *** *****	*****	*****
*** +		
	USE ROLL UP/DOWN	F19 RETURN TO SELECT
	F08 SHOW CUMULATIVE	F24 END OF JOB

### What to do

- To see daily detail information for one or more summary display lines, type in **1** in the **SEL** field and press **Enter**. Go to display AMQ493.
- To see cumulative detail information for one or more summary display lines, type in **1** in the **SEL** field and use **F08**. Go to display AMQ494.
- To return to the Review Schedule Performance (Select) display (AMQ491), use **F19**.

### Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of schedules.

F08 SHOW CUMULATIVE shows you display AMQ494 so you can review cumulative detail for the item you selected.

F19 RETURN TO SELECT returns to the Select display (AMQ491) so you can make another selection.

F24 END OF JOB shows you the Schedule Management menu (AMQM40) again, so you can choose another option or end this activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WH (Warehouse) (HOUSE).** The warehouse you selected on display AMQ491. If left blank, the field shows information for all warehouses.

**REVIEW BY (RPTBY).** The Review Schedules option from menu AMQ491 (Line, Item, or Planner) followed by a description.

**% COMPLETE LESS THAN (CMPPC).** The percentage from AMQ491. Any percent complete values that are less than the value shown are highlighted.

**SEL (Select) (SELWK).** Type in 1 next to each schedule for which you want to review daily schedule information.

**WH (Warehouse) (HOUSE).** The warehouse in which the finished items are received.

**LINE (LINWK).** The production line on which activity occurred.

**ITEM (ITNBR).** The item number being produced.

**CURRENT SCHEDULE (SCHED).** The schedule quantity for this item and line since the last schedule break.

**CURRENT COMPLETE (QTCP1).** The completed quantity for this item and line since the last schedule break.

**CURRENT VARIANCE (QTVR1).** The difference between quantity completed and quantity scheduled for this item and line since the last schedule break.

**CURRENT % CMP (PRCNT).** The percentage of the quantity completed against the schedule.

**PERIOD SCHEDULE (SCHED).** The schedule quantity for this item and line for the period.

**PERIOD COMPLETE (QTCP1).** The completed quantity for this item and line for the period.

**PERIOD VARIANCE (QTVR2).** The difference between quantity completed and quantity scheduled for this item and line for the period.

**PERIOD % CMP (PRCNT).** The percentage of the quantity completed against the schedule for the total period.



## AMQ493—Review Schedule Performance, Daily (Inquiry)

Use this display to review daily schedule information since the last purge.

This display appears when you type in **1** in the **SEL** field on display AMQ492 or when you use **F08 SHOW DAILY** on display AMQ494.

```

DATE **/**/**          REVIEW SCHEDULE PERFORMANCE      INQUIRY   AMQ493  **
                        DAILY

WH ***  ITEM *****
LINE *****  PLANNER *****

C SCH DATE      SCHEDULE      COMPLETE      DAILY VAR      SCHED VAR      PERIOD  VAR
SCH NBR  TYPE      PLANNED SCRAP  DAILY SCRAP    PERIOD SCRAP    YIELD
* **/**/** ***** .*** ***** .*** ***** .***- ***** .***- ***** .***-
*****      *          ***** .***- ***** .***- ***** .***- ***** .***-
* **/**/** ***** .*** ***** .*** ***** .***- ***** .*** ***** .***-
*****      *          ***** .***- ***** .***- ***** .***- ***** .***-
* **/**/** ***** .*** ***** .*** ***** .***- ***** .*** ***** .***-
*****      *          ***** .***- ***** .***- ***** .***- ***** .***-
* **/**/** ***** .*** ***** .*** ***** .***- ***** .*** ***** .***-
*****      *          ***** .***- ***** .***- ***** .***- ***** .***-

AVERAGE DAILY VARIANCE ***** .***-

                                F08 SHOW CUMULATIVE
                                USE ROLL UP/DOWN      F19 RETURN TO SELECT
                                F03 RETURN TO SUMMARY   F24 END OF JOB

```

### What to do

- To see the next selected record, press **Enter**. If no more records have been selected, go to display AMQ492.
- To see cumulative performance information, use **F08** and go to display AMQ494.
- To return to the Review Schedule Performance Summary (Inquiry) display (AMQ492), use **F03**. Go to display AMQ492.
- To return to the Review Schedule Performance (Select) display (AMQ491), use **F19**.

### Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of schedules.

F03 RETURN TO SUMMARY returns to the previous display (AMQ492).

F08 SHOW CUMULATIVE proceeds to the next display (AMQ494) which shows cumulative quantities for the Quantity Schedule, Quantity Complete, Quantity Scrapped, and Variance fields for consecutive dates.

F19 RETURN TO SELECT returns to the Select display (AMQ491) so you can make another selection.

F24 END OF JOB shows you the Inquiry menu (AMQM10) again, so you can choose another option.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

All of the fields on this display are for information only.

**WH (Warehouse) (HOUSE)**. The warehouse from which components are issued and the finished items are received.

**ITEM (ITNBR)**. The item number and description selected on the previous display.

**LINE (LINWK)**. The production line selected on the previous display.

**PLANNER (PLANN)**. The code of the person responsible for planning and scheduling this finished item.

**C (Complete) (IFLAG)**. If a schedule has had a receipt transaction reported to make the schedule complete, a C appears in this field.

**SCH DATE (DATEWK)**. The date the item is scheduled to be completed.

**SCHEDULE (SCHED)**. The schedule quantity for this item and line for this schedule date.

**COMPLETE (QTCP1)**. The completed quantity for this item and line for this schedule date.

**DAILY VAR (Daily Variance) (QTVR1)**. The difference between the units reported as completed and the units scheduled for this date.

**SCHED VAR (Schedule Variance) (QTVR2)**. The accumulated sum of daily variances for a summary schedule.

**PERIOD VAR (Period Variance) (QTVR3)**. The period-to-date sum of the schedule variances for this item.

**SCH NBR (ORDNO)**. The schedule number associated with this item.

**CFO (CARRY FORWARD) (CFWCD)**. The code specifies how the carry forward function applies to this schedule.

- 1 Schedule is not part of a production campaign.
- 2 Schedule is part of a production campaign.
- 3 Schedule is the last schedule in a production campaign.

**PLANNED SCRAP (PSCR)**. The amount of expected item scrap, based on the units scheduled. The calculation is scheduled quantity times shrinkage factor for the end item.

**DAILY SCRAP (QTSP3)**. The actual reported scrap for the finished item.

**PERIOD SCRAP (QTSP1)**. The cumulative actual scrap quantity reported for this item and line since the last purge of schedules.

**YIELD (AYLD4).** The percentage of completed units of the item that have passed inspection. Quantity complete divided by (quantity complete plus quantity scrapped) times 100 equals percent yield.

**AVERAGE DAILY VARIANCE (AVAR1).** The sum of the unsigned daily variances divided by the number of days a schedule appears. This field provides a measurement of how well schedules are met.

## AMQ494—Review Schedule Performance, Cumulative (Inquiry)

Use this display to review cumulative daily information as shown on the previous display.

This display appears when you use **F08 SHOW CUMULATIVE** on display AMQ492 or AMQ493.

DATE **/**/**	REVIEW SCHEDULE PERFORMANCE CUMULATIVE	INQUIRY AMQ494 **
WH *** ITEM *****	*****	
LINE *****	PLANNER *****	
C SCH DATE	SCHEDULE PLANNED SCRAP	COMPLETE DAILY SCRAP
PERIOD SCRAP	SCHED VAR	YIELD
* **/**/** *****	*****	*****
*****	*****	*****
* **/**/** *****	*****	*****
*****	*****	*****
* **/**/** *****	*****	*****
*****	*****	*****
* **/**/** *****	*****	*****
*****	*****	*****
AVERAGE DAILY VARIANCE *****		+
USE ROLL UP/DOWN F03 RETURN TO SUMMARY		F08 SHOW DAILY F19 RETURN TO SELECT F24 END OF JOB +

### What to do

- To see the next selected record, press **Enter**. If no more records have been selected, go to display AMQ492.
- To see daily performance information, use **F08**. Go to display AMQ493.
- To return to the Review Schedule Performance Summary (Inquiry) display (AMQ492), use **F03**. Go to display AMQ492.
- To return to the Review Schedule Performance (Select) display (AMQ491), use **F19**. Go to display AMQ491.

## Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of schedules.

F03 RETURN TO SUMMARY returns to display AMQ492.

F08 SHOW DAILY returns to the previous display (AMQ493).

F19 RETURN TO SELECT returns to the Select display (AMQ491) so you can make another selection.

F24 END OF JOB returns to the Inquiry menu (AMQM10) so you can choose another option.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

All of the fields on this display are for information only.

**WH (Warehouse) (HOUSE)**. The warehouse from which components are issued and the finished items are received.

**ITEM (ITNBR)**. The item number and description selected on the previous display.

**LINE (LINWK)**. The production line selected on the previous display.

**PLANNER (PLANN)**. The code of the person responsible for planning and scheduling this finished item.

**C (Complete) (IFLAG)**. If a schedule has had a receipt transaction reported to make the schedule complete, a C appears in this field.

**SCH DATE (Schedule Date) (DATEWK)**. The date the item is to be received.

**SCHEDULE (QTSC1)**. The cumulative schedule quantity for this item and line for this schedule date.

**COMPLETE (QTCP1)**. The cumulative completed quantity for this item and line for this schedule date.

**SCHED VAR (Schedule Variance) (QTVR2)**. The accumulated sum of daily variances.

**PERIOD VAR (Period Variance) (QTVR3)**. The cumulative period-to-date sum of the schedule variances for this item.

**PLANNED SCRAP (PSCR)**. The cumulative amount of expected item scrap, based on the units scheduled. The calculation is scheduled quantity times yield factor that is defined in MRP FIFO date/batch lot for the end item.

**DAILY SCRAP (QTSP3)**. The actual reported scrap for the finished item.

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**PERIOD SCRAP (QTSP1).** The cumulative actual scrap quantity reported for this item and line since the last purge of schedules.

**YIELD (AYLD4).** The percentage of completed units of the item that have passed inspection. Quantity complete divided by (quantity complete plus quantity scrapped) times 100 equals percent yield.

**AVERAGE DAILY VARIANCE (AVAR1).** The sum of the unsigned daily variances divided by the number of days a schedule appears. This field provides a measurement of how well schedules are met.

---

## Option 3. Schedule vs Demand (AMQM10)

Use this option to determine how well the current production plan is meeting scheduled item demand. This inquiry compares the demand quantity on a daily basis with the quantity scheduled and calculates the item's available-to-promise quantity.

An item number is required. If multiple warehouses are defined, a warehouse number is required.

**What information you need:**

- The item number of each item for inquiry
- The warehouse number

**What reports are printed:** None.

**What forms you need:** None.

The basic steps to inquire about schedule versus demand follow each display.

### AMQ1G1—Schedule vs Demand (Select)

Use this display to enter a warehouse and item to review how well the schedules are meeting product demand.

This display appears when you select option 3 on menu AMQM10.

```
DATE **/**/**          SCHEDULE VS DEMAND          SELECT    AMQ1G1  **
WH aA3  ITEM aaaaaaaaaaA15

F24 END OF JOB          +
```

#### What to do

To inquire about schedule vs. demand performance for a specific item, type in the information requested and press **Enter**. Go to display AMVATP04.

## Function keys

F24 END OF JOB shows you the Repetitive Production Management Inquiry menu (AMQM10) again, so you can choose another inquiry or end inquiry activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WH (Warehouse) (WAREHS) [?]**. Required. This field contains the value of the default planning warehouse. Type in the code of the warehouse from which components are issued and the finished items received.

**ITEM (ITEMNO) [?]**. Required. Type in the number of the item that you want to review.

## AMVATP04—Schedule vs Demand (Inquiry)

Use this display to review daily quantities of an item not committed to demand. You may change the selection criteria on this display. Schedule and demand quantities are summarized by item. (S-numbers are combined.) The available-to-promise quantity is only shown in the summary record.

This display appears after you select an item and warehouse on display AMQ1G1.

```

AMVATP04                               Schedule vs Demand
Warehouse . . . . . aA3 *****
Item . . . . . aaaaaaaaaA15 *****
On hand quantity . . : *,**,*- Safety stock . . . : ***,**,*-
Allocated quantity . : *,**,*- Available quantity : ***,**,*-
Paging date . . . . . nnnnnn
                                                    More: - +

Date          Available to promise    Expected receipts    Demand    S-Number
**/**/**      ***,**,*- ***,**,*- ***,**,*- ***,**,*- *****
**/**/**      ***,**,*- ***,**,*- ***,**,*- ***,**,*- *****
**/**/**      ***,**,*- ***,**,*- ***,**,*- ***,**,*- *****
**/**/**      ***,**,*- ***,**,*- ***,**,*- ***,**,*- *****
**/**/**      -----***** TF -----*****
**/**/**      ***,**,*- ***,**,*- ***,**,*- ***,**,*- *****
**/**/**      ***,**,*- ***,**,*- ***,**,*- ***,**,*- *****
**/**/**      ***,**,*- ***,**,*- ***,**,*- ***,**,*- *****
**/**/**      ***,**,*- ***,**,*- ***,**,*- ***,**,*- *****
**/**/**      ***,**,*- ***,**,*- ***,**,*- ***,**,*- *****
**/**/**      ***,**,*- ***,**,*- ***,**,*- ***,**,*- *****
**/**/**      ***,**,*- ***,**,*- ***,**,*- ***,**,*- *****
F3=Exit  F7=Backward  F8=Forward  F11=Job status  F12=Cancel

```

## What to do

To inquire about another item's schedule vs. demand performance, type in the information required and press **Enter**.

## Function keys

F3=Exit ignores any options or changes you typed on the current display, ends the current task, and returns to the display or menu where you started.

F7=Backward shows the previous set of entries or information on the display. You can press **F7** when you see **More: -** in the upper right part of the display.

F8=Forward shows the next set of entries or information on the display. You can press **F8** when you see **More: +** in the upper right part of the display.

F11=Job status shows a list of your current system and job information. You can see the status of your current job, including: system ID, date, job number, and job name; your ID and your workstation ID; the default output queue and output queue library; and the XA environment.

F12=Cancel ignores any options or changes you typed on the current display and causes the previous display to appear.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**Warehouse (WAREHS) [?]**. Required. The value you entered on display AMQ1G1 appears in this field. Type in the code of the warehouse from which components are issued and the finished item received. The field that follows is a description of the warehouse.

**Item (ITMNR) [?]**. Required. Initially, the value you entered on display AMQ1G1 appears in this field. Type in the item number that you want to view. The field that follows is a description of the item used on inquiries and reports.

**On hand quantity (MOHTQ)**. The total quantity of the item in inventory.

**Safety stock (SAFTY)**. The minimum quantity of item to keep in stock.

**Allocated quantity (MALQT)**. The quantity currently reserved for this item.

**Available quantity (AVBLE)**. The net quantity not yet committed to a production schedule. (On-hand plus on order minus allocated.)

**Paging date (PAGDTE)**. Type in the date you want to review. If the date entered is not found, the next earliest date is used. If the date entered is before the beginning of the data, the first available date is used. If the date entered is after the end of the data, the latest date is used.

**Date (DATDSP)**. The manufacturing dates.

**Available to promise (DSPATP)**. The uncommitted quantities of an item that are available to satisfy potential additional demand for this day.

**Expected receipts (RECDSP)**. The total of all orders (manufacturing, purchase, firm planned, and planned) expected into inventory for the date.



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***Demand (DMDDSP)***. The quantity needed to satisfy requirements after available inventory has been applied to demand. The amount can either be order quantities from COM, dependent demand from MRP, or demand quantities from the Schedule Interface file.

***S-Number (SNMBRP)***. The features and options code for the item. S-number appears if you chose feature/options support during PDM tailoring.

This display contains both detail and summary entries. The summary lines have Date, Demand, Expected receipts, and Available to promise values. The detail lines have Date, Demand, Expected receipts, and S-number values.

---

## Option 4. Released Schedules (AMQM10)

Use this option to review information about released schedules in the open schedule files, such as allocation, status, quantity, and cost information.

**What information you need:**

- The item number of each scheduled item for inquiry
- The warehouse number
- The S-number if feature/options are supported

**What reports are printed:** None.

**What forms you need:** None.

The basic steps to inquire about released schedules follow each display.

### AMQ1H1—Released Schedules (Select)

Use this display to select released schedules you wish to review in detail. To select a specific schedule, you may enter either the schedule number or any of the other fields (**WH**, **ITEM**, **LINE**, **SCHED DATE**, or **S-NUMBER**).

This display appears when you select option 4 on menu AMQM10.

```
DATE **/**/**          RELEASED SCHEDULES          SELECT  AMQ1H1 **

WH aA3  ITEM aaaaaaaaaaaaA15  REVISION aaaaA6
LINE aaaA5
SCHED DATE nnnnnn  SCHEDULE NUMBER aaaaaA7  S-NUMBER aaaaaaaaaaaaaaaaaA20

                                     F24 END OF JOB                                     +
```

#### What to do

To see released schedule information, press **Enter**. Go to display AMQ1H2 if only one schedule is selected or go to display AMQ1H8 if more than one schedule is selected.

#### Function keys

F24 END OF JOB shows you the Repetitive Production Management Inquiry menu (AMQM10) again, so you can choose another inquiry or end inquiry activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WH (Warehouse) (HOUSE) [?]**. This field contains the value of the default planning warehouse. Type in the code of the warehouse from which components are issued and the finished items received.

**ITEM (ITNBR) [?]**. Type in the item number you want to review.

**REVISION (REV)**. This field appears only if EPDM is activated. Accept the default of \*ALL to retrieve all item revisions. Type \*CUR to retrieve the current item revision based on the current system date. Type in a specific item revision identifier to see only released schedules associated with that item revision. A \*CUR entry or a specific number is required if you enter an S-number.

**LINE (LINWK) [?]**. Type in the production line you want to review.

**SCHED DATE (ODUPT)**. Type in the date the item's schedule is due to be completed.

**SCHEDULE NUMBER (ORDNO)**. Type in the control number assigned by the system to each schedule in the data base. You can enter this number instead of warehouse, item, line, or schedule date.

**S-NUMBER (SNMBR) [?]**. Type in the features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

## AMQ1H2—Released Schedules, Schedule Structure (Inquiry)

Use this display to select a specific operation and component to review. This display provides the starting point from which you can review information relating to operations, material, allocations, and summary data.

This display appears after you enter valid information on display AMQ1H1.

```

DATE **/**/**                               RELEASED SCHEDULES             INQUIRY    AMQ1H2  **
                                          SCHEDULE STRUCTURE

WH aA3  ITEM aaaaaaaaaaA15 ***** REVISION *****
       LINE aaaA5 *****
SCHED DATE nnnnnn  SCHEDULE NUMBER aaaaaA7  S-NUMBER aaaaaaaaaaaaaaaaaA20

SEL  A         WORK
C   C  OPER   CTR  COMPONENT      SEQ
A   *   ****  ****
A   *   ****  ****  *****
A   *   ****  ****  *****
A   *   ****  ****  *****
A   *   ****  ****  *****
A   *   ****  ****  *****
A   *   ****  ****  *****
A   *   ****  ****  *****
A   *   ****  ****  *****
A   *   ****  ****  *****
A   *   ****  ****  *****
A   *   ****  ****  *****
A   *   ****  ****  *****

                                             F11 POSITION TO
                                  USE ROLL UP/DOWN      F19 RETURN TO SELECT
                                  F01 REVIEW SUMMARY SCHED F24 END OF JOB

```

```

DATE **/**/**                               RELEASED SCHEDULES             INQUIRY    AMQ1H2  **
                                          SCHEDULE STRUCT=====
                                            POSITION TO
WH ***  ITEM ***** ***** | OPER aaA4 COMP aaaaaaaaaaA15 |
       LINE ***** ***** | SEQ aaA4 |
SCHED DATE ***** SCHEDULE NUMBER ***** =====

```

**What to do**

- To view a specific operation or component and user sequence, use **F11** and type the required information in the *POSITION TO* window. Press **Enter** to skip to the specific record. The window disappears when you press **Enter**.
- To see component information for the schedule shown, type in **1** in the **SEL** field and press **Enter**. Go to display AMQ1H4.
- To see information for a new schedule, type in the new schedule selection criteria and press **Enter**.
- To see operations for the schedule, type **1** in the **SEL** field and press **Enter**.
- To see summary schedule information, use **F01**. Go to display AMQ1H6.
- To return to the Released Schedules (Select) display (AMQ1H1) or the Released Schedules, Schedules (Select) display (AMQ1H8), use **F19**.

## Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of operations or components.

F01 REVIEW SUMMARY goes to Summary Schedule display (AMQ1H6) to show the summary information about the selected released schedule.

F11 POSITION TO shows you the **Position To** window. This window allows you to enter an operation ID or a component ID and user sequence ID. If you enter only an operation ID, that operation appears if it exists for the schedule. If the operation does not exist for the schedule, the first operation prior to the one entered appears.

If you enter a component ID, the component that matches or the first one prior to the one entered appears.

F19 RETURN TO SELECT returns to the Select display (AMQ1H1 or AMQ1H8) so you can select another record.

F24 END OF JOB shows you the Repetitive Production Management Inquiry menu (AMQM10) again, so you can choose another inquiry or end inquiry activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WH (Warehouse) (HOUSE) [?]**. This is the value that you typed in on AMQ1H1.

**ITEM (FITEM) [?]**. The item number selected on display AMQ1H1. You can type in another item that you want to review. The field following is a description of the item used on inquiries and reports.

**REVISION (REVX)**. This field appears only if EPDM is activated. The revision identifier associated with this item.

**LINE (WKCTR) [?]**. The production line selected on display AMQ1H1. You can type in another production line that you want to review.

**SCHED DATE (Schedule Date) (ODUDT)**. The schedule date selected on display AMQ1H1, or you can type in another schedule date you want to review.

**SCHEDULE NUMBER (ORDNO)**. The schedule number selected on display AMQ1H1, or you can type in another schedule number you want to review. You can enter this number instead of warehouse, item, line, or schedule date.

**S-NUMBER (SNMBR) [?]**. The S-number selected on display AMQ1H1, or you can type in another features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**SEL (Select) (SELWK)**. Type in **1** next to each operation or component you want to select for review.

**AC (ACTIVE) <Y,N> (ACFLG).** The code that designates an operation or component as being active or inactive.

**Y** Active  
**N** Inactive

If the operation is active, the material associated with this operation will be backflushed.

**OPER (Operation) (OPSEQ).** The operation sequence number that identifies an operation.

**WORK CTR (WKCTR).** The grouping of workers or machines used to perform the operation.

**COMPONENT (CITEM).** The component item number used in the operation.

**SEQ (USRSQ).** The user-defined sequence number used to uniquely identify the component.

### AMQ1H3—Released Schedules, Operations (Inquiry)

Use this display to show operations for which you want to see further detail. **F11 POSITION TO** allows you to position the display at a specific operation.

This display appears when you select records and press **Enter** on display AMQ1H2.

```

DATE **/**/**          RELEASED SCHEDULES          INQUIRY    AMQ1H3  **
                        OPERATIONS

WH aA3  ITEM ***** REVISION *****
      LINE *****
SCHED DATE **/**/**  SCHEDULE NUMBER ***** S-NUMBER *****

                                --- STANDARD HOURS/RATES ---
SEL AC OPER                                WRK CTR RP TBC PFAC SETUP MACHINE LABOR
  A *  START DEPT PROCESS TOOL   LC CREW RWK
    **/**/** ***** * * * * * *****.*****.*****.*****
                                OUTSIDE COST ***,***,***.*****

                                USE ROLL UP/DOWN          F11 POSITION TO
                                F03 PREVIOUS DISPLAY      F12 ADDITIONAL FIELDS
                                                                F24 END OF JOB
                                                                +
    
```

```

DATE **/**/**          RELEASED SCHEDULES          INQUIRY    AMQ1H3  **
                        OPERATIONS
                                =====
                                | POSITION TO |
                                | OPER aaA4 |
                                |=====
SCHED DATE **/**/**  SCHEDULE NUMBER ***** S-NUMBER *****
    
```

## What to do

- To select a specific operation, use **F11** and type an operation in the **POSITION TO** window. Press **Enter** to skip to the specific record. The window disappears when you press **Enter**.
- To see additional fields, use **F12**. To return to the original display format, use **F12** again.
- To see additional operation descriptions, type **1** in the **SEL** field and press **Enter**. Go to display AMQ1H7.
- To return to the Released Schedules Schedule Structure (Inquiry) display (AMQ1H2), use **F03**.

## Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of schedules.

F03 PREVIOUS DISPLAY shows you the Schedule Structure display (AMQ1H2).

F11 POSITION TO shows you the **Position To** window. This window allows you to enter an operation ID that appears if it exists for the schedule.

F12 ADDITIONAL FIELDS allows you to review the second line of fields on the display. Using F12 a second time returns you to the original format of one line of fields.

F24 END OF JOB shows you the Repetitive Production Management Inquiry menu (AMQM10) again. If any records were selected, you can choose another inquiry or end inquiry activity.

## Fields

**WH (Warehouse) (HOUSE)**. The warehouse selected on display AMQ1H1.

**ITEM (FITEM)**. The item number selected on display AMQ1H2.

**REVISION (REVX)**. This field appears only if EPDM is activated. The revision identifier associated with this item.

**LINE (PLINE)**. The production line selected on display AMQ1H2.

**SCHED DATE (ODUDT)**. The date the item's schedule is due to be completed.

**SCHEDULE NUMBER (ORDNO)**. The control number assigned to each schedule in the data base.

**S-NUMBER (SNMBR)**. The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**SEL (Select)**. Type in **1** next to each operation you want to select for additional operation descriptions.

**AC (Active) <Y,N>**. The code that designates an operation as being active or inactive.

**Y** Active  
**N** Inactive

**OPER (Operation) (OPSEQ)**. The operation sequence number that identifies an operation detail record within a schedule.

**WRK CTR (AWRKC)**. The grouping of workers or machines used to perform the operation.

**RP (Reporting Point) (IRCOD)**. The code that identifies an operation where transactions can be reported.

**Y** Reporting point  
**N** Not a reporting point

**TBC (Time Basis Code) (TBCDE)**. The code indicates the relationship between standard operation run unit time and expected operation quantities. The code is used to determine standard operation run labor hours and run machine hours.

**blank** Hours per unit  
**C** Cost per piece (outside operation)  
**H** Hours per lot size  
**P** Pieces per hour  
**M** Minutes per piece  
**1** Hours per 10 units  
**2** Hours per 100 units  
**3** Hours per 1000 units  
**4** Hours per 10000 units

**PFAC**. Class, defined by your company, to group or classify orders or items by production facility for accounting purposes.

**STANDARD HOURS SETUP (SSLHU)**. The standard setup labor time (in hours) for a manufacturing operation.

**STANDARD HOURS MACHINE (SRMHU)**. The standard run machine time (in hours) per unit, times the scheduled quantity.

**STANDARD HOURS LABOR (SRLHU)**. The standard run labor time (in hours) per unit, times the scheduled quantity.

**STANDARD RATES SETUP (SSLAB)**. The standard set up labor rate (in dollars). This rate is used to calculate the standard setup labor cost.

**STANDARD RATES MACHINE (SMACH)**. The standard machine rate (in dollars) per hour. This rate is used to calculate the standard run machine cost.

**STANDARD RATES LABOR (SRLAB)**. The standard run labor rate (in dollars) per hour.

**START**. The scheduled start date of a manufacturing order or operation.

**DEPT (DPTNO)**. The department associated with the specific operation.



**PROCESS (PRONO).** The process sheet number used to identify the detailed instruction for the operation. The actual process sheet is kept outside of the data base.

**TOOL (TOOLS).** The number assigned to a specific tool or list of tools needed to perform the operation. The control of special tools is done outside of the data base.

**LC (Prime Load Code) (PLCDE).** The code used to determine the critical time factors used in calculating the operation duration.

**CREW (SETCS).** The number of personnel required for the operation at setup time.

**RWK (REWRK).** The code that identifies if the operation is used to perform rework.

**Y** Rework operation  
**N** Not a rework operation

**OUTSIDE COST (OSCS).** The cost per piece charged by the vendor to produce the item. This field is used when the time basis code is C.

## AMQ1H4—Released Schedules, Component (Inquiry)

Use this display to review a specific component on a schedule.

This display appears after you select an operation/component on display AMQ1H2.

```

DATE **/**/**                RELEASED SCHEDULES          INQUIRY   AMQ1H4 **
                              COMPONENT

WH ***  ITEM *****          *****          REVISION *****
        LINE *****          *****
SCHED DATE **/**/**  SCHEDULE NUMBER *****  S-NUMBER *****

COMPONENT *****  SEQ *****
ACTIVE *          *****

OPERATION WHERE USED *****          REQUIRED DATE          **/**/**
STOCK LOCATION          *****          LINE LOCATION          *****
ADJ QTY PER          *****          FLOOR STOCK CODE          *
STD QTY PER          *****          BACKFLUSH CODE          *
UNIT COST          *****          REVISION          *****
CUSTOMER JOB NUMBER          *****

                                          F03 PREVIOUS DISPLAY
                                          F10 ALLOCATIONS
                                          F24 END OF JOB
    
```

### What to do

- To review existing allocation records for the scheduled item, use **F10**. Go to display AMQ1H5.
- To review the next selected component, press **Enter**. If no more components have been selected, go back to display AMQ1H2.
- To return to the Released Schedules Structure (Inquiry) display (AMQ1H2), use **F03**.

## Function keys

F03 PREVIOUS DISPLAY shows you the Schedule Structure display (AMQ1H2).

F10 ALLOCATIONS allows you to review existing allocation records for the scheduled item on display AMQ1H5.

F24 END OF JOB shows you the Repetitive Production Management Inquiry menu (AMQM10) again, so you can choose another inquiry or end inquiry activity.

## Fields

**WH (Warehouse) (HOUSE).** The warehouse you selected on display AMQ1H1.

**ITEM (FITEM).** The item number selected on display AMQ1H2. The field following is a description of the item used on inquiries and reports.

**REVISION (REVM).** This field appears only if EPDM is activated. The revision identifier associated with this item.

**LINE (PLINE).** The production line associated with the operation/component selected on display AMQ1H2.

**SCHED DATE (ODUPT).** The date that the item's schedule is due to be completed.

**SCHEDULE NUMBER (ORDNO).** The control number assigned by the system to each schedule in the data base.

**S-NUMBER (SNMNR).** The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**COMPONENT (CITEM).** The material used in the production of the scheduled item.

**SEQ (USRSQ).** The user-defined sequence number used to uniquely identify the component.

**ACTIVE (ACFLG) <Y,N>.** The code that designates a component as being active or inactive.

**OPERATION WHERE USED (OPRWU).** The operation sequence number that identifies the operation where the component is used.

**REQUIRED DATE (REQDT).** The date that the component is required at the production line.

**STOCK LOCATION (CSKLC).** The supply location from which parts are taken to supply the production line requirements.

**LINE LOCATION (DLOCN).** The location on the production line where the component is normally delivered.

**ADJ QTY PER (QTYPRE).** The quantity (adjusted for yield) of this component used to produce one unit of the finished item.



## What to do

- To review materials information, use **F09**. Go to display AMIWA1.
- To return to the Released Schedules Component (Inquiry) display (AMQ1H4), use **F03**.

## Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of schedules.

F03 PREVIOUS DISPLAY shows you the previous display (AMQ1H4).

F09 MATERIALS INQUIRY shows you the Location Detail by Item/Warehouse display (AMIWA1).

F24 END OF JOB shows you the Repetitive Production Management Inquiry menu (AMQM10) again, so you can choose another inquiry or end inquiry activity.

## Fields

All of the fields on this display are for information only.

**WH (Warehouse) (HOUSE)**. The warehouse selected on display AMQ1H1.

**ITEM (FITEM)**. The item number selected on display AMQ1H1. The field following is a description of the item used on inquiries and reports.

**REVISION (REVM)**. This field appears only if EPDM is activated. The revision identifier selected on display AMQ1H1.

**LINE (LINWK)**. The production line selected on display AMQ1H1.

**SCHED DATE (DDATE)**. The date that the item's schedule is due to be completed.

**SCHEDULE NUMBER (ORDNO)**. The control number assigned by the system to each schedule in the data base.

**S-NUMBER (SNMBR)**. The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**COMPONENT (CITEM)**. The material used in the production of the scheduled item.

**SEQ (USRSQ)**. The user-defined sequence number used to uniquely identify the component.

**ACTIVE (ACFLG)**. The code that designates an operation or component as being active or inactive.

**QUANTITY (LALQY)**. The amount from the specified locations allocated to the schedule.

**SPL LOC (Supply Location) (LLOCN)**. The location from which parts are delivered to the line.

**BATCH/LOT (LBHNO).** The batch/lot number assigned to an item lot received into inventory.

**FIFO (First In First Out) (FDATE).** The date that an item was received into inventory.

## AMQ1H6—Released Schedules, Summary Schedule (Inquiry)

Use this display to review information in the summary record for released schedules.

This display appears when you use **F01 REVIEW SUMMARY SCHED** on display AMQ1H2.

DATE **/**/**	RELEASED SCHEDULES SUMMARY SCHEDULE	INQUIRY	AMQ1H6	**
WH ***	ITEM *****	*****	REVISION	*****
	LINE *****	*****		
SCHED DATE **/**/**	SCHEDULE NUMBER *****	S-NUMBER *****		
SCHEDULED QUANTITY *****.	SCHEDULE GROUP *****	RUN SEQUENCE		***
QUANTITY COMPLETED *****.	ITEM RATE *****.	ALT ROUTING CODE		**
CARRY FORWARD QTY *****.	P/C CODE *	STATUS		**
SETUP COST *****.	UNIT COST *****.			-
LABOR COST *****.	OVERHEAD COST *****.			-
ISSUE COST *****.	SCRAP COST *****.			-
RECEIPT COST *****.	RECEIPT COST THIS PERIOD *****.			-
PLANNER *****	SCHED ACCOUNTING CLASS	***		
DEPARTMENT *****	START DATE	**/**/**		
CUSTOMER JOB *****	LAST ACTIVITY DATE	**/**/**		
REFERENCE *****	LAST MAINTENANCE DATE	**/**/**		
ENG DRAW *****	SCHEDULE RESCHEDULE CODE	*		
F03 PREVIOUS DISPLAY	F10 SOURCE OF DEMAND	F24 END OF JOB		

### What to do

To return to the Released Schedules Schedule Structure (Inquiry) display (AMQ1H2), use **F03**.

### Function keys

F03 PREVIOUS DISPLAY shows display AMQ1H2

F10 SOURCE OF DEMAND allows you to see the source of demand for this item. Display AMMM71 appears.

F24 END OF JOB shows you the Repetitive Production Management Inquiry menu (AMQM10) again, so you can choose another inquiry or end inquiry activity.

### Fields

**WH (Warehouse) (HOUSE).** The warehouse selected on display AMQ1H1.

**ITEM (FITEM).** The item number selected on display AMQ1H2. The field following is a description of the item used on inquiries and reports.

**REVISION (REVX).** This field appears only if EPDM is activated. The revision identifier associated with this item.

**LINE (PLINE).** The production line selected on display AMQ1H2.

**SCHEDULE DATE (DDATE).** The date that the item's schedule is due to be completed.

**SCHED NUMBER (ORDNO).** The control number assigned by the system to each schedule in the data base.

**S-NUMBER (SNMBR).** The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**SCHEDULED QUANTITY (ORQTY).** The quantity of the finished item scheduled to be produced on the schedule date.

**SCHEDULE GROUP (SCHGP).** A user-defined code used to sequence schedules. This code can also identify items that have similar manufacturing characteristics.

**RUN SEQUENCE (RUNSQ).** A code that determines the sequence that schedules are run on a production line. Run sequence, then schedule group, determines the order in which items are produced on the production line on the schedule date.

**QUANTITY COMPLETED.** The completed quantity for this item and line for this date.

**ITEM RATE (PCSHR).** The rate at which items are produced on the production line, stated in either pieces per hour or cycle time (time between pieces coming off the line).

**ALT ROUTING CODE (ARCDE).** The Alternate Routing Code determines which additional operations are added to the routing. A default of blank (no select) indicates that only base operations were selected (no additional operations were added).

**CARRY FORWARD QTY (CFWRD).** The quantity to be posted to the next schedule.

**P/C CODE.** Code indicating the contents of the **ITEM RATE** field.

**blank** Value for any manufacturing order in the Manufacturing Order Master file  
**C** Item Rate is shown as cycle time.  
**P** Item Rate is shown as pieces per hour.

**STATUS (OSTAT).** The reporting status of an open order or schedule.

**00** Planned order/schedule not released  
**10** Order/schedule released, not primed  
**40** Activity reported (schedule primed)  
**55** Order/schedule complete

**SETUP COST (SETCO).** The costs associated with preparing a production line for the production of a new item.

**UNIT COST (CSTPC).** The cost per unit of the finished item.

**LABOR COST (LABCD).** The cost of labor associated with the production schedule.

**OVERHEAD COST (OVHCO).** Costs not reported directly to a schedule.

**ISSUE COST (ISSCD).** The transaction cost of the material issued to a schedule.

**SCRAP COST (SCPCO).** The cost of labor, materials, and overhead incurred in the production of scrapped items and components.

**RECEIPT COST (RECCO).** The costs associated with completed units that were received on this schedule.

**RECEIPT COST THIS PERIOD (RECTP).** The costs associated with completed units that were received on this schedule for the period to date.

**PLANNER (PLANN).** The code of the person responsible for planning and scheduling this finished item.

**SCHED ACCOUNTING CLASS (OARC).** Class, defined by your company, to group or classify orders for accounting purposes.

**START DATE (SSTDT).** The scheduled start date of the schedule or operation.

**DEPARTMENT (DPTNO).** The department associated with manufacturing the item.

**LAST ACTIVITY DATE (LATDT).** The last date a transaction was reported against the schedule.

**CUSTOMER JOB (JOBNO).** The customer order number associated with the schedule.

**LAST MAINTENANCE DATE (MDATE).** The last date on which any changes were made to this summary record.

**REFERENCE NUMBER (REFNO).** The user-defined code used to provide additional information.

**ENG DRAW (ENGNO).** The unique engineering drawing number assigned to an end product or item.

**SCHEDULE RESCHEDULE CODE (ORRC).** Code used to indicate whether or not an individual manufacturing order or purchase order line item can be rescheduled automatically by the system.

- |          |   |
|----------|---|
| <b>0</b> | Default to item reschedule code. This is the default. |
| <b>1</b> | Cannot be rescheduled automatically                   |
| <b>2</b> | Can be scheduled out                                  |
| <b>3</b> | Can be scheduled in                                   |
| <b>4</b> | Can be scheduled both out and in                      |





**LINE (LINWK).** The production line selected on display AMQ1H2.

**SCHED DATE (ODUDT).** The date that the item’s schedule is due to be completed.

**S-NUMBER (SNMBR).** The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**SCHEDULE NUMBER (ORDNO).** The control number assigned by the system to each schedule in the data base.

**OPERATION (OPSEQ).** The operation sequence number that identifies an operation within a manufacturing order.

**ACTIVE.** The code that designates an operation or component as being active or inactive.

**SEQ NBR (Sequence Number) (DSQNO).** The sequence for the text records associated with the selected operation.

**ADDITIONAL DESCRIPTION (ADDSC).** The additional description detail for the operation.

## AMQ1H8—Released Schedules, Schedules (Select)

Use this display to select from the schedules shown for review.

This display appears when more than one schedule matches the selection you entered on the Released Schedule (Select) display (AMQ1H1 or AMQ1H2).

DATE **/**/**	RELEASED SCHEDULES SCHEDULES			SELECT	AMQ1H8	**
SEL WH LINE	SCHED ITEM	START DATE	SCHED DATE	S-NUMBER		
A *** *****	***** **/**/**	**/**/**	**/**/**	*****	*****	*****
				SCH NBR	*****	REV *****
A *** *****	***** **/**/**	**/**/**	**/**/**	*****	*****	*****
				SCH NBR	*****	REV *****
A *** *****	***** **/**/**	**/**/**	**/**/**	*****	*****	*****
				SCH NBR	*****	REV *****
A *** *****	***** **/**/**	**/**/**	**/**/**	*****	*****	*****
				SCH NBR	*****	REV *****
A *** *****	***** **/**/**	**/**/**	**/**/**	*****	*****	*****
				SCH NBR	*****	REV *****
A *** *****	***** **/**/**	**/**/**	**/**/**	*****	*****	*****
				SCH NBR	*****	REV *****
A *** *****	***** **/**/**	**/**/**	**/**/**	*****	*****	*****
				SCH NBR	*****	REV *****

USE ROLL UP/DOWN                      F19 RETURN TO SELECT  
F12 ADDITIONAL FIELDS                F24 END OF JOB

+

## What to do

- To see location information for a QC item, type in the item number, warehouse, and FIFO date if FIFO control is active. Press **Enter** and go to display AMIWA2.
- To see location information for a non-QC item, type in the item number, warehouse, and FIFO date if FIFO control is active. Press **Enter** and go to display AMIWA3.

## Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of schedules.

F12 ADDITIONAL FIELDS allows you to see a description of the finished item. Using F12 a second time returns you to the original format of showing one line per record.

F19 RETURN TO SELECT returns you to the Select display (AMQ1H1).

F24 END OF JOB shows you the Repetitive Production Management Inquiry menu (AMQM10) again. If any records were selected, you can choose another inquiry or end inquiry activity. If no records were selected, this display appears again.

## Fields

**SEL (Select) (SELEC).** Required. Type in **1** next to each operation or component you want to select for review.

**WH (Warehouse) (HOUSE).** The warehouse from which components are issued and the finished items are received.

**LINE (PLINE).** The production line selected on the previous display.

**SCHED ITEM (FITEM).** The item number selected on the previous display.

**START DATE (SSTDT).** The date work is to begin on a schedule. This date is when materials are required to be delivered to the first production facility.

**SCHEDULE DATE (ODUDT).** The date that the item's schedule is due to be completed.

**S-NUMBER (SNMBR).** The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**SCH NBR (ORDNO).** The control number assigned by the system to each schedule in the data base.

**REVISION (REVX).** This field appears only if EPDM is activated. The revision identifier associated with this item.

## AMIWA1—Location Detail by Item/Warehouse (Select)

Use this display to enter the item and warehouse code for the location details you want to see.

This display appears when you use **F09 MATERIALS INQUIRY** on display AMQ1H5.

DATE **/**/**	LOCATION DETAIL BY ITEM/WAREHOUSE	SELECT	AMIWA1	**
ITEM	aaaaaaaaaaaaA15	WH aA3	FIFO DATE	nnnnnn
F24 END OF JOB				

### What to do

- To see location information for a QC item, type in the item number, warehouse code, and FIFO date (if FIFO control is active) and press **Enter**. Go to display AMIWA2.
- To see location information for a non-QC item, type in the item number, warehouse code, and FIFO date (if FIFO control is active) and press **Enter**. Go to display AMIWA3.

### Function keys

F24 END OF JOB causes the Inquiry menu to appear again.

### Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**ITEM (ITNBR) [?]**. Required. Type in the item number whose location detail you want to see.

**WH (Warehouse Code) (HOUSE)**. If you have multiple warehouses defined in the Warehouse Master file, type in the code of the warehouse for the location detail you want to see. If you have only one warehouse, the warehouse defined in the Warehouse Master file appears in this field and cannot be changed.

**FIFO DATE (FDATE).** Type in the date the item was actually received in stock, whether in approved or unapproved status. All locations containing the item with this or later dates appear. If this field is blank, all locations containing the item appear. This field appears only if you chose the FIFO date option during application tailoring.

## AMIWA2—QC Approved Lots Only (Inquiry)

Use this display to see location information for the item and warehouse selected. The display shows this information only for lots that are QC approved and available for issuing. In addition, the display indicates for the selected item and warehouse the total quantity that has not been QC approved and is not available for issuing so that you can take further action as necessary.

This display appears when you enter a QC item number on display AMIWA1 or select **F06** from the All Lots Approved and Not Approved (Inquiry) display (AMIWA3).

```

DATE **/**/**          QC APPROVED LOTS ONLY          INQUIRY   AMIWA2  **

ITEM      aaaaaaaaaaaA15          WH  aA3          FIFO DATE  nnnnnn
*****
LOCATION   QUANTITY   BATCH/LOT  DATE  LOCATION  QUANTITY   BATCH/LOT  DATE
*****
*****
*****
*****
*****
*****
*****
*****
*****
*****

TOTAL APPROVED      ** , ** , ** . **
INITIAL INSPECT RQD ** , ** , ** . **
SHELF LIFE EXPIRED ** , ** , ** . **
REJECTED            ** , ** , ** . **

F02 PAGE FORWARD
F03 PAGE BACKWARD
F05 ALL LOTS
F24 END OF JOB
  
```

### What to do

- To see location information for another QC item, type in that item number, warehouse code, and FIFO date (if FIFO control is active) and press **Enter**. This display appears again with the information you requested.  
**Note:** If you enter a non-QC item number, an error message appears. Use **F05** to see information for that item.
- To see location information for both QC approved and not approved lots, use **F05**. Go to display AMIWA3.
- If you type in a non-QC item number, an error message appears. Select **F05** to see details for the non-QC item.

### Function keys

F02 PAGE FORWARD causes successive pages of location information to appear until the message END appears. Pressing **F02** after the END message appears cause the first page of location information to appear again.

F03 PAGE BACKWARD shows you the previous page of location information if more than one page exists. When you reach the first page, **F03** has no effect.

F05 ALL LOTS causes the All Lots Approved and Not Approved (Inquiry) display (AMIWA3) to appear.

F24 END OF JOB causes the Inquiry menu to appear again.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**ITEM (ITNBR) [?]**. Type in the item number whose location detail you want to see.

**WH (Warehouse Code) (HOUSE)**. If you have multiple warehouses defined in the Warehouse Master file, type in the code of the warehouse for the location detail you want to see. If you have only one warehouse, the warehouse defined in the Warehouse Master file appears in this field and cannot be changed.

**FIFO DATE (FDATE)**. This is the date the item was received in stock. This field appears only if you chose the FIFO date option during application tailoring.

\*NOT A QC ITEM\* appears under the **FIFO DATE** field if QC control is not applicable to this item.

**Description (ITDSC)**. The description of the item that appears on invoices, inquiries, and reports. This field appears below the **ITEM** field but has no heading.

When you press **Enter** on displays AMIWA1 or AMIWA2, the following fields appear:

**LOCATION (LLOCN)**. The stock location code from the Location Detail file.

**QUANTITY (LQNTY)**. The number of items in each location.

**BATCH/LOT (ALOT1)**. The batch or lot number of the items.

**DATE (First-In-First-Out Date) (DDATE)**. The date the item was received in the corresponding location. If you did not choose the FIFO date option during application tailoring, do not use this field.

**TOTAL APPROVED**. The total quantity of the item that is available at the specified warehouse, whose QC type code is 1.

**INITIAL INSPECT RQD**. The total quantity of the item that is unavailable at the specified warehouse because it is waiting for inspection on receipt. QC type code for these items is 7 or 9.

**SHELF LIFE EXPIRED**. The total quantity of the item that is unavailable at the specified warehouse because the shelf life of the item has expired. QC type code is 6.

**REJECTED**. The total quantity of the item that is unavailable at the specified warehouse because the item is rejected. QC type code is 8.

## AMIWA3—All Lots Approved and Not Approved (Inquiry)

Use this display to see location information for the item and warehouse selected. The display shows this information for both QC approved and not approved lots, as well as for non-QC items.

This display appears when you enter a non-QC item number on display AMIWA1 or select **F05** from the QC Approved Lots Only (Inquiry) display (AMIWA2).

```

DATE **/**/**          ALL LOTS APPROVED AND NOT APPROVED   INQUIRY    AMIWA3  **

      ITEM  aaaaaaaaaaaaA15           WH  aA3           FIFO DATE  nnnnnn
*****
LOCATION  QUANTITY  BATCH/LOT  DATE  LOCATION  QUANTITY  BATCH/LOT  DATE
*****
*****
*****
*****
*****
*****
*****
*****
*****
*****

TOTAL APPROVED          **, **, **, ***
INITIAL INSPECT RQD    **, **, **, ***
SHELF LIFE EXPIRED    **, **, **, ***
REJECTED               **, **, **, ***
* NOT APPROVED

F02 PAGE FORWARD
F03 PAGE BACKWARD
F06 QC APPROVED LOTS
F24 END OF JOB

```

### What to do

- To see detail information for another non-QC item, type in that item number, warehouse code, and FIFO date (if FIFO control is active) and press **Enter**. This display appears again with the information you requested.
- To see location information for QC approved lots only, use **F05**. Go back to display AMIWA2.

### Function keys

F02 PAGE FORWARD causes successive pages of location information to appear until the message END appears. Pressing **F02** after the END message appears causes the first page of location information to appear again.

F03 PAGE BACKWARD shows you the previous page of location information if more than one page exists. When you reach the first page, **F03** has no effect.

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F06 QC APPROVED LOTS (QC items only) causes the QC Approved Lots Only (Inquiry) display (AMIWA2) to appear.

F24 END OF JOB causes the Inquiry menu to appear again.

## **Fields**

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

Refer to “AMIWA2—QC Approved Lots Only (Inquiry)” for an explanation of the fields on this display.

---

## Option 5. Work With Item/Line (AMQM10)

Use this option to review operation and component information for an item produced on a specific production line.

### Item/Line panels

**AMQWIL01** Work with Item/Line Definitions  
**AMQSIL00** Subset Item/Line Definitions  
**AMQAIL01** Create Item/Line Definition  
**AMQCIL01** Change Item/Line Definition  
**AMQRIL01** Confirm Delete of Item/Line Definitions  
**AMQDIL01** Display Item/Line Definition

### Component/Line panels

**AMQWCL01** Work with Component/Line Definitions  
**AMQSCL00** Subset Component/Line Definitions  
**AMQCCL01** Change Component Line Item Definition  
**AMQCCL02** Mass Change

See Chapter 9, "Work with Repetitive" for more information on using the Work With panels.



---

## Option 6. Production Facility (AMQM10)

Use this option to see the information from the Production Facility Master file for production lines, work stations, and work centers. You can show the standard costs, the standard capacity hours, and the variable capacity hours which have been assigned. A facility ID is required.

This option is not available if EPDM is activated.

**What information you need:** The identifier (ID) for each facility you want to see.

**What reports are printed:** None.

**What forms you need:** None.

The basic steps to inquire about production facilities follow each display.

### AMVD60—Production Facility Inquiry (Select)

Use this display to select a facility record for review.

This is the first display that appears when you select option 5 from the PDM Inquiry menu (AMEM02) or option 6 from the REP Inquiry menu (AMQM10), if EPDM is not activated. It also appears when you select option 5 from the CRP Planning Run Control menu (AMTM10), option 4 from the PC&C Inquiry menu (AMCM10) or option 3 from the PM&C Inquiry menu (AMJM10), if EPDM is not activated.

```
DATE **/**/**          PRODUCTION FACILITY INQUIRY          SELECT          AMVD60  **
FACILITY ID          aaaA5

F24 END OF JOB
```

#### What to do

To inquire about production facilities defined in the Production Facility file, type in a facility ID and press **Enter**. Go to display AMVD62.

## Function keys

F24 END OF JOB ignores the data you just entered and causes the menu to appear again.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**FACILITY ID (WKCTR) [?]**. Required. Type in the unique identification representing the facility being reviewed.

## AMVD61—Production Facility Inquiry

Use this display to review detailed information for the facility identified on display AMVD60.

This display appears when you type a valid ID on display AMVD60.

Examples of information shown on the display include facility type, foreman, location, standard and average efficiency, queue time, standard and actual average output, current and standard rates, lengths and capacities for three shifts, and machine and labor resource numbers.

DATE **/**/**	PRODUCTION FACILITY INQUIRY					AMVD61 **
FACILITY ID	aaaA5	FACILITY TYPE	*	*****		
DESCRIPTION	*****					
DEPARTMENT	****	PN FAC ACTG CLS	***	QUEUE TIME DAYS	**.**	
FOREMAN	***	PRIME LOAD CODE	*	AVG QUEUE TIME	*****	
LOCATION	*****	TRACKING SIGNAL	*****	QUEUE MAD	*****	
STD EFFICIENCY	*.**	AVG STD OUTPUT	*****	MACH RESOURCE NO.	*****	
AVG EFFICIENCY	*.**	AVG ACTL OUTPUT	*****	LABOR RESOURCE NO.	*****	
EXTRACT MACH BRKS	*	REPORTING METHOD	*	CLOCKING WINDOW	*:**	
	MACHINE	RUN LABOR	SETUP LABOR	OVERHEAD	OVERHEAD	
	RATE	RATE	RATE	RATE/PERCENT	CODE	
CURRENT	**,**.*	**,**.*	**,**.*	**,**.*	*	
STANDARD	**,**.*	**,**.*	**,**.*	**,**.*	*	
	-----LENGTH-----	-----CAPACITY-----		DIRECT USAGES *		
	DESIRED MAXIMUM	DESIRED	MAXIMUM	CALENDAR NAME *****		
SHIFT 1	**.* **.*	**.*	**.*	POST TO OLDEST SCHED *		
SHIFT 2	**.* **.*	**.*	**.*	POST TO FUTURE SCHED *		
SHIFT 3	**.* **.*	**.*	**.*	FACILITY STOCK LOC *****		
**	F02 VARIABLE CAPACITY F24 END OF JOB					

## What to do

- To look at variable capacity information for this facility, use **F02**. Go to display AMVD62.

**Note:** If REP and/or CRP are not installed and interfacing, **F02** does not appear on the display.

- To look at another production facility record, type in the facility ID and press **Enter**. This display appears again with information for that production facility.

## Function keys

F02 VARIABLE CAPACITY. If REP or CRP is interfacing, the Production Facility Inquiry–Variable Capacity display (AMVD62) appears with variable capacity information for this facility.

F24 END OF JOB causes the menu to appear again.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**FACILITY ID (WKCTR) [?]**. Required. When you have completed reviewing the detail for this facility, you can type in the ID of the next facility you want to see.

**FACILITY TYPE**. This field has no heading and appears to the immediate right of **FACILITY ID**. It shows the type of facility this is, such as WORK CENTER, WORK STATION, or PRODUCTION LINE.

**DESCRIPTION (WCDSC)**. The name of the facility.

**DEPARTMENT (DPTNO)**. The department number associated with the facility.

**PN FAC ACTG CLS (PFAC)**. Class, defined by your company, to group or classify orders or items by production facility for accounting purposes.

**QUEUE TIME DAYS (STDQT)**. The expected number of days a job may wait at the facility before being started.

**FOREMAN (FRMAN)**. A three-character code that identifies the facility foreman.

**PRIME LOAD CODE (PLOAD)**. The critical operation time factor used in scheduling routines.

**AVG QUEUE TIME (AVGQT)**. The average total standard hours of work in the queue at this facility.

**LOCATION (WCLOC)**. The facility location.

**TRACKING SIGNAL (TRSIG)**. The sum of the deviation of the current queue from the old average queue.

**QUEUE MAD (Queue Mean Absolution Deviation) (WQMAD)**. The Queue Mean Absolute Deviation—an average of the differences between the current queue and the old average queue.

**STD EFFICIENCY (Standard Efficiency) (STDEF)**. This field shows the expected efficiency of the facility. The percentage is manually maintained and reflects the expected value of standard average output divided by average actual output.

**AVG STD OUTPUT (Average Standard Output) (AVGSO)**. The expected average of the standard time (hours) produced per day for this period (PC&C order closeout) at the facility.

**MACH RESOURCE NO. (Machine Resource Number) (MACRN).** The resource number used by MPSP (if installed and interfacing) to identify machine hours in a facility as a critical resource. For example, a machine that affects major work flow in a facility.

**AVG EFFICIENCY (Average Efficiency) (AVGEF).** The average of the standard output per day for this period divided by actual hours worked per day for this period.

**AVG ACTL OUTPUT (Average Actual Output) (AVGHO).** The average of the hours actually worked per day for this period (PC&C order closeout) at the facility.

**LABOR RESOURCE NO. (LABRN).** The resource number used by MPSP (if installed and interfacing) to identify labor hours in a facility as a critical resource. For example, it may show a facility with limited available labor hours because of workers with special skills.

**EXTRACT MACH BRKS (BRKXT) <1/0>.** Indicates whether PM&C is extracting break time from machine hours. This field appears only if PM&C is interfacing.

**REPORTING METHOD.** The method used at the facility for reporting job transactions in PM&C. The values for the methods are:

- 0** ON/OF reporting. Both ON (On) and OF (Off) transactions are required for each job. Jobs completed without both transactions are flagged as errors.
- 1** Off-only reporting with full ON override. OF transactions are required for each job. ON transactions are optional. If a job starts with an ON transaction, all information is used from the ON transaction. If an ON transaction does not exist, start times for the job are calculated from previous OF and T/A transactions and all other information is used from the OF transaction.
- 2** Off-only reporting with ON facility ID override. OF transactions are required for each job. ON transactions are optional. If the job starts with an ON transaction, the only information used from the ON transaction is the facility ID. All other information is used from the OF transaction. Start times are always calculated from previous OF and T/A transactions (even if an ON transaction exists).

**CLOCKING WINDOW.** The clocking window time defined in PM&C for facilities using off-only reporting to group jobs that are run concurrently by the same employee and apportion time among those jobs. It can be any value from 0:00 to 9:59 (one second less than ten minutes). A value of 0:00 indicates that jobs at this facility are treated as if they are done consecutively.

This field is used by the Production Monitoring and Control (PM&C) application.

**CURRENT MACHINE RATE (CMACH).** This rate, expressed in cost per hour, is used only by PDM product costing with the run machine field of the associated routing to calculate current run machine cost.

**CURRENT RUN LABOR RATE (CRLAB).** This rate, expressed in cost per hour, is used only by PDM product costing with the run labor field of the associated routing to calculate current run labor cost.

**CURRENT SETUP LABOR RATE (CSLAB).** This rate, expressed in cost per hour, is used only by PDM product costing with the setup labor hours field of the associated routing to calculate current setup labor costs.

**CURRENT OVERHEAD RATE/PERCENT (COVER).** This value, expressed in cost per hour or percent depending on the current labor overhead code, is used only by PDM product costing in labor overhead calculation.

**CURRENT OVERHEAD CODE (COCOD).** This code indicates which of four methods is used only by PDM product costing to calculate current labor overhead.

**STANDARD MACHINE RATE (SMACH).** This rate, expressed in cost per hour, is used by PC&C order costing and PDM product costing with the run machine field of the associated operation detail and routing to calculate standard run machine cost.

**STANDARD RUN LABOR RATE (SRLAB).** This rate, expressed in cost per hour, is used by PC&C order costing and PDM product costing with the run labor field of the associated operation detail and routing to calculate standard run labor cost.

**STANDARD SETUP LABOR RATE (SSLAB).** This rate, expressed in cost per hour, is used by PC&C order costing and PDM product costing with the setup labor time field and setup crew size of the associated operation detail and routing to calculate standard setup labor cost.

**STANDARD OVERHEAD RATE/PERCENT (SOVER).** This value, expressed in cost per hour or percent according to the standard labor overhead code, is used in labor overhead calculation by PC&C order costing and PDM product costing.

**STANDARD OVERHEAD CODE (SOCOD).** This code indicates which of four methods is used to calculate standard labor overhead.

**DESIRED LENGTH (DLEN1, DLEN2, DLEN3).** The number of prime load code hours normally available for the duration of shifts 1, 2, and 3 for this facility.

**MAXIMUM LENGTH (MLEN1, MLEN2, MLEN3).** The maximum number of prime load code hours available for this facility that can be scheduled for shifts 1, 2, and 3.

**DESIRED CAPACITY (DCAP1, DCAP2, DCAP3).** The number of employees or machines normally available in this facility for shifts 1, 2, and 3.

**MAXIMUM CAPACITY (MCAP1, MCAP2, MCAP3).** The maximum number of employees or machines available for shifts 1, 2, and 3.

**DIRECT USAGES (NORWU).** The number of routing records in which the facility appears.

**CALENDAR NAME (CALN).** The name of the production calendar associated with this facility. This calendar is used only by REP to explicitly define the days a production line is available for work.

**POST TO OLDEST SCHED (APSQ).** The method used for applying transaction quantities to REP schedules. The valid codes are:

**blank** Defaults to the setting from the REPCTL record.

**0** Off, posting is by individual schedules for all items on this production line.

**1** On, multi-schedule posting, beginning with the oldest schedule, is used for all items on this production line.



F03 PREVIOUS SCREEN causes the Production Facility Inquiry display (AMVD61) to appear.

F24 END OF JOB causes the menu to appear again.

## Fields

**FACILITY ID (WKCTR).** The identifier for the facility. When you have finished reviewing the detail for this facility or production line, you can type in the ID of the next facility you want to see.

**FACILITY TYPE.** This field shows the kind of production facility that is associated with the facility ID: work center, production line, or work station.

**Note:** A work station cannot have variable capacity information associated with it.

**DESCRIPTION (WCDSC).** A description of this facility.

**START DATE (VDATE).** The date this variable resource becomes available.

**NBR DAYS (VDAYS).** The duration for which the variable resource is available. If the value is 99, this is a permanent resource.

**SHIFT LENGTH 1, 2, and 3 (VLEN1, VLEN2, VLEN3).** The available time in hours of each shift for a particular work center or production line. The variable dates for each shift cannot overlap.

**RESOURCE UNITS 1, 2, and 3 (VCAP1, VCAP2, VCAP3).** The number of extra units above base capacity for this resource. Resource units are expressed in shift length increments such that each resource unit works the entire shift time. For example, if the shift length is 8 hours and you want to add one unit of 4 hours, you type **5** as the resource units to indicate that this resource should work half of the shift length.

**SOURCE DESCRIPTION (VDESC).** The reason for the change to the variable capacity. Examples are Scheduled Overtime or Lead Operator on Vacation.

## Option 7. Item Detail by Location (AMQM10)

Use this option to see information about items stocked at locations at a production line.

**What information you need:** The stock location number.

**What reports are printed:** None.

**What forms you need:** None.

The basic steps to do an Item Detail by Location inquiry follow each display.

### AMIWB1—Item Detail by Location (Select)

Use this display to specify the stock location for the information you want to see. You can enter a production line to see all locations assigned to a production line or to see a specific line location. This display can be used for any location other than quality control or bulk store areas. **F08 SHOW PROD/LINE/STOCK** allows you to rotate this display between production line mode, line location mode, and stock location mode.

This display appears when you select option 10 on the IM Inquiry menu (AMIM10) or option 7 on the REP Inquiry menu (AMQM10).

```

DATE *****          ITEM DETAIL BY LOCATION          SELECT    AMIWB1  **

                                STOCK LOCATION
                                AISLE  BAY  LEVEL  PALLET
                                -----
                                aA3    A2   A2    A    A

STOCK                                F08 SHOW PROD/LINE/
                                F24 END OF JOB
    
```

```

DATE *****          ITEM DETAIL BY LOCATION          SELECT    AMIWB1  **

                                WH      PRODUCTION LINE
                                -----
                                aA3    aaaA5
    
```



DATE *****	ITEM DETAIL BY LOCATION	SELECT	AMIWB1 **
	WH		LINE LOCATION
	aA3		aaaaaA7

### What to do

- To see location detail information, type in the location and press **Enter**. Go to display AMIWB2.
- To alternate between the production line, line location, and stock location modes, press **F08**.

### Function keys

F08 SHOW PROD/LINE/STOCK allows you to alternate between three modes: production line, line location, and stock location. This function key is available when REP and IM are interfacing.

F24 END OF JOB causes the Inquiry menu (AMIM10 or AMQM10) to appear again.

### Fields

**WH (Warehouse Code).** Required. If you have multiple warehouses defined in the Warehouse Master file, type in the code of the warehouse where the item is stocked. If you have only one warehouse, the warehouse defined in the Warehouse Master file appears in this field and cannot be changed.

**aisle.** Required. Type in the stock location row.

**BAY.** Required. Type in the vertical aisle location.

**LEVEL.** Required. Type in the horizontal bay location.

**PALLET.** Required. Type in the pallet code that indicates the lowest division in an individual bay/level combination.

**PRODUCTION LINE.** Required. Type in the production line whose line locations you want to review. This field replaces the stock location fields when this display is in production line mode. Production line mode is available when REP and IM are interfacing.

**LINE LOCATION.** Required. Type in the location at the production line where material is delivered for processing. This field replaces the stock location fields when this display is in line location mode. Line location mode is available when REP and IM are interfacing.

## AMIWB2—Item Detail by Location (Inquiry)

Use this display to see the contents of the selected location.

This display appears when you enter a location on display AMIWB1. If REP is interfacing with IM, three display modes are available: stock location, production line, and line location.

DATE *****	ITEM DETAIL BY LOCATION				INQUIRY	AMIWB2 **	
	WH	STOCK LOCATION					
		AISLE	BAY	LEVEL	PALLET		
	aA3	A2	A2	A	A		
LOCATION		ITEM		QUANTITY	BATCH/LOT	QC TYPE	
****	*****	*****		*,***,***,**	*****	*****	
****	*****	*****		*,***,***,**	*****	*****	
****	*****	*****		*,***,***,**	*****	*****	
F02 PAGE FORWARD							
F08 SHOW PROD/LINE/STOCK							
F24 END OF JOB							

DATE *****	ITEM DETAIL BY LOCATION		INQUIRY	AMIWB2 **
	WH	PRODUCTION LINE		
	aA3	aaaA5		

DATE *****	ITEM DETAIL BY LOCATION		INQUIRY	AMIWB2 **
	WH	LINE LOCATION		
	aA3	aaaaaA7		

### What to do

- To see detail information for another location, type in that location and press **Enter**. This display appears again with the information you requested.
- To alternate between the production line, line location, and stock location modes, press **F08**.

### Function keys

F02 PAGE FORWARD causes the next page of location contents to appear until the message END appears. Pressing **F02** again after the END message appears causes the first page of location contents to appear.

F08 SHOW PROD/LINE/STOCK causes display AMIWB1 to appear again and allows you to alternate between three modes: production line, line location, and stock location. This function key is available when REP and IM are interfacing.

F24 END OF JOB causes the Inquiry menu (AMIM10 or AMQM10) to appear again.

## Fields

The location or line fields appear with information you typed in on the AMIWB1 display. You may type over these fields to review information in a different location or line.

**WH (Warehouse Code).** If you have multiple warehouses defined in the Warehouse Master file, type in the code of the warehouse where the item is stocked. If you have only one warehouse, the warehouse defined in the Warehouse Master file appears in this field and cannot be changed.

**AISLE.** Type in the stock location row.

**BAY.** Type in the vertical aisle location.

**LEVEL.** Type in the horizontal bay location.

**PALLET.** Type in the pallet code that indicates the lowest division in an individual bay/level combination.

**LOCATION (LLOCN).** In stock location mode, the word MAIN followed by the main location you typed in. If there are subdivisions for the main location, the word SUB appears directly under MAIN, followed by each subdivision location.

In production line mode, the word LINE followed by each line location associated with the production line. Production line mode is available when REP and IM are interfacing.

In line location mode, the word LINE followed by the same line location that appears above. Line location mode is available when REP and IM are interfacing.

**ITEM (ITNBR).** The number of the item stored in each location. If the location contains no stock, EMPTY appears.

**QUANTITY (LQNTY).** The quantity of each item stored in the location.

**BATCH/LOT (LBHNO).** The batch or lot number of each item stored in the location.

**QC TYPE (Quality Control Type).** This field appears only if QC control is active. It shows one of the following:

**CHECKED** Inspection not currently required; item is within shelf life.

**N/A** Quality control inspection not applicable for this item.

**QC DUE** Item is waiting for inspection due to expired shelf life.

**WAITING** Item is waiting for inspection on receipt.

**REJECT** Item is rejected, waiting for disposal or rework.

**PRODUCTION LINE.** Type in the production line whose line locations you want to review. This field replaces the stock location fields when this display is in production line mode. Production line mode is available when REP and IM are interfacing.

**LINE LOCATION.** Type in the location at the production line where material is delivered for processing. This field replaces the stock location fields when this display is in line location mode. Line location mode is available when REP and IM are interfacing.

## Option 8. Transaction History (AMQM10)

Use this option to see information in the Transaction History file and the Restored Transaction History file.

**What information you need:**

- The type of inquiry you want to use
- The date sequence: ascending or descending by posting date within warehouse
- The item number, order number, warehouse, batch/lot number, transaction type, and date range for the transactions you want to see. Some displays require the item number; others require the order number. The remaining fields are optional.

**What reports are printed:** None.

**What forms you need:** None.

The basic steps to inquire about transaction history follow each display.

### AMIS11—Transaction History–Inquiry Selection (Select)

Use this display to select the kind of inquiry you want to see and a date sequence for the transactions.

This display appears when you select option 1 on the IM menu or option 8 on the REP Inquiry menu (AMQM10).

```
DATE **/**/**          TRANSACTION HISTORY          SELECT    AMIS11  **
                        INQUIRY SELECTION

                        SELECT INQUIRY          n
                        1  ITEM NUMBER
                        2  ITEM NUMBER AND BATCH/LOT
                        3  ORDER/SCHEDULE NUMBER
                        4  PRODUCTION LINE

                        DATE SEQUENCE          n
                        1  ASCENDING
                        2  DESCENDING

                                                F24 END OF JOB
```

**What to do**

To select the kind of inquiry to review, type in a number from 1 to 4 and the date sequence and press **Enter**. Go to display AMIS12 for item number inquiry, display

AMIS13 for item number and batch/lot inquiry, display AMIS14 for order schedule inquiry, or display AMIS19 for production line inquiry.

### Function keys

F24 END OF JOB causes the menu to appear again.

### Fields

**SELECT INQUIRY.** Required. Type in the number for the kind of inquiry:

- 1 Item number. Transaction history by item number.
- 2 Item number and batch/lot. Transaction history by item number and batch/lot.
- 3 Order/schedule number. Transaction history by order number. If REP is installed and interfacing, you can choose orders or schedules.
- 4 Production line. Transaction history by production line. This option is only available if REP is installed and interfacing.

**DATE SEQUENCE.** Required. Type in the number for the kind of posting date sequence to use in transaction history inquiries:

- 1 Transactions arranged in ascending posting date within warehouse sequence (earliest date first)
- 2 Transactions arranged in descending posting date within warehouse sequence (latest date first)

## AMIS12—Transaction History—Summary by Item (Inquiry)

Use this display to select the transactions you want to see.

This display appears when you type **1** in the **SELECT INQUIRY** field on the Transaction History Inquiry Selection (Select) display (AMIS11).

```
DATE **/**/**          TRANSACTION HISTORY          INQUIRY  AMIS12  **
                        SUMMARY BY ITEM

ITEM aaaaaaaaaaaaA15
WAREHOUSE  aA3
DATE FROM  nnnnnn  TO  nnnnnn

F19 RETURN TO SELECT
F24 END OF JOB
```

### What to do

To select transactions to review, type in the item number and, optionally, the warehouse and date range and press **Enter**. Go to display AMIS15.

### Function keys

F19 RETURN TO SELECT causes the Transaction History Inquiry Selection (Select) display (AMIS11) to appear.

F24 END OF JOB ignores any data you typed on this display and causes the menu to appear again.

### Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**ITEM (ITNBR) [?]**. Required. Type in the item number for the transaction information.

**WAREHOUSE (HOUSE)**. If you have multiple warehouses defined in the Warehouse Master file, type in the code of the warehouse associated with the item. Leave this field blank to see transactions for all warehouses for the selected item. If you have only one warehouse, the warehouse defined in the Warehouse Master file appears in this field and cannot be changed.

**DATE FROM/TO.** Type in the posting date limits for the transactions:

- Leave the **FROM** field blank to start with the earliest transaction in the file.
- Leave the **TO** field blank to include the latest transaction in the file.
- Leave both fields blank to see transactions for all dates.
- Type in the same date for both fields to see transactions posted only on that date.

## AMIS15—Transaction History—Summary by Item (Inquiry)

Use this display to review transactions from the Transaction History file.

This display appears when you do one of the following:

- Enter a valid item number and, optionally, warehouse and date range on display AMIS12
- Enter a valid item number and, optionally, warehouse and date range on this display (AMIS15)
- Press **Enter** on display AMIS18.

```

DATE **/**/**          TRANSACTION HISTORY          INQUIRY  AMIS15  **
                          SUMMARY BY ITEM
ITEM aaaaaaaaaaA14      *****
WAREHOUSE  aA3  LOCATION *****
DATE FROM  nnnnnn  TO  nnnnnn
ORD POL *  STK U/M **  PLANNER *****  ENGR DRAWING *****

REF WH  -----TRANSACTION-----
NO. NO  CODE      QUANTITY          UM  -----RESULTING-----

**  ***  **      *, ***, ***, ***-  **  ON-HAND *  ***, ***, ***  ON-ORD *, ***, ***, ***
      ORDER NO. *****              POST DATE **/**/**  ALLOC  *, ***, ***, ***
**  ***  **      *, ***, ***, ***-  **  ON-HAND *  ***, ***, ***  ON-ORD *, ***, ***, ***
      ORDER NO. *****              POST DATE **/**/**  ALLOC  *, ***, ***, ***
**  ***  **      *, ***, ***, ***-  **  ON-HAND *  ***, ***, ***  ON-ORD *, ***, ***, ***
      ORDER NO. *****              POST DATE **/**/**  ALLOC  *, ***, ***, ***
**  ***  **      *, ***, ***, ***-  **  ON-HAND *  ***, ***, ***  ON-ORD *, ***, ***, ***
      ORDER NO. *****              POST DATE **/**/**  ALLOC  *, ***, ***, ***
nn  ENTER REFERENCE NUMBER FOR ADDITIONAL DETAIL
                                          More...
                                          USE ROLL UP/DOWN
                                          F19 RETURN TO SELECT
                                          F24 END OF JOB

```

### What to do

- To see the details of a transaction, type the reference number for the transaction into the **ENTER REFERENCE NUMBER FOR ADDITIONAL DETAIL** field, and press **Enter**. Go to display AMIS18.
- To see history transactions for a different item, warehouse, or date range, type in the new information over the information shown in the heading and press **Enter**. The display appears again with the transaction information requested.

### Function keys

USE ROLL UP/DOWN causes the next or previous page of transactions to appear.



F19 RETURN TO SELECT causes the Transaction History Inquiry Selection (Select) display (AMIS11) to appear.

F24 END OF JOB ignores any data you typed on this display and causes the menu to appear again.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

The **ITEM**, **WAREHOUSE**, and **DATE FROM and TO** fields appear with information you typed on the AMIS12 display. You can type over these fields to display information for a different item, warehouse, or date range. You can also type a reference number in the **ENTER REFERENCE NUMBER FOR ADDITIONAL DETAIL** field. All other fields on this display are informational only.

**ITEM (ITNBR) [?]**. Required. Type in the item number for the transaction information.

**Description (ITDSC)**. The description of the item that appears on invoices, inquiries, and reports. This field appears to the right of the **ITEM** field but has no heading.

**TYPE (Item Type Code) (ITTYP)**. The item type code that best describes the item. The available codes are:

<b>0</b>	Phantom
<b>1</b>	Assembly or subassembly
<b>2</b>	Fabricated item
<b>3</b>	Raw material
<b>4</b>	Purchased item
<b>9</b>	User option
<b>F</b>	Feature
<b>K</b>	Kit

**CLS (Item Type Class) (ITCLS)**. The user-assigned code that describes the classification to which this item belongs. For example, ST might be used to code all items made of steel.

**MLI (Master Level Item Code) (MLICD)**. This field may contain one of the codes used by MRP (if installed and interfacing) to indicate whether this item is a Master Level Item and, if so, which requirements to use when planning orders for it.

**WAREHOUSE (HOUSE)**. If you have multiple warehouses defined in the Warehouse Master file, type in the code of the warehouse associated with the item. Leave the field blank to see transactions for all warehouses for the selected item. If you have only one warehouse, the warehouse defined in the Warehouse Master file appears in this field and cannot be changed.

**LOCATION (WHS LC)**. The user-defined code indicating the location of the item in the controlled warehouse.

**DATE FROM/TO**. Type in the posting date limits for the transactions.

- Leave the **FROM** field blank to start with the earliest transaction in the file.
- Leave the **TO** field blank to include the latest transaction in the file.
- Leave both fields blank to see transactions for all dates.
- Type in the same date for both fields to see transactions posted only on that date.

**ORD POL (Order Policy Code) (ORDPC).** A code identifying the order policy used to plan replenishment orders for this item. The available codes are:

- A** Discrete order quantity
- B** Order point, order quantity
- C** Order point, order up to level
- D** Fixed quantity
- F** Part-period balancing – standard cost
- G** Time periods of supply
- H** Discrete above a minimum quantity
- I** Part-period balancing – current cost see F above
- Z** User option

**STK U/M (Stocking Unit of Measure) (UNMSR).** A user-assigned code that defines the measurement basis of on hand quantity and issue quantity for this item; for example, EA (each), KG (kilogram), or CM (centimeter).

**PLANNER (PLANN).** Number assigned by your company to identify the person responsible for planning the replenishment strategy for this item. MRP and MPSP use this field as a limit for selection and for sequencing Order Status reports.

**ENGR DRAWING (Engineering Drawing Number) (ENGNO).** The item's engineering drawing number.

The following fields make up the body of the display:

**REF NO. (Reference Number).** A unique number assigned by the system to each of the transactions shown. You can enter this number in the **ENTER REFERENCE NUMBER FOR ADDITIONAL DETAIL** field to see further information about this transaction.

**WH NO (Warehouse Number) (CITWH).** The warehouse in which this transaction took place.

**TRANSACTION CODE (TCODE).** A two-letter code for the type of inventory transaction. If the transaction code is preceded by an R, the displayed information is for a reversal transaction and processed in immediate update. The codes available are:

**Issue Transactions.**

- IP** Planned Manufacturing Issue. Used to report individual component issues to manufacturing orders.
- IS** Miscellaneous Issue. Used to report issues that are not charged to customer or manufacturing orders.
- IU** Unplanned Component Issue. Used to add a component to a manufacturing order and create an issue transaction.
- IW** Interwarehouse Issue. Used to report issues to another warehouse.
- IX** Uncontrolled floor stock. Used to report uncontrolled floor stock issues.
- MI** Miscellaneous Item Issue. Used to report issues of miscellaneous items.
- PB** Pick Complete by Item. Used to report the pick completion of an item (bulk pick).

- PC** Pick Complete by Order. Used to report that all components of an order have been picked.
- VR** Purchase Return to Vendor. Used by Purchasing (if installed and interfacing) to report that purchased items were returned to the vendor.

***Receipt Transactions.***

- MR** Miscellaneous Item Receipt. Used to report receipts for miscellaneous items.
- RC** Miscellaneous Receipt. Used to report receipts for items that do not have open orders.
- RD** Purchase Order Receipt to Dock. Used to report receipt of purchased items at the dock.
- RI** Purchase Order Receipt to Inspection. Used to report movement of a purchased item from the dock to inspection.
- RM** Production Receipt. Used to report an item receipt from production.
- RP** Purchase Order Receipt to Stock. Used to report receipt of purchased items to stock.
- RW** Interwarehouse Receipt. Used to report receipts from other warehouses.

***Cost Transactions.***

- CA** Cost Adjustment. Used to recalculate the average unit cost and to replace the last unit cost of an item.
- CR** Average Cost Replacement. Used to change the average unit cost of an item.
- CS** Standard Cost Replacement. Used to change the standard unit cost of an item.
- CU** Standard unit cost default replacement. Used to change the unit cost default for an item.

***Scrap Transactions.***

- SC** Manufactured Component Scrap. Used to report component items that have been scrapped on a manufacturing order or schedule.
- SM** Manufacturing Order Scrap. Used to report the scrapping of partially completed end items.
- SP** Purchase Order Scrap. Used to report items that have been scrapped on a purchase order.
- SS** Scrap From Stock. Used to report items that have been scrapped from stock.

***Quality Control Transactions.***

- CQ** Cyclic Item QC Complete. Used to report QC check complete for cyclic items.
- MQ** Manufactured Item QC Complete. Used to report QC check complete for manufactured items.
- PQ** Purchase Item QC Complete. Used to report QC check complete for purchase items.
- RQ** Reject Item QC Complete. Used to report QC check complete for rejected items.
- SQ** QC Status Change. Used to report a change in the QC status of an item.

***Maintenance Transactions.***

- IA** Inventory Adjustment. Used to adjust the on-hand balance of an item.
- LA** Location Addition. Used to report the addition of an item to a location.
- LQ** Batch/Lot Number Change. Used to report a change in the batch/lot number.
- PH** Physical Inventory Adjustment. Used to report changes to on-hand balances in the Item Balance and Location Quantity files.

***Miscellaneous Transactions.***

- OP** Purchase Routing Null Transaction. Used to update purchase order routings.
- RS** Component Return to Stock. Used to report the return of a previously issued component item to stock.
- SA** Sales Shipment. Used to report sales shipments.
- TW** Interwarehouse Transfer. Used to complete both the issue and receipt of an interwarehouse transfer.
- VA** Purchase Order Vendor Accept. Used by Purchasing (if installed and interfacing) to report that the vendor has accepted the terms of a purchase order.

***Repetitive Production Management (REP) Transactions.***

- CL** Component Transfer to Line. Used by REP to report the movement of components to the production line.
- CN** Component Return to Stores. Used by REP to report the return of components to the warehouse.
- PS** Production Status. User-defined method to report production statistics, such as production line down-time.
- RLL** Replenishment by Location. Used by REP to report the issue of components by line location, for replenishment.
- RLS** Replenishment by Schedule. Used by REP to report the issue of components by schedule, for replenishment.
- RM** Schedule Receipt. Used to report a schedule item complete.
- RO** Operation Reporting. Used to report completion of an operation for the scheduled item.
- SC** Manufactured Component Scrap. Used to report component items that have been scrapped on a manufacturing order or schedule.
- SM** Schedule Scrap. Used to report the scrapping of a schedule item.

***TRANSACTION QUANTITY (TRQTY).*** The quantity of this transaction.

***TRANSACTION UM (Transaction Unit of Measure) (ENTUM).*** The unit of measure for the item entered with this transaction. If no unit of measure was entered, the stocking unit of measure (STKUM) appears.

***ORDER NO. (Order Number) (ORDNO).*** The number of the purchase, manufacturing, customer order, or schedule associated with this transaction.

If COM is installed and interfacing with IM, a customer order number includes the company number and order type of the associated customer order.

**POST DATE (UPDDT).** The date when this transaction was posted, changing the computer's on hand balance for the item.

**RESULTING ON-HAND (NUQOH).** The quantity of this item that remained in stock after this transaction was posted.

**RESULTING ON-ORD (NUQOO).** The total quantity of this item that was on open purchase or manufacturing orders after this transaction was posted.

**RESULTING ALLOC (NUALC).** The total quantity of this item allocated for both manufacturing orders and sales order picking lists after this transaction was posted.

**ENTER REFERENCE NUMBER FOR ADDITIONAL DETAIL.** To see more detail, type in the reference number of the transaction.

## AMIS13—Transaction History—Summary by Item and Batch/Lot (Inquiry)

Use this display to inquire into the Transaction History file by item number. You can also enter other information, including batch or lot number, to limit the transactions you see.

This display appears when you type **2** in the **SELECT INQUIRY** field on the Transaction History Inquiry Selection (Select) display (AMIS11).

```
DATE **/**/**          TRANSACTION HISTORY          INQUIRY  AMIS13  **
                        SUMMARY BY ITEM AND BATCH/LOT
ITEM aaaaaaaaaaaaaA15
WAREHOUSE  aA3          BATCH/LOT aaaaaaaA10      TRANSACTION CODE  A2
DATE FROM  nnnnnn  TO  nnnnnn

F19 RETURN TO SELECT
F24 END OF JOB
```

### What to do

To review the transaction history for an item, type in the item number and any other information needed, and press **Enter**. Go to display AMIS16.

### Function keys

F19 RETURN TO SELECT causes the Transaction History Inquiry Selection (Select) display (AMIS11) to appear.

F24 END OF JOB ignores any data you typed on this display and causes the menu to appear again.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**ITEM (ITNBR) [?]**. Required. Type in the item number for the transaction information.

**WAREHOUSE (HOUSE)**. If you have multiple warehouses defined in the Warehouse Master file, type in the code of the warehouse associated with the item. Leave the field blank to see transactions for all warehouses for the selected item. If you have only one warehouse, the warehouse defined in the Warehouse Master file appears in this field and cannot be changed.

**BATCH/LOT (LBHNO)**. Type in the batch or lot number for the transaction information. Leave the field blank to see transactions for all batch/lots for the item.

**TRANSACTION CODE (TCODE)**. Type in the two-letter code for the type of transaction information. Leave the field blank to see all transaction types for the item. For a description of the available codes, see the explanation of display AMIS15 earlier in this section.

**DATE FROM/TO**. Type in the posting date limits for the transactions:

- Leave the **FROM** field blank to start with the earliest transaction in the file.
- Leave the **TO** field blank to include the latest transaction in the file.
- Leave both fields blank to see transactions for all dates.
- Type in the same date for both fields to see transactions posted only on that date.

## AMIS16—Transaction History—Summary by Item and Batch/Lot (Inquiry)

Use this display to review transactions from the Transaction History file.

This display appears when you:

- Enter a valid item number and, optionally, other information on display AMIS13
- Enter a valid item number and, optionally, other information on this display (AMIS16)
- Press **Enter** on display AMIS18.

```

DATE **/**/**                TRANSACTION HISTORY                INQUIRY  AMIS16  **
                               SUMMARY BY ITEM AND BATCH/LOT
ITEM aaaaaaaaaaaaA15          ***** TYPE *  CLS **** MLI *
WAREHOUSE aa3                 BATCH/LOT aaaaaaaA10    TRANSACTION CODE A2
DATE FROM nnnnnn TO nnnnnn
ORD POL *  STK U/M **  PLANNER ***** ENGR DRAWING *****

R/ TR POSTING ORDER          WAREHOUSE          U/          CMP
/N CD DATE NO NO/LOCN QUANTITY /M BATCH/LOT CD REFERENCE
** ** **/**/** ***** ** ***** ***** ** ** ***** * *****
** ** **/**/** ***** ** ***** ***** ** ** ***** * *****
** ** **/**/** ***** ** ***** ***** ** ** ***** * *****
** ** **/**/** ***** ** ***** ***** ** ** ***** * *****
** ** **/**/** ***** ** ***** ***** ** ** ***** * *****
** ** **/**/** ***** ** ***** ***** ** ** ***** * *****
** ** **/**/** ***** ** ***** ***** ** ** ***** * *****
** ** **/**/** ***** ** ***** ***** ** ** ***** * *****
** ** **/**/** ***** ** ***** ***** ** ** ***** * *****
** ** **/**/** ***** ** ***** ***** ** ** ***** * *****
** ** **/**/** ***** ** ***** ***** ** ** ***** * *****
** ** **/**/** ***** ** ***** ***** ** ** ***** * *****
** ** **/**/** ***** ** ***** ***** ** ** ***** * *****
** ** **/**/** ***** ** ***** ***** ** ** ***** * *****
nn ENTER REFERENCE NUMBER FOR ADDITIONAL DETAIL
                                                    More...
                                                    USE ROLL UP/DOWN
                                                    F19 RETURN TO SELECT
                                                    F24 END OF JOB

```

### What to do

- To see the details of a transaction, type the reference number for the transaction into the **ENTER REFERENCE NUMBER FOR ADDITIONAL DETAIL** field, and press **Enter**. Go to display AMIS18.
- To see the transactions for a different item, warehouse, batch/lot, transaction type, or date range, type in the new information over the information shown in the heading and press **Enter**. The display appears again with the transaction information requested.

### Function keys

USE ROLL UP/DOWN causes the next or previous page of transactions to appear.

F19 RETURN TO SELECT causes the Transaction History Inquiry Selection (Select) display (AMIS11) to appear.

F24 END OF JOB ignores any data you typed on this display and causes the menu to appear again.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

The **ITEM**, **WAREHOUSE**, **BATCH/LOT**, **TRANSACTION CODE**, and **DATE FROM and TO** fields appear with information you typed on the AMIS13 display. You can type over these fields to display information for a different item, warehouse, batch/lot, transaction code, or date range. You can also type a reference number in the **ENTER REFERENCE NUMBER FOR ADDITIONAL DETAIL** field. All other fields on this display are informational only.

**ITEM (ITNBR) [?]**. Required. Type in the item number for the transaction information.

**Description (ITDSC)**. This field appears to the right of the **ITEM** field but has no heading. It shows the description of the item that appears on invoices, inquiries, and reports.

**TYPE (Item Type Code) (ITTYF)**. The item type code that best describes the item. The available codes are:

<b>0</b>	Phantom
<b>1</b>	Assembly or subassembly
<b>2</b>	Fabricated item
<b>3</b>	Raw material
<b>4</b>	Purchased item
<b>9</b>	User option
<b>F</b>	Feature
<b>K</b>	Kit

**CLS (Item Type Class) (ITCLS)**. The user-assigned code that describes the classification to which this item belongs. For example, ST might be used to code all items made of steel.

**MLI (Master Level Item Code) (MLICD)**. One of the codes used by MRP (if installed and interfacing) that indicate whether this item is a Master Level Item and, if so, the requirements to use when planning orders for it.

**WAREHOUSE (HOUSE)**. If you have multiple warehouses defined in the Warehouse Master file, type in the code of the warehouse associated with the item. Leave the field blank to see transactions for all warehouses for the selected item.

If you have only one warehouse, the warehouse defined in the Warehouse Master file appears in this field and cannot be changed.

**BATCH/LOT (Batch or Lot Number) (LBHNO)**. Type in the batch or lot number for the transaction information. Leave the field blank to see information for all batch/lots for the item. When an item is defined as having batch/lot control, all transactions involving that item must carry the batch/lot number.

**TRANSACTION CODE (TCODE)**. Type in the two-letter code for the type of transaction information. Leave the field blank to see all types of transactions for the item. For a description of the transaction codes available, see "AMIS15—Transaction History—Summary by Item (Inquiry)".



**DATE FROM/TO.** Type in the posting date limits for the transactions:

- Leave the **FROM** field blank to start with the earliest transaction in the file.
- Leave the **TO** field blank to include the latest transaction in the file.
- Leave both fields blank to see transactions for all dates.
- Type in the same date for both fields to see transactions posted only on that date.

**ORD POL (Order Policy Code) (ORDPC).** A code that identifies the order policy to be used to plan replenishment orders for this item. The available codes are:

<b>A</b>	Discrete order quantity
<b>B</b>	Order point, order quantity
<b>C</b>	Order point, order up to level
<b>D</b>	Fixed quantity
<b>F</b>	Part-period balancing – standard cost
<b>G</b>	Time periods of supply
<b>H</b>	Discrete above a minimum quantity
<b>I</b>	Part-period balancing – current cost see F
<b>Z</b>	User option

**STK U/M (Stocking Unit of Measure) (UNMSR).** A user-assigned code that defines the measurement basis of on hand quantity and issue quantity for this item; for example, EA (each), KG (kilogram), or CM (centimeter).

**PLANNER (PLANN).** Number assigned by your company to identify the person responsible for planning the replenishment strategy for this item. MRP and MPSP use this field as a limit for selection and for sequencing Order Status reports.

**ENGR DRAWING (Engineering Drawing Number) (ENGNO).** The item's engineering drawing number.

The following fields make up the body of the display:

**R/N (Reference Number).** A unique number assigned by the system to each of the transactions shown. You can enter this number in the **ENTER REFERENCE NUMBER FOR ADDITIONAL DETAIL** field to see further information about this transaction.

**TR CD (Transaction Code) (TCODE).** The two-letter code for the type of inventory transaction. For a description of the transaction codes available, see "AMIS15—Transaction History—Summary by Item (Inquiry)".

**POSTING DATE (UPDDT).** The date when this transaction was posted, changing the application's on-hand balance for the item.

**ORDER NO (ORDNO).** The number of the purchase, manufacturing, or customer order related to this transaction.

If COM is installed and interfacing with IM, a customer order number includes the company number and order type of the associated customer order.

**WAREHOUSE NO/LOCN (CITWH) (WHS LC).** The codes identifying the warehouse and the location within the warehouse of the item used in the transaction.

**QUANTITY (TRQTY).** The quantity of this transaction.

**U/M (Stocking Unit of Measure) (STKUM).** A user-assigned code that defines the measurement basis of on hand quantity and issue quantity for this item; for example, EA (each), KG (kilogram), or CM (centimeter).

**BATCH/LOT (LBHNO).** The number of the batch or lot of the item used in this transaction.

**CMP CD (Completion Code) (CMPCD).** The order completion code. Valid codes are:

- blank** Partial receipt (default)
- C** Order complete
- P** Partial receipt
- R** Reopen order (immediate update only)

**REFERENCE (REFNO).** The user-defined reference code entered with this transaction.

**ENTER REFERENCE NUMBER FOR ADDITIONAL DETAIL.** To see more detail, type in the reference number of the transaction.

## AMIS14—Transaction History—Summary by Order/Schedule (Inquiry)

Use this display to inquire into the Transaction History file by purchase, manufacturing, or customer order numbers. If REP is installed and interfacing, you can also inquire by schedule. You can type in other information to limit the transactions you see.

This display appears when you type **3** in the **SELECT INQUIRY** field on the Transaction History Inquiry Selection (Select) display (AMIS11). This display appears with schedule history only if you gained access to Transaction History from the REP menu AMQVM10.

```
DATE **/**/**          TRANSACTION HISTORY          INQUIRY  AMIS14  **
                        SUMMARY BY SCHEDULE
SCHEDULE  aaaaaA7
ITEM aaaaaaaaaaA15  WAREHOUSE aa3  BATCH/LOT aaaaaaA10  TRANSACTION CODE A2
DATE FROM nnnnnn  TO  nnnnnn
```

```
DATE **/**/**          TRANSACTION HISTORY          INQUIRY  AMIS14  **
                        SUMMARY BY ORDER
ORDER      nn A2 aaaaaA7
ITEM aaaaaaaaaaaaaA15  WAREHOUSE aA3  BATCH/LOT aaaaaaA10  TRANSACTION CODE A2
DATE FROM nnnnnn  TO  nnnnnn
```

```
F19 RETURN TO SELECT
F24 END OF JOB
```

## What to do

- To view the transaction history for an order, type in the order number and any other information needed, and press **Enter**. If COM is installed, type in the company number, order number, and order type. Go to display AMIS17.
- To view a manufacturing, purchase, or schedule order, type in the order number.

## Function keys

F19 RETURN TO SELECT causes the Transaction History Inquiry Selection (Select) display (AMIS11) to appear.

F24 END OF JOB ignores any data you typed on this display and causes the menu to appear again.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**ORDER (ORDNO)**. Required. Type in the purchasing, manufacturing, or customer order number for the transaction information.

If COM is installed and interfacing with IM, a customer order number includes the company number and order type of the associated customer order.

**SCHEDULE (ORDNO)**. Required and appears if REP is installed and interfacing. Type in the schedule number for the transaction information.

**ITEM (ITNBR) [?]**. Type in the number of the item in the order that has transaction information. Leave the field blank to see transaction information for all items in the order.

**WAREHOUSE (HOUSE).** If you have multiple warehouses defined in the Warehouse Master file, type in the code of the warehouse associated with the order number entered above. Leave the field blank to see transactions for all warehouses affected by the order. If you have only one warehouse, the warehouse defined in the Warehouse Master file appears in this field and cannot be changed.

**BATCH/LOT (LBHNO).** Type in the batch or lot number for the transaction information. Leave the field blank to see transactions for all batch/lots for the items on the order.

**TRANSACTION CODE (TCODE).** Type in the two-letter code for the type of transaction information. Leave the field blank to see all transaction types for the items on the order. For a description of the available codes, see the explanation of display AMIS15 earlier in this section.

**DATE FROM/TO.** Type in the posting date limits for the transactions:

- Leave the **FROM** field blank to start with the earliest transaction in the file.
- Leave the **TO** field blank to include the latest transaction in the file.
- Leave both fields blank to see transactions for all dates.
- Type in the same date for both fields to see transactions posted only on that date.

## AMIS17—Transaction History—Summary by Order/Schedule (Inquiry)

Use this display to review transactions from the Transaction History file for selected order numbers or schedules (If REP is interfacing with IM).

This display appears when you do one of the following:

- Enter a valid order number or schedule and, optionally, other information on display AMIS14.
- Enter a valid order number or schedule and, optionally, other information on this display (AMIS17).
- Press **Enter** on display AMIS18.

```

DATE **/**/**          TRANSACTION HISTORY          INQUIRY  AMIS17  **
                        SUMMARY BY SCHEDULE

SCHEDULE  aaaaaA7
ITEM  aaaaaaaaaaaaaA15  WAREHOUSE  aA3  BATCH/LOT  aaaaaaaA10  TRANSACTION CODE  A2
DATE FROM  nnnnnn  TO  nnnnnn
    
```

```

DATE **/**/**          TRANSACTION HISTORY          INQUIRY    AMIS17  **
                          SUMMARY BY ORDER

ORDER    nn A2 aaaaaA7
ITEM aaaaaaaaaaaaaA15  WAREHOUSE aA3 BATCH/LOT aaaaaaA10  TRANSACTION CODE A2
DATE FROM nnnnnn TO nnnnnn

REF TR  POSTING
NO. CD  DATE      ITEM NUMBER      WAREHOUSE      QUANTITY      U/      CMP
      /M BATCH/LOT  CD
** **  **/**/**  *****          **          * , ** , ** . ** - ** ***** *
** **  **/**/**  *****          **          * , ** , ** . ** - ** ***** *
** **  **/**/**  *****          **          * , ** , ** . ** - ** ***** *
** **  **/**/**  *****          **          * , ** , ** . ** - ** ***** *
** **  **/**/**  *****          **          * , ** , ** . ** - ** ***** *
** **  **/**/**  *****          **          * , ** , ** . ** - ** ***** *
** **  **/**/**  *****          **          * , ** , ** . ** - ** ***** *
** **  **/**/**  *****          **          * , ** , ** . ** - ** ***** *
** **  **/**/**  *****          **          * , ** , ** . ** - ** ***** *
** **  **/**/**  *****          **          * , ** , ** . ** - ** ***** *
** **  **/**/**  *****          **          * , ** , ** . ** - ** ***** *
** **  **/**/**  *****          **          * , ** , ** . ** - ** ***** *
** **  **/**/**  *****          **          * , ** , ** . ** - ** ***** *
** **  **/**/**  *****          **          * , ** , ** . ** - ** ***** *
** **  **/**/**  *****          **          * , ** , ** . ** - ** ***** *

nn ENTER REFERENCE NUMBER FOR ADDITIONAL DETAIL
                                           Bottom
                                           USE ROLL UP/DOWN
                                           F19 RETURN TO SELECT
                                           F24 END OF JOB

```

### What to do

- To see the details of a transaction, type the reference number for the transaction into the **ENTER REFERENCE NUMBER FOR ADDITIONAL DETAIL** field, and press **Enter**. Go to display AMIS18.
- To see the transactions for a different order, item, warehouse, batch/lot, transaction type, or date range, type in the new information over the information shown in the heading and press **Enter**. The display appears again with the transaction information requested.

### Function keys

USE ROLL UP/DOWN causes the next or previous page of transactions to appear.

F19 RETURN TO SELECT causes the Transaction History Inquiry Selection (Select) display (AMIS11) to appear.

F24 END OF JOB ignores any data you typed on this display and causes the menu to appear again.

### Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

The **ORDER** or **SCHEDULE**, **ITEM**, **WAREHOUSE**, **BATCH/LOT**, **TRANSACTION CODE**, and **DATE FROM and TO** fields appear with information you typed on the AMIS14 display. You can type over these fields to display information for a different order or schedule, item, warehouse, batch/lot, transaction code, or date range. You can also type a reference number in the **ENTER REFERENCE NUMBER FOR ADDITIONAL DETAIL** field. All other fields on this display are informational only.

**ORDER (ORDNO).** Required. Type in the order number for the transaction information.

If COM is installed and interfacing with IM, a customer order number includes the company number and order type of the associated customer order.

**SCHEDULE (ORDNO).** Required. Type in the schedule number for the transaction information if you perform the inquiry from REP.

**ITEM (ITNBR) [?].** Type in the item number for the transaction information. Leave the field blank to see transactions for all items on the order.

**WAREHOUSE (HOUSE).** If you have multiple warehouses defined in the Warehouse Master file, type in the code of the warehouse associated with the item. Leave the field blank to see transactions for all warehouses.

If you have only one warehouse, the warehouse defined in the Warehouse Master file appears in this field and cannot be changed.

**BATCH/LOT (LBHNO).** Type in the batch or lot number for the transaction information. Leave the field blank to see information for all batch/lots for the items on the order. When an item is defined as having batch/lot control, all transactions involving that item must carry the batch/lot number.

**TRANSACTION CODE (TCODE).** Type in the two-letter code for the type of transaction information. Leave the field blank to see all types of transactions for the items on the order. For a description of all transaction codes available, see the explanation of display AMIS15 earlier in this section.

**DATE FROM/TO.** Type in the posting date limits for the transactions:

- Leave the **FROM** field blank to start with the earliest transaction in the file.
- Leave the **TO** field blank to include the latest transaction in the file.
- Leave both fields blank to see transactions for all dates.
- Type in the same date for both fields to see transactions posted only on that date.

The following fields make up the body of the display:

**REF NO. (Reference Number).** A unique number assigned by the system to each of the transactions shown. You can enter this number in the **ENTER REFERENCE NUMBER FOR ADDITIONAL DETAIL** field to see further information about this transaction.

**TR CD (Transaction Code) (TCODE).** A code for the type of inventory transaction. For a description of the transaction codes available, see the explanation of display AMIS15 earlier in this section.

**POSTING DATE (UPDDT).** The date when this transaction was posted, changing the application's on hand balance for the item.

**ITEM NUMBER (ITNBR).** The number of the item used in this transaction.

**WAREHOUSE NO/LOCN (CITWH) (WHS LC).** A code identifying the warehouse and the location within the warehouse of the item used in the transaction.

**QUANTITY (TRQTY).** The quantity of this transaction.

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**U/M (Stocking Unit of Measure) (STKUM).** A user-assigned code that defines the measurement basis of on hand quantity and issue quantity for this item; for example, EA (each), KG (kilogram), or CM (centimeter).

**BATCH/LOT (LBHNO).** The number of the batch or lot of the item used in this transaction.

**CMP CD (Completion Code) (CMPCD).** The order completion code. Select one of the following codes:

**blank** Partial receipt (default)  
**C** Order complete  
**P** Partial receipt  
**R** Reopen order (immediate update only)

**ENTER REFERENCE NUMBER FOR ADDITIONAL DETAIL.** To see more detail, type in the reference number of the transaction.

## AMIS10—Transaction History—Summary by Line (Inquiry)

Use this display to select the transactions you want to see.

This display appears when you type **4** in the **SELECT INQUIRY** field on the Transaction History Inquiry Selection (Select) display (AMIS11).

Ranges are entered and interpreted as follows:

- If the **FROM** and **TO** fields are blank, then all data is selected.
- If the **FROM** and **TO** fields are both filled in, then data is selected if the record is equal to or greater than the **FROM** value and equal to or less than the **TO** value.
- If the **FROM** field is filled in and the **TO** field is blank, then all data equal to and greater than the **FROM** value is selected.
- If the **FROM** field is blank and the **TO** field is filled in, then all data up to and including the **TO** value is selected.

```
DATE **/**/**          TRANSACTION HISTORY          INQUIRY  AMIS10  **
                        SUMMARY BY LINE

PRODUCTION LINE aaaA5  TRANSACTION CODE A2

DATE FROM  nnnnnn  TO  nnnnnn
```

```
F19 RETURN TO SELECT
F24 END OF JOB
```

### What to do

- To select the transaction to review, type in the production line and, optionally, the transaction code and the posting date limits and press **Enter**. Go to display AMIS19.
- To review only one type of transaction, type in the transaction code.

### Function keys

F19 RETURN TO SELECT causes the Transaction History Inquiry Selection (Select) display (AMIS11) to appear.

F24 END OF JOB ignores any data you typed on this display and causes the menu to appear again.



## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**PRODUCTION LINE (PLINE) [?]**. Required. Type the production line for the transaction you want to review.

**TRANSACTION CODE (TCODES)**. For IM, the transaction types are:

<b>CA</b>	Cost adjustment
<b>CL</b>	Component transfer to line
<b>CN</b>	Component transfer to stores
<b>CR</b>	Average cost replace
<b>CS</b>	Standard cost replace
<b>CU</b>	Standard unit cost default replacement
<b>IA</b>	Inventory adjustment
<b>IP</b>	Planned manufacture issue
<b>IS</b>	Miscellaneous issue
<b>IU</b>	Unplanned component issue
<b>IW</b>	Interwarehouse issue
<b>IX</b>	Uncontrolled floor stock
<b>MQ</b>	Manufacturing item QC complete
<b>PH</b>	Physical inventory update
<b>PQ</b>	Purchase item QC complete
<b>RC</b>	Miscellaneous receipt
<b>RM</b>	Production receipt
<b>RP</b>	P.O. receipt to stock
<b>RQ</b>	Shelf life expired - reject
<b>RS</b>	Component return to stock
<b>RW</b>	Interwarehouse receipt
<b>SA</b>	Sales shipment
<b>SC</b>	Manufacturing component scrap
<b>SM</b>	Manufacturing order scrap
<b>SP</b>	Purchase order scrap
<b>SQ</b>	QC status change
<b>SS</b>	Scrap from stock
<b>VR</b>	Purchase return to vendor

**DATE FROM/TO.** Type in the posting date limits for the transactions:

- Leave the **FROM** field blank to start with the earliest transaction in the file.
- Leave the **TO** field blank to include the latest transaction in the file.
- Leave both fields blank to see transactions for all dates.
- Type in the same date for both fields to see transactions posted only on that date.

## AMIS19—Transaction History—Summary by Line (Inquiry)

Use this display to review transactions from the Transaction History file.

This display appears when you do one of the following:

- Enter a valid production line number, and optionally, transaction code and date range on display AMIS10.
- Enter a valid production line number and, optionally, transaction code and date range on this display (AMIS19).
- Press **Enter** on display AMIS18.

Ranges are entered and interpreted as follows:

- If the **FROM** and **TO** fields are blank, then all data is selected.
- If the **FROM** and **TO** fields are both filled in, then data is selected if the record is equal to or greater than the **FROM** value and equal to or less than the **TO** value.
- If the **FROM** field is filled in and the **TO** field is blank, then all data equal to and greater than the **FROM** value is selected.
- If the **FROM** field is blank and the **TO** field is filled in, then all data up to and including the **TO** value is selected.

```

DATE **/**/**          TRANSACTION HISTORY          INQUIRY  AMIS19  **
                        SUMMARY BY LINE

PRODUCTION LINE aaaA5  TRANSACTION CODE A2

DATE FROM  nnnnnn  TO  nnnnnn

REF TR  SCHEDULE  POSTING  W          ITEM NUMBER          QUANTITY          U/
NO  CD   DATE      DATE      H          *****          * , * , * , * . * * *  /M  REFERENCE
** **  **/**/**  **/**/**  **  *****          * , * , * , * . * * *  ** *****
** **  **/**/**  **/**/**  **  *****          * , * , * , * . * * *  ** *****
** **  **/**/**  **/**/**  **  *****          * , * , * , * . * * *  ** *****
** **  **/**/**  **/**/**  **  *****          * , * , * , * . * * *  ** *****
** **  **/**/**  **/**/**  **  *****          * , * , * , * . * * *  ** *****
** **  **/**/**  **/**/**  **  *****          * , * , * , * . * * *  ** *****
** **  **/**/**  **/**/**  **  *****          * , * , * , * . * * *  ** *****
** **  **/**/**  **/**/**  **  *****          * , * , * , * . * * *  ** *****
** **  **/**/**  **/**/**  **  *****          * , * , * , * . * * *  ** *****
** **  **/**/**  **/**/**  **  *****          * , * , * , * . * * *  ** *****
** **  **/**/**  **/**/**  **  *****          * , * , * , * . * * *  ** *****
** **  **/**/**  **/**/**  **  *****          * , * , * , * . * * *  ** *****
** **  **/**/**  **/**/**  **  *****          * , * , * , * . * * *  ** *****
** **  **/**/**  **/**/**  **  *****          * , * , * , * . * * *  ** *****
** **  **/**/**  **/**/**  **  *****          * , * , * , * . * * *  ** *****
** **  **/**/**  **/**/**  **  *****          * , * , * , * . * * *  ** *****

99 ENTER REFERENCE NUMBER FOR ADDITIONAL DETAIL

                                USE ROLL UP/DOWN
                                F19 RETURN TO SELECT
                                F24 END OF JOB

```

### What to do

- To review another transaction, type in the production line, transaction code, and date and press **Enter**.

- To see the details of a transaction, type the reference number for the transaction into the **ENTER REFERENCE NUMBER FOR ADDITIONAL DETAIL** field and press **Enter**. Go to display AMIS18.

## Function keys

USE ROLL UP/DOWN causes the next or previous page of transactions to appear.

F19 RETURN TO SELECT causes the Transaction History Inquiry Selection (Select) display (AMIS11) to appear.

F24 END OF JOB ignores any data you typed on this display and causes the menu to appear again.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

The **PRODUCTION LINE**, **TRANSACTION CODE**, and **DATE FROM and TO** fields appear with information you typed on display AMIS10. You can type over these fields to select information for a different production line, transaction code, or date range. The **PRODUCTION LINE** field is required. You can also type a reference number in the **ENTER REFERENCE NUMBER FOR ADDITIONAL DETAIL** field. All other fields on this display are informational only.

**PRODUCTION LINE (PLINE) [?]**. Type in the production line for the transaction information.

**TRANSACTION CODE (TCODE)**. Type in the two-letter code for the type of transaction information. Leave the field blank to see all types of transactions for the item. For a description of the transaction codes available, see the explanation of display AMIS15 earlier in this section.

**DATE FROM/TO**. Type in the posting date limits for the transactions to review:

- Leave the **FROM** field blank to start with the earliest transaction in the file.
- Leave the **TO** field blank to include the latest transaction in the file.
- Leave both fields blank to see transactions for all dates.
- Type in the same date for both fields to see transactions posted only on that date.

The following fields make up the body of the display:

**REF NO (Reference Number)**. A unique number assigned by the system to each of the transactions shown. You can enter this number in the **ENTER REFERENCE NUMBER FOR ADDITIONAL DETAIL** field to see further information about this transaction.

**TR CD (Transaction Code) (TCODE)**. The two-letter code for the type of inventory transaction. For a description of the transaction codes available, see the explanation of display AMIS10 earlier in this section.

**SCHEDULE DATE (DATSC)**. The date of the schedule.

**POSTING DATE (UPDDT).** The date when this transaction was posted, changing the application's on hand balance for the item.

**WH (HOUSE).** The code identifying the warehouse used in the transaction.

**ITEM NUMBER (ITNBR).** The item number entered in this transaction.

**QUANTITY (TRQTY).** The quantity of this transaction.

**U/M (Unit of Measure) (ENTUM).** The unit of measure for the item entered with this transaction. If no unit of measure was entered, the stocking unit of measure (STKUM) appears.

**REFERENCE (REFNO).** The user-defined reference code entered with this transaction.

**ENTER REFERENCE NUMBER FOR ADDITIONAL DETAIL.** To see more detail, type in the reference number of the transaction.

## AMIS18—Transaction History—Detail (Inquiry)

Use this display to review additional details about a transaction shown on display AMIS15, AMIS16, or AMIS17.

This display appears when you enter a valid reference number on display AMIS15, AMIS16, AMIS17, or AMIS19.

```

DATE **/**/**                TRANSACTION HISTORY                INQUIRY    AMIS18  **
                               DETAIL                        * CALCULATED
ITEM *****                  *****                         TYPE * CLS **** MLI *
WH *** LOCN ***** LINE ***** OPER **** BATCH/LOT ***** FIFO **/**/**
ORD POL * STK U/M ** PLANNER ***** ENGR DRAWING *****
VENDOR CATALOG *****
*MRO* WORK ORDER-TASK: ***** COST CODE: ***** COUNTRY OF ORIGIN ***
WH -----TRANSACTION----- SCHEDULE / WH LOC -----RESULTING-----
NO. CODE QUANTITY UM DATE DATE BCH/LOT ON-HAND *,**,***.***
*** ** **/**/** **/**/** ***** ***** ON-ORDER *,**,***.***
***** **/**/** **/**/** ***** ALLOCATED *,**,***.***
GRN ***** MATCHED QTY nnnnnnnnnnnn.nnnn
TRF CMP BLK USER TRANS AMT/ VENDOR/ NEXT WH -----PREVIOUS-----
WH CD REL SEQ SALES COST REASON LOCATION ON-HAND *,**,***.***
*** * **/**/** **/**/** ***** ***** ON-ORDER *,**,***.***
***** **/**/** **/**/** ***** ALLOCATED *,**,***.***

-----DATE LAST----- --FLAGS--- BATCH/ PREVIOUS LAST COST REFERENCE
O.H. CHG  CYC/PHYS  SAL QC INV  WS-ID  AVERAGE COST
**/**/** **/**/** * * ** ***** ***** *****
***** ***** ***** *****
                               USE ROLL UP/DOWN
                               F19 RETURN TO SELECT
                               F24 END OF JOB

```

### What to do

- To return to the transaction summary display, press **Enter**.
- To return to the Transaction History Inquiry Selection display (AMIS11), use **F19**.

## Function keys

USE ROLL UP/DOWN causes the next or previous transaction to appear.

F19 RETURN TO SELECT causes the Transaction History Inquiry Selection (Select) display (AMIS11) to appear.

F24 END OF JOB causes the menu to appear again.

## Fields

All the fields on this display are informational only. The word \*CALCULATED appears if the transaction amount was calculated by the system rather than entered by the user.

**ITEM (ITNBR).** Number of the item, which can be any raw material, manufactured or purchased part, subassembly, assembly, or end item.

**Description (ITDSC).** This field appears to the right of the **ITEM** field but has no heading. It contains the description of the item that appears on invoices, inquiries, and reports.

**TYPE (Item Type Code) (ITTYP).** The item type code that best describes the item. The available codes are:

0	Phantom
1	Assembly or subassembly
2	Fabricated item
3	Raw material
4	Purchased item
9	User option
F	Feature
K	Kit

**CLS (Item Type Class) (ITCLS).** The user-assigned code that describes the classification to which this item belongs. For example, ST might be used to code all items made of steel.

**MLI (Master Level Item Code) (MLICD).** One of the codes used by MRP (if installed and interfacing) to indicate whether this item is a Master Level Item and, if so, which requirements to use when planning orders for it.

**WH (HOUSE).** The code of the warehouse associated with the item number above.

**LOCN (WHSLC).** The user-defined code indicating the location of the item in the warehouse.

**LINE (PLINE).** The production line used in this transaction. This field appears only if REP is installed and interfacing.

**OPER (OPSEQ).** The operation sequence number used with this transaction. This field appears only if REP is installed and interfacing.

**BATCH/LOT (LBHNO).** The number of the batch or lot of this item used in this transaction. This field appears only for a controlled warehouse.

**FIFO (FDATE).** The date the item was received in the warehouse. This field appears only if you selected the FIFO date integrity option during application tailoring.

**ORD POL (Order Policy Code) (ORDPC).** A code that identifies the order policy used to plan replenishment orders for this item. The available codes are:

<b>A</b>	Discrete order quantity
<b>B</b>	Order point, order quantity
<b>C</b>	Order point, order up to level
<b>D</b>	Fixed quantity
<b>F</b>	Part-period balancing – standard cost
<b>G</b>	Time periods of supply
<b>H</b>	Discrete above a minimum quantity
<b>I</b>	Part-period balancing – current cost
<b>Z</b>	User option

**STK U/M (Stocking Unit of Measure) (UNMSR).** A user-assigned code that defines the measurement basis of on hand quantity and issue quantity for this item; for example, EA (each), KG (kilogram), or CM (centimeter).

**PLANNER (PLANN).** The user-assigned number that identifies the person responsible for planning the replenishment strategy for this item.

**ENGR DRAWING (Engineering Drawing Number) (ENGNO).** The item's engineering drawing number. This field comes from the purchase order if one was entered there. If not, this field is the value from Item Master.

**VENDOR CATALOG NUMBER.** The catalog number used by the vendor for this item. This field comes from the purchase order.

**COUNTRY OF ORIGIN.** A code defined by your company that indicates where the item is manufactured.

The next four fields appear for Maintenance, Repair, and Overhaul (MRO) items if IM is interfacing with the Maintenance Management System (MMS).

**\*MRO\* (Maintenance Repair Overhaul Item).** Indicates that this is a spare part or a service item.

**WORK ORDER.** The number of the work order that originated in MMS.

**TASK.** Identifies a step on the work order. It represents the task to charge field, not the task sequence number.

**COST CODE.** The cost category that MMS uses to accumulate a specific cost associated with this work order or item. It is used only for non-stores and service items in MMS.

**WH NO (HOUSE).** The code of the warehouse associated with the detail transaction for the item number above.

**TRANSACTION CODE (TCODE).** A code identifying the type of transaction. A brief description of the transaction type appears on the line below the code.

A transaction code preceded by an R indicates a reversal transaction.

**TRANSACTION QUANTITY (TRQTY).** The quantity associated with this transaction.

**TRANSACTION UM (ENTUM).** The unit of measure for the item associated with this transaction.

**TRANSACTION DATE (TRNDT).** The date entered with this transaction.

**ORDER NO (ORDNO).** The number of the customer, purchase, or manufacturing order to which the transaction belongs.

If REP is installed and interfacing, the field name changes to SCHEDULE/DATE. The schedule number starts with S, and the date of the schedule appears below the number.

If COM is installed and interfacing with IM, a customer order number includes the company number and order type of the associated customer order.

**WH LOCATION (LLOCN).** The code for the location where the item used in this transaction was stored. For interwarehouse transactions, this code shows the location from which the item used in the transaction was picked. This field appears for controlled warehouses.

**BCH/LOT (LBHNO).** The previous identification of a specific batch or lot of an item that appears only for LQ (Change Batch/Lot Number) transactions.

**RESULTING ON-HAND (NUQOH).** The quantity of this item in stock after this transaction was posted.

**RESULTING ON-ORDER (NUQOO).** The total quantity of this item on open purchase or manufacturing orders after this transaction was posted.

**RESULTING ALLOCATED (NUALC).** The total quantity of this item allocated for both manufacturing orders and sales order picking lists after this transaction was posted.

**GRN (Goods Received Note).** This field appears if the GRN option was selected during application tailoring or if IFM is installed and interfacing. The number of the goods received note corresponds to a receipt. This field is user-defined and can represent a receiving ticket, a bill of lading, or an IFM invoice number. The GRN is used by the accounts payable department to check that invoiced items were actually received.

**MATCHED QUANTITY.** This field appears only if IFM is interfacing and you selected invoice-to-receipt matching. The total quantity of this receipt already matched to an IFM invoice.

**TRF WH (Transfer Warehouse) (TRWHS).** The warehouse to which this item was transferred. This field applies only to interwarehouse transfer transactions.

**CMP CD (Completion Code) (CMPCD).** The order completion code. Valid codes are:

<b>blank</b>	Partial receipt (default)
<b>C</b>	Order complete
<b>P</b>	Partial receipt
<b>R</b>	Reopen order

**BLK REL (Blanket Release) (BLKSQ).** The blanket release sequence number for a purchase transaction applied to a specific release.

**USER SEQ (USRSQ).** The user-defined sequence number of the component in the Manufacturing Order Detail record or the line item sequence number of a purchase order.

**TRANSACTION AMT (TRAMT).** This field appears only if you are authorized to review cost fields. It shows the value originally entered with the transaction.

**Note:** An asterisk following this field indicates no amount was entered on the transaction. The amount shown was calculated by multiplying transaction quantity by the current STP cost.

**SALES COST.** This field appears only if you are authorized to review cost fields. If this is a Sales Shipment (SA) transaction, this field shows the calculated cost amount.

**VENDOR/REASON (VNDNR) (REASN).** The vendor number and the reason code originally entered with the transaction.

**NEXT WH LOCATION (LLOCN).** The code for the location where the quantity of the item used in the transaction was moved. This field applies only to interwarehouse transfer transactions.

**PREVIOUS ON-HAND (PRQOH).** The quantity of this item in stock before this transaction was posted.

**PREVIOUS ON-ORDER (PRQOO).** The total quantity of this item on open purchase or manufacturing orders before this transaction was posted.

**PREVIOUS ALLOCATED (PRALQ).** The total quantity of this item allocated for both manufacturing orders and sales order picking lists (if COM is installed and interfacing) before this transaction was posted.

**DATE LAST O. H. CHG (Date of Last On Hand Change) (LDQOH).** The last date that this item's on hand quantity was changed.

**DATE LAST CYC/PHYS (Date of Last Cycle/Physical Count) (LPHDT).** The date this item was last counted in a cycle count or physical inventory.

**FLAGS SAL (Sales Flag) (SAFLG).** A code that indicates if this item is tracked in Sales Analysis. The codes are:

- 1 Tracked in Sales Analysis
- 0 Not tracked in Sales Analysis

**FLAGS QC (QC Type Code) (QCFLG).** A code that indicates the quality control type of the item. The codes are:

- 1 The item is within shelf life, and inspection is not yet required.
- 2 The item does not have shelf life.
- 6 The item is waiting inspection due to expiration of shelf life.
- 7 The manufactured item is waiting for inspection on receipt.
- 8 The item is rejected, waiting for disposal or rework.
- 9 The purchased item is waiting for inspection on receipt.



**FLAGS INV (Inventory Code) (INVFG).** A code that indicates the inventory status of this item. The codes are:

- 01** Inventory item
- 02** Miscellaneous item
- 03** Service item
- 04** Non-Inventory item (COM)

**BATCH/WS-ID (BATCH) (TRMID).** The batch number in which this transaction was entered and the identifier of the work station where the transaction was originally entered.

**PREVIOUS STD. COST (PCOST).** This field appears only if you are authorized to review cost fields. The field name changes to PREVIOUS AVG COST (average), or PREVIOUS LAST COST depending on the costing option selected during application tailoring. It shows the unit cost for this item before this transaction was posted.

**AVERAGE COST (AVCST).** This field appears only if you are authorized to review cost fields. It shows the average unit cost for this item after this transaction was posted.

**REFERENCE (REFNO) .** The reference number assigned by your company to relate this order to other orders.

---

## Option 9. Work with Location/Component (AMQM10)

Use this option to access the Work With function to review location and component information so you can define or review what mode of replenishment is used at a location and specify or review other replenishment controls.

### Location/Component panels

<b>AMQWLC01</b>	Work with Location Component Definitions
<b>AMQWLC02</b>	Change Defaults
<b>AMQSCL00</b>	Subset Location Component Definitions
<b>AMQALC01</b>	Create Location/Component Definition
<b>AMQCLC01</b>	Change Location/Component Definition
<b>AMQDLC01</b>	Display Location/Component Definition
<b>AMQRLC01</b>	Confirm Delete - Location Component Definitions
<b>AMQVLC01</b>	Validate Location Component Definitions

See Chapter 9, "Work with Repetitive" for more information on using the Work With panels.

---

## Option 10. Work with Component Status (AMQM10)

Use this option to access the Work With function to review the replenishment cycle controlled by the Location Component Status (CMPSTS) File. At the component level, this file tracks how much is needed, how much has been supplied, how much has been used, and what is being replenished.

### Component Status panels

**AMQSLS00** Subset Component Status  
**AMQWCS01** Work with Component Status  
**AMQWCS03** Change Defaults  
**AMQDCS01** Display Component Status

See Chapter 9, "Work with Repetitive" for more information on using the Work With panels.

## Chapter 4. Reports

When you select option 2 on the Repetitive Production Management Main Menu (AMQM00), the Reports menu (AMQM20) appears. This menu has 10 options to allow you to print numerous reports to help manage schedules and the REP application. This section describes the displays that allow you to limit the amount of information to be printed on the report.

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Option 9. Item/Line Audit (AMQM20) .....	4-23
Option 10. Location Audit (AMQM20).....	4-25

```

AMQM20                      Repetitive Production Management          *****
                              Reports

Type option or command; press Enter.

    1. Item Balance
    2. Schedule Performance
    3. Released Schedules
    4. Production Schedules
    5. Item/Line Process
    6. Item/Line
    7. WIP Cost
    8. Item Balance Audit
    9. Item/Line Audit
   10. Location Audit

==> _____

F3=Exit      F4=Prompt   F9=Retrieve   F10=Actions
F11=Job status  F12=Return  F22=Messages

```

**Option 1. Item Balance.** Use this option to print information for all items or a range of items from the Item Balance file.

**Option 2. Schedule Performance.** Use this option to print information about units scheduled, completed, and scrapped by shift for schedules run since the last schedule purge.

**Option 3. Released Schedules.** Use this option to print information about released schedules, such as allocation, status, quantity, and cost information. This option also prints a list of error transactions that did not process.

**Option 4. Production Schedules.** Use this option to print information on the quantity of the items to be built on a production line over a range of dates.

**Option 5. Item/Line Process.** Use this option to print information about standard labor and material costs of manufacturing an item or items on a production line.

**Option 6. Item/Line.** Use this option to print information on material, labor, and processing time for an item produced on a specific production line.

**Option 7. WIP Cost.** Use this option to print summary cost information for all open schedules and manufacturing orders.

**Option 8. Item Balance Audit.** Use this option to print discrepancies between the Item Balance file and the Item/Line, Product Structure, and Routing master files.

**Option 9. Item/Line Audit.** Use this option to validate key information for the Item/Line and Component/Line versus the Item Balance, Product Structure, and Routing master files, and between the Manufacturing Order Detail and the Manufacturing Order Master Files.

**Option 10. Location Audit.** Use this option to comprehensively validate the location fields used in the Repetitive Product Management application. The location fields in the following files are validated: Item/Line, Component/Line, Item Balance (scheduled items), Manufacturing Order Master, and Manufacturing Order Data (schedule orders).

---

## Option 1. Item Balance (AMQM20)

Use this option when you need a report for all items, or a range of items from the Item Balance file.

**What information you need:**

- The warehouse whose items you want to appear on the report, if you are printing items from only one warehouse
- The beginning and ending item numbers, if you are not printing all items in the file

**What report is printed:** Item Balance File List (AMI2T).

**What forms you need:** None.

The basic steps to print for all items or range of items from the Item Balance file follow each display.

## AMI2S1—Item Balance File List, Report Options

Use this display to select the options for printing the Item Balance File List (AMI2T).

This display appears when you select option 1 on the REP Reports menu or option 2 on the IM File Listings menu (AMIM23).

```
DATE **/**/**          ITEM BALANCE FILE LIST          AMI2S1  **
                        REPORT OPTIONS

OPTIONAL REPORT LIMITS:
  WAREHOUSE             aA3
  ITEM NUMBERS FROM-  aaaaaaaaaaaaaA15  TO-  aaaaaaaaaaaaaA15

                                F24 CANCEL THE JOB
```

### What to do

To print the listing, type in the information requested and press **Enter**. The Item Balance File List is scheduled to print. The menu from which you selected this report appears again.

### Function keys

F24 CANCEL THE JOB cancels printing of the report and causes the menu to appear again.

### Fields

All the fields on this display are optional.

**OPTIONAL REPORT LIMITS.** The limits for the report.

Ranges are entered and interpreted as follows:

- If blank, then all data is selected.
- If you fill in the **FROM** and **TO** fields, then records greater than or equal to the **FROM** field and less than or equal to the **TO** field appear.
- If you fill in the **FROM** field and leave the **TO** field blank, then all records equal to and greater than the **FROM** value are selected.

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- If you leave the **FROM** field blank and fill in the **TO** field, then all records up to and including the **TO** value appear.

If no limits are entered, all the Item Balance records print. Use either or both of the following limits:

**WAREHOUSE.** If you have multiple warehouses defined in the Warehouse Master file, type in the code of the warehouse to be used on the report. If you have multiple warehouses and you leave this field blank, all warehouses are shown on the report.

If you have only one warehouse, the warehouse defined in the Warehouse Master file appears in this field and cannot be changed.

**ITEM NUMBERS FROM/TO.** The range of item numbers to appear on the report.

---

## Option 2. Schedule Performance (AMQM20)

Use this option when you want a report showing how well the schedules are being met. The report lists the over/under completion status for open schedules. It provides both detail and cumulative totals.

You must select a report option to indicate the sequence of schedules to print. You can also print information selectively by warehouse, item, line, planner, schedule date range, and shift.

### What information you need:

- The warehouse whose items you want to appear on the report, if you are printing items from only one warehouse. Leave the field blank to print information for all warehouses.
- The printing sequence of the report:
  - By line
  - By item
  - By planner
  - By schedule
- The beginning and ending lines, items, and planners, if you are not printing all schedules
- The beginning and ending schedule dates if you want only schedules within a specified date range
- A shift, if you want only information for a specific shift

### What reports are printed:

- Schedule Performance by Line Report (AMQ231)
- Schedule Performance by Item Report (AMQ232)
- Schedule Performance by Planner Report (AMQ233)
- Schedule Performance by Schedule Report (AMQ234)

**What forms you need:** None.

The basic steps to report on schedule performance follow each display.

## AMQ221—Schedule Performance Report (Select)

Use this display to select the sequence and amount of information to be printed on the Schedule Performance Report (AMQ23n). You can print schedules by item, item within planner, item within production line, or by schedule numbers. You can also select schedules within a range of dates and for a specific shift.

This display appears when you select option 2 from menu AMQM20.

For the **From** and **To** ranges on this display, the value you type in the **To** field must be greater than or equal to the value you type in the **From** field when both fields are used. The range begins with and includes the value you type in the **From** field; it ends with and includes the value you type in the **To** field.

If you type a value in the **From** field only, the system ends the range with the highest value for that field. If you type a value in the **To** field only, the system begins the range with the lowest value for that field. If you want to select records by a single value instead of a range, use that value in both the **From** and **To** fields.



```

DATE **/**/**          SCHEDULE PERFORMANCE REPORT          SELECT          AMQ221  **

WAREHOUSE              aA3

REPORT OPTION          n          FROM          TO
1 BY LINE              aaaA5          aaaA5
2 BY ITEM              aaaaaaaaaaaaA15  aaaaaaaaaaaaA15
3 BY PLANNER          nnnnn          nnnnn
4 BY SCHEDULE         aaaaaA7          aaaaaA7

SCHEDULE DATE          FROM          TO
                      nnnnnn          nnnnnn

SHIFT < ,1,2,3>      n

F24 CANCEL JOB

```

### What to do

To print the listing, type in the information requested and press **Enter**. The Schedule Performance Report is scheduled for printing.

### Function keys

F24 CANCEL JOB shows you the Repetitive Production Management Reports menu (AMQM20) again, so you can choose another report or end this activity.

### Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WAREHOUSE (HOUSE) [?]**. This field contains the value of the default planning warehouse. Type in a specific warehouse code to print schedules for that warehouse, or leave the field blank to print schedules for all warehouses.

**REPORT OPTION (SELWK)**. Required. Type in a code to indicate the sequence of schedules to print on the report.

- 1 By line
- 2 By item
- 3 By planner
- 4 By schedule

**BY LINE FROM/TO (FRLIN/TOLIN) [?]**. Type in the production line range. The report will include information on all scheduled items for all lines that are selected.

**BY ITEM FROM/TO (FRITM/TOITM) [?]**. Type in the item range. The report will include information on all production lines producing the selected scheduled items.

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**BY PLANNER FROM/TO (FRPLN/TOPLN).** Type in the planner range. The report will include information on all items and lines for all planners that are selected.

**BY SCHEDULE FROM/TO (FRSCH/TOSCH).** Type in the schedule number range. The report will include information on all released schedules for all schedule numbers that are selected.

**SCHEDULE DATE FROM/TO (FRDAT/TODAT).** Type in the date range used to limit the schedules shown on the report.

**SHIFT (SHFTW).** Type in **1**, **2**, or **3** for the production shift to be included on the report. Leave blank to include all shifts.

---

## Option 3. Released Schedules (AMQM20)

Use this option when you want a report showing released schedule information, such as allocation, status, quantity, and cost information. This option also prints a list of error transactions that did not process.

The Released Schedules report prints two reports about open schedules. Released Schedules Errors Pending Backflush report lists those suspended batches having unapplied Schedule Receipt (RM), Operation Reporting (RO), or Schedule Scrap (SM) transactions. You can use this report to resolve the errors in batches which are suspended. The Released Schedules reports show you the status of your open schedules.

You must select a report option to indicate the sequence of schedules to print. You can also print information selectively by warehouse, line, item, planner, and schedule date range.

### What information you need:

- The warehouse whose items you want to appear on the report, if you are printing items from only one warehouse. Leave the field blank if you want to print information for all warehouses.
- The printing sequence of the report:
  - By line
  - By item
  - By planner
  - By schedule
- The beginning and ending lines, items, and planners, if you are not printing all released schedules
- The beginning and ending schedule dates, if you want only schedules within a specified date range

### What reports are printed:

- Released Schedules by Line Report (AMQ2M1)
- Released Schedules by Item Report (AMQ2M2)
- Released Schedules by Planner Report (AMQ2M3)
- Released Schedules by Schedule Report (AMQ2M4)
- Released Schedules Errors Report (AMQ2M5)

**What forms you need:** None.

The basic steps to report on released schedule information follow each display.

## AMQ2C1—Released Schedules Report (Select)

Use this display to select the content and sequence of information to be printed on the Released Schedules Report. You can print the report within a range of production lines, items, planners, or schedule numbers. You can print the report with errors only. A range of schedule dates can also be selected.

This display appears when you select option 3 on menu AMQM20.

For the **From** and **To** ranges on this display, the value you type in the **To** field must be greater than or equal to the value you type in the **From** field when both fields are used. The range begins with and includes the value you type in the **From** field; it ends with and includes the value you type in the **To** field.

If you type a value in the **From** field only, the system ends the range with the highest value for that field. If you type a value in the **To** field only, the system begins the range with the lowest value for that field. If you want to select records by a single value instead of a range, use that value in both the **From** and **To** fields.

DATE **/**/**	RELEASED SCHEDULES REPORT	SELECT	AMQ2C1 **
WAREHOUSE	aA3		
REPORT OPTION	n	FROM	TO
1	BY LINE	aaaA5	aaaA5
2	BY ITEM	aaaaaaaaaaaaA15	aaaaaaaaaaaaA15
3	BY PLANNER	nnnnn	nnnnn
4	BY SCHEDULE	aaaaA7	aaaaA7
5	WITH ERRORS ONLY		
SCHEDULE DATE	FROM	TO	
	nnnnnn	nnnnnn	
		F16 PRINT NOW	
		F24 CANCEL JOB	
			+

### What to do

- To print the report, type in the information requested and press **Enter**. The Released Schedules Report is scheduled for printing.
- To print the report interactively, use **F16**.

### Function keys

F16 PRINT NOW prints the report immediately instead of sending it to the job queue. The Reports menu (AMQM20) appears again. If errors occur, the display appears again with the errors highlighted.

F24 CANCEL JOB shows you the Repetitive Production Management Reports menu (AMQM20) without printing the report. You can then choose another report or end this activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WAREHOUSE [?]**. This field contains the value of the default planning warehouse. Type in the code for the warehouse you want printed on the report, or leave this field blank to print all warehouses on the report.

**REPORT OPTION (SELWK)**. Required. Type in a code to indicate the sequence in which schedules will print on the report.

- 1 By line
- 2 By item
- 3 By planner
- 4 By schedule number
- 5 With errors only

**BY LINE FROM/TO (FRLIN/TOLIN) [?]**. Type in the production line range. The report will include information on all scheduled items for all lines that are selected.

**BY ITEM FROM/TO (FRITM/TOITM) [?]**. Type in the item range. The report will include information on all production lines producing the selected scheduled items.

**BY PLANNER FROM/TO (FRPLN/TOPLN)**. Type in the planner range. The report will include information on all scheduled items and lines for all planners that are selected.

**BY SCHEDULE FROM/TO (FRSCH/TOSCH)**. Type in the schedule number range. The report will include information on all released schedules for all schedule numbers that are selected.

**WITH ERRORS ONLY**. The error report will include all pending issue transactions that would result in a negative inventory balance at a line location. Data is sequenced by production line and scheduled item.

**SCHEDULE DATE FROM/TO (FRDAT/TODAT)**. Type in the beginning and ending date of the date range used to limit the schedules shown on the report.

**Note:** This range for Schedule Date has no effect when you enter **4** (with errors only) in the **REPORT OPTION** field.

---

## Option 4. Production Schedules (AMQM20)

Use this option to print information on the quantity of the items to be built on a production line over a range of dates. You can also review the schedule assigned to each production line, the sequence of each schedule, and the line load of each schedule.

You must select a report option to indicate the sequence of schedules to print. You can also print information selectively by warehouse, line, item, planner, schedule group, or schedule number, and by production date range.

### What information you need:

- The printing sequence of the report:
  - By line
  - By item
  - By planner
  - By schedule group
  - By schedule number.
- The warehouse whose items you want to appear on the report, if you are printing items from only one warehouse
- The beginning and ending lines, items, or planners
- The beginning and ending production dates if you want only schedules within a specified date range

### What reports are printed:

- Production Schedules by Line Report (AMQ2N1)
- Production Schedules by Item Report (AMQ2N2)
- Production Schedules by Planner Report (AMQ2N3)
- Production Schedules by Schedule Group Report (AMQ2N4)
- Production Schedules by Schedule Number Report (AMQ2N5)

**What forms you need:** None.

The basic steps to report on scheduled production of items follow each display.



**WAREHOUSE (FITWH) [?]**. This field contains the value of the default planning warehouse. Type in the code for the warehouse you want printed on the report. If this field is left blank, all warehouses are printed on the report.

**REPORT OPTION (SELWK)**. Required. Type in a code to indicate the sequence of schedules you want to print on the report.

- 1 By line
- 2 By item
- 3 By planner
- 4 By group
- 5 By schedule

**BY LINE FROM/TO (FRLIN/TOLIN) [?]**. Type in the production line range. The report will include information on all scheduled items for all lines that are selected.

**BY ITEM FROM/TO (FRITM/TOITM) [?]**. Type in the item range. The report will include information on all production lines producing the selected scheduled items.

**BY PLANNER FROM/TO (FRPLN/TOPLN)**. Type in the planner range. The report will include information on all items and lines for all planners that are selected.

**BY GROUP FROM/TO (FRGRP/TOGRP)**. Type in the group range. This field allows you to print the production schedules by schedule group. The report will include information on all items, lines, planners, and schedule numbers for all selected schedule groups.

**BY SCHEDULE FROM/TO (FRSCH/TOSCH)**. Type in the schedule range. This field allows you to print the production schedules by schedule number. The report will include information on all items, lines, groups, and planners for all selected schedule numbers.

**PRODUCTION DATE FROM/TO (FRDAT/TO)**. Type in the date range used to limit the schedules shown on the report.



---

## Option 5. Item/Line Process (AMQM20)

Use this option when you want a report showing standard labor and material costs of manufacturing an item or items on a production line.

This report summarizes labor, machine hours, and material in units and hours or costs for schedules that are included in the report. It calculates hours or costs per unit for an operation based on standard labor, machine hours and setup used, and the number of pieces reported at the operation. It also calculates operation hours or costs per unit based on the total of all operations and units of the finished item that are reported. Schedules with a status code of 40 and 55 are selected for processing over a date range that you select.

You must select a report option to indicate the sequence of schedules to print. You can also print information selectively by warehouse, line, item, or planner, material and labor, and schedule date range.

### What information you need:

- The printing sequence of the report:
  - By line
  - By item
  - By planner
- The warehouse whose items you want to appear on the report, if you are printing items from only one warehouse
- The beginning and ending lines, items, or planners
- The material and labor to be shown in units and hours, or as costs
- The beginning and ending schedule due dates, if you want only schedules within a specified date range

### What reports are printed:

- Item/Line Process by Line in Units and Hours Report (AMQ2P1)
- Item/Line Process by Line as Costs Report (AMQ2P2)
- Item/Line Process by Item in Units and Hours Report (AMQ2P3)
- Item/Line Process by Item as Costs Report (AMQ2P4)
- Item/Line Process by Planner in Units and Hours Report (AMQ2P5)
- Item/Line Process by Planner as Costs Report (AMQ2P6)

**What forms you need.** None.

The basic steps to report on the standard labor and material costs for manufacturing an item or items on a production line follow each display.

## AMQ2E1—Item/Line Process Report (Select)

Use this display to select the sequence and amount of information to be printed on the Item/Line Process Report. You can print the report within a range of production lines, items, or planners. You can select whether to show material and labor in units and hours or as costs. A range of schedule dates can also be selected.

This display appears when you select option 5 on the Reports menu (AMQM20).

For the **From** and **To** ranges on this display, the value you type in the **To** field must be greater than or equal to the value you type in the **From** field when both fields are used. The range begins with and includes the value you type in the **From** field; it ends with and includes the value you type in the **To** field.

If you type a value in the **From** field only, the system ends the range with the highest value for that field. If you type a value in the **To** field only, the system begins the range with the lowest value for that field. If you want to select records by a single value instead of a range, use that value in both the **From** and **To** fields.

DATE **/**/**	ITEM/LINE PROCESS REPORT	SELECT	AMQ2E1 **
WAREHOUSE	aA3		
REPORT OPTION	n	FROM	TO
	1 BY LINE	aaaA5	aaaA5
	2 BY ITEM	aaaaaaaaaaaaA15	aaaaaaaaaaaaA15
	3 BY PLANNER	nnnnn	nnnn
MATERIAL AND LABOR	n		
	1 SHOW IN UNITS AND HOURS		
	2 SHOW AS COSTS		
SCHEDULE DATE	FROM	TO	
	nnnnnn	nnnnnn	
F24 CANCEL JOB			+

### What to do

To print the report, type in the information requested and press **Enter**. The Item/Line Process Report is scheduled for printing.

### Function keys

F24 CANCEL JOB shows you the Repetitive Production Management Reports menu (AMQM20) again, so you can choose another report or end this activity.

### Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WAREHOUSE (FITWH) [?]**. This field contains the value of the default planning warehouse. Type in a specific warehouse code to print schedules for that warehouse, or leave the field blank to print schedules for all warehouses.

**REPORT OPTION (SELWK)**. Required. Type in a code to indicate the sequence of schedules to print on the report.

- 1 By line
- 2 By item
- 3 By planner

**BY LINE FROM/TO (FRLIN/TOLIN) [?]**. Type in the production line range. The report will include information on all scheduled items for all lines that are selected.

**BY ITEM FROM/TO (FRITM) [?]**. Type in the item range. The report will include information on all production lines producing the selected scheduled items.

**BY PLANNER FROM/TO (FRPLN/TOPLN)**. Type in the planner range. The report will include information on all items and lines for all planners that are selected.

**MATERIAL AND LABOR (SELWK)**. Type in a code to indicate how you want material and labor shown on the report.

- 1 Show in units and hours
- 2 Show as costs

**SCHEDULE DATE FROM/TO (FRDAT/TODAT)**. Type in the date range used to limit the schedules shown on the report.

---

## Option 6. Item/Line (AMQM20)

Use this option when you want a report showing material and labor information for an item/line combination.

For a specific finished item and the production line on which the item is produced, this report shows pertinent information merged from the item master, item balance, item line, component line, location component, product structure, and routing files. It is designed to give a user a perspective of the manufacturing and replenishment characteristics of the finished item and its components.

You must select a report option to indicate the sequence of schedules to print. You can also print information selectively by line, or item and S-number, alternate routing code, and EC effectivity date.

### What information you need:

- The printing sequence of the report:
  - By line
  - By item
- The line or item for which you want the report to print
- The S-number for this item, if feature/options are supported
- The EC effectivity date and the alternate routing code

### What reports are printed:

- Item/Line Report (AMQ2Q1)
- Item/Line Report (AMQ2Q2)

**What forms you need:** None.

The basic steps to report on labor and material information follow each display.

## AMQ2F1—Item/Line Report (Select)

Use this display to select the sequence and amount of information to be printed on the Item/Line Report. You can print this report by production line or item and S-number. You can also use the default routing code or specify an alternate routing code and EC effectivity date. If you select a specific warehouse, locations are checked to make sure they exist.

This display appears when you select option 6 on menu AMQM20.

```

DATE **/**/**                ITEM/LINE REPORT                SELECT    AMQ2F1  **

                                WAREHOUSE                aA3

                                REPORT OPTION              n
                                1 BY LINE                aaaA5
                                2 BY ITEM                aaaaaaaaaaaaaA15 REVISION aaaaA6
                                S-NBR                    aaaaaaaaaaaaaaaaaA20

                                EC EFFECTIVE DATE          nn/nn/nn

                                DEFAULT ALT RTG <Y,N>      A
                                OR
                                ALT RTG SELECT CODE        A2

                                                                F24 CANCEL JOB
                                                                +

```

### What to do

To print the report, type in the information requested and press **Enter**. The Item/Line Report is scheduled for printing.

### Function keys

F24 CANCEL JOB shows you the Repetitive Production Management Reports menu (AMQM20) again so you can choose another report or end this activity.

### Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WH (Warehouse) [?]**. This field contains the value of the default planning warehouse. Type in the code for the warehouse you want printed on the report. If this field is left blank, all warehouses are printed on the report.

**REPORT OPTION (SELWK).** Required. Type in a code to indicate the sequence of schedules you want to print on the report.

- 1 By line
- 2 By item

**BY LINE (WKCTR) [?].** Prints the line setup information for specific line.

**BY ITEM (FITEM) [?].** Prints the line setup information for a specific item.

**REVISION (REVX).** This field appears only if EPDM is activated. Accept the default of \*ALL to see all revisions. Type \*CUR to see the current revision based on the current system. Type a revision identifier instead of a schedule number to see a specific revision.

**S-NUMBER (SNMBR) [?].** Type in the features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**EC EFFECTIVE DATE (ECEFF).** Type in the date to select those components which are currently in use. Components whose effectivity date has expired or has not yet become active will not be shown. The default is blank, which will display all components.

**DEFAULT ALT RTG <Y,N>.** Type in Y (Yes) or N (No):

- Y** Includes base operations plus those for the default alternate routing code as contained in the Item/Line Master File.
- N** Uses the default alternate routing code.

**ALT RTG SELECT CODE (ARCOD).** The Alternate Routing Code determines which additional operations are added to the routing. Type in the alternate routing code to select base operations, plus those for the specific alternate routing code entered. Type in \*\* to select all operations. If you leave this field left blank and enter a Y in the **DEFAULT ALT RTG** field, the base operations plus those for the default alternate routing code will be shown.

## Option 7. WIP Cost (AMQM20)

Use this option when you want a report showing a summary of all costs to date for all open schedules and manufacturing orders.

You must specify a report option to indicate the sequence of schedules to print. This display appears only if both PC&C and REP are installed.

**What information you need:** None.

**What report is printed:** WIP Cost Totals Sheet (AMVQ20).

**What forms you need:** None.

The basic steps to print WIP costs follow each display.

### AMVQ10—Report Analysis Options—WIP Totals Sheet

Use this display to select report options for the WIP Totals Sheet.

This display appears when you select the WIP Totals Sheet option on the Reports menu.

```
DATE **/**/**          REPORT ANALYSIS OPTIONS          AMVQ10  **
                        WIP TOTALS SHEET

SELECT SITE            aA3

ENTER REPORT OPTION    n

                        1 INCLUDE OPEN MANUFACTURING ORDERS AND SCHEDULES
                        2 INCLUDE OPEN MANUFACTURING ORDERS ONLY
                        3 INCLUDE OPEN SCHEDULES ONLY

                        F24 CANCEL THE JOB
```

#### What to do

- To print manufacturing orders and manufacturing schedules, type **1** in the **Report Option** field and press **Enter**.
- To print manufacturing orders only, type **2** in the **Report Option** field and press **Enter**.
- To print manufacturing schedules only, type **3** in the **Report Option** field and press **Enter**.
- To cancel the session, use **F24**.

## Function keys

F24 CANCEL JOB shows you the Reports menu again so you can choose another report or end this activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**SELECT SITE [?]**. Type in a site identifier you want to use for the report. This field appears only if EPDM is activated.

**ENTER REPORT OPTION (OPTION)**. Type in a number corresponding to the desired report option. Select one of the following values:

- 1 Open manufacturing orders and schedules
- 2 Open manufacturing orders only
- 3 Open schedules only



---

## Option 8. Item Balance Audit (AMQM20)

Use this option when you want a report that audits Item Balance entries coded as schedule-controlled. This report provides a listing of discrepancies between the Item Balance and the Product Structure, Routing, and Item/Line master files.

**What information you need:** None.

**What report is printed:** Item Balance Audit Report (AMQ2H).

**What forms you need:** None.

Select option 8 from menu AMQM20 to print the Item Balance Audit Report. No display appears when you select this option.

---

## Option 9. Item/Line Audit (AMQM20)

Use this option when you want a report showing discrepancies between the Item/Line and Component/Line versus the Item Balance, Product Structure, and Routing master files, and between the Manufacturing Order Detail and the Manufacturing Order Master Files.

You must enter an allowable variance percent to determine significant variances.

**What information you need:** The percentage variance to be used to report discrepancies between changeover and flow time hours in the Item/Line file and the calculated unit setup and run hours from the Routing master file.

**What report is printed:** Item/Line Audit Report (AMQ2J).

**What forms you need:** None.

If EPDM is activated, report AMQ2K is printed instead of AMQ2J.

The basic steps to report on an item/line audit follow each display.

### AMQ2B1—Item/Line Audit (Select)

Use this display to print discrepancies between changeover and flow time hours in the Item/Line file and calculated unit setup and run hours in the Routing file. You can enter an allowable variance percent for the Item/Line to Routing hours comparison.

This display appears when you select option 9 on menu AMQM20.

```
DATE **/**/**          ITEM/LINE AUDIT          SELECT  AMQ2B1  **

ITEM/LINE TO ROUTING HOURS COMPARISON
ALLOWABLE VARIANCE PERCENT 999.99

F24 CANCEL JOB          +
```

#### What to do

To print the report, type in the information requested and press **Enter**. The Item/Line Audit report is scheduled for printing.

## Function keys

F24 CANCEL JOB shows you the Repetitive Production Management Reports menu (AMQM20) without printing the report. You can then choose another report or end this activity.

## Fields

***ALLOWABLE VARIANCE PERCENT (VARPER)***. Type in the allowable variance percent you want to use to determine significant variances between the sum of changeover hours and flow time hours in the Item/Line file and the calculated unit setup or run hours in the Routing file.

---

## Option 10. Location Audit (AMQM20)

Use this option to validate the location fields used in the Repetitive Product Management application. This report provides a comprehensive validation of the location fields used in the Repetitive Product Management application. The location data in the following files is validated:

- Item/Line
- Component/Line
- Component/Location
- Component Status
- Item Balance (scheduled items)
- Manufacturing Order Master (schedule orders)
- Manufacturing Detail

**What information you need:** None.

**What report is printed:** Location Audit Report (AMQ2L).

**What forms you need:** None.

Select option 10 from the Reports menu AMQM20 to print the Location Audits Report. No display appears when you select this option.

## Chapter 5. Material Management

When you select option 3 on the Repetitive Production Management Main Menu (AMQM00), the Material Management menu (AMQM30) appears. This menu has 8 options to allow you to work with and control components on the production line.

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Option 3. Print Container Labels (AMQM30).....	5-11
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Option 5. Enter Transactions (AMQM30) .....	5-19
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Option 8. Print Transaction Register (AMQM30).....	5-103

```

AMQM30                      Repetitive Production Management          *****
                               Material Management

Type option or command; press Enter.

  1. Prime Production Lines
  2. Print Pick List
  3. Print Container Labels
  4. Print Component Return List
  5. Enter Transactions
  6. Enter Transactions from Offline Files
  7. Enter IM Transactions
  8. Print Transaction Register

==> _____

F3=Exit      F4=Prompt      F9=Retrieve      F10=Actions
F11=Job status  F12=Return      F22=Messages

```

**Option 1. Prime Production Lines.** Use this option to begin the material replenishment cycle by signaling the movement of component parts to a line in support of released production schedules. These production schedules can be specified from a display that shows schedules by line, item, planner, or schedule start date.

**Option 2. Print Pick List.** Use this option to print a listing of materials that are needed at a production line. Components appear on this list as a result of priming production lines, reporting replenishment transactions, or manual typing. This option also allows you to reprint pick lists.

**Option 3. Print Container Labels.** Use this option to print part identification labels for standard containers. Labels can be printed in support of picked schedules or on an as-required basis.

**Option 4. Print Component Return List.** Use this option to print a list of components that are to be returned to stock. This option can be used to identify excess material at a line due to reduced or canceled schedules. You also can reprint component return lists. This option also allows you to print a list of excess stock at line locations to identify material not required at the line location.

**Option 5. Enter Transactions.** Use this option to enter or maintain transactions that affect production line status, schedule performance, and component material movement.

**Option 6. Enter Transactions from Offline Files.** Use this option to process Repetitive Production Management transactions from an offline disk file or from a diskette that originated outside the Repetitive Production Management application.

**Option 7. Enter IM Transactions.** Use this option to enter Inventory Management transactions from the Repetitive Production Management menu. This option will take you directly into Inventory Management to enter inventory transactions.

**Option 8. Print Transaction Register.** Use this option to print the Transaction Register, which shows transactions entered using option 5 or option 6. To print the Transaction Register for IM transactions, refer to the Inventory Management User's Guide.

---

## Option 1. Prime Production Lines (AMQM30)

Use this option to initiate the production process for a given schedule. This option prepares the schedule to be started in production by determining the quantity of the component to issue, the line location to which the material is to be delivered, and the date when the material is to be delivered.

You can select the schedules you want to prime by warehouse, line, schedule item, S-number (if tailored in PDM/EPDM), start date range, and planner.

**What information you need:** The warehouse, line, item, S-number, date range, and planner.

**What report is printed:** Prime Production Line Audit (AMQ3S).

**What forms you need:** None.

The basic steps to prime production lines follow display.

### AMQ311—Prime Production Lines (Select)

Use this display to select released schedules to be primed, to begin the replenishment cycle. Schedules are selected based on the amount of information that you enter.

This display appears when you select option 1 on menu AMQM30.

For the **From** and **To** ranges on this display, the value you type in the **To** field must be greater than or equal to the value you type in the **From** field when both fields are used. The range begins with and includes the value you type in the **From** field; it ends with and includes the value you type in the **To** field.

If you type a value in the **From** field only, the system ends the range with the highest value for that field. If you type a value in the **To** field only, the system begins the range with the lowest value for that field. If you want to select records by a single value instead of a range, use that value in both the **From** and **To** fields.

```
DATE **/**/**          PRIME PRODUCTION LINES          SELECT          AMQ311  **
WH aA3  LINE aaaA5  SCHED ITEM aaaaaaaaaaaaaA15  S-NBR aaaaaaaaaaaaaaaaaA20
START DATE FROM nnnnnn TO nnnnnn          PLANNER nnnnn
OR
SCHED NUMBER  aaaaaA7

F24 CANCEL JOB          +
```

**What to do**

To select schedules to prime the production lines, type in the information you need and press **Enter**. Go to display AMQ312.

**Function keys**

F24 CANCEL JOB shows you the Material Management menu (AMQM30) again, so you can choose another option or end this activity.

**Fields**

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WH (Warehouse) (HOUSE) [?]**. This field contains the value of the default planning warehouse. Type in the code of the warehouse from which components are issued and the finished items received.

**LINE (PLINE) [?]**. Type in a production line to see a list of schedules released for this line.

**SCHED ITEM (FITEM) [?]**. Type in a scheduled item to see a list of schedules released for this item.

**S-NBR (SNMBR) [?]**. Type in the features and options code for the scheduled item you want to review. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**FROM/TO START DATE (FRDAT/TODAT)**. Type in the beginning and ending start date to see a list of released schedules that have a schedule start date greater than, less than, or equal to this date.

**PLANNER (PLANN).** Type in the code of the person responsible for planning and scheduling this finished item.

**SCHEDULE NUMBER (ORDNO).** Type in the schedule number for this finished item.

## AMQ312—Prime Production Lines (Entry)

Use this display to select a specific schedule to be primed from the group you selected on display AMQ311. You can also choose to prime all production lines for the selected schedules. You can review additional fields on this display by selecting **F12 ADDITIONAL FIELDS**.

This display appears after data is entered and edited on display AMQ311.

```

DATE **/**/**                PRIME PRODUCTION LINES                ENTRY                AMQ312  **
WH ***  LINE *****  SCHED ITEM *****  S-NBR *****
START DATE FROM **/**/** TO **/**/**                PLANNER *****

SEL WH  LINE  SCHED ITEM                SCHED QTY  START DATE  SCHED DATE  SCHED NBR
SCHED NBR                S-NUMBER
A  ***  *****  *****  *,***,***.***_  **/**/**  **/**/**  *****
*****  *****
A  ***  *****  *****  *,***.***.***  **/**/**  **/**/**  *****
*****  *****
A  ***  *****  *****  *,***.***.***  **/**/**  **/**/**  *****
*****  *****
A  ***  *****  *****  *,***.***.***  **/**/**  **/**/**  *****
*****  *****
A  ***  *****  *****  *,***.***.***  **/**/**  **/**/**  *****
*****  *****
A  ***  *****  *****  *,***.***.***  **/**/**  **/**/**  *****
*****  *****
*****  *****  *****  *,***.***.***  **/**/**  **/**/**  *****
*****  *****
+

                                F13 ACCEPT ALL SCHEDULES
                                F19 RETURN TO SELECT
                                F24 CANCEL JOB
                                +

                                USE ROLL UP/DOWN
                                F12 ADDITIONAL FIELDS

```

### What to do

- To select schedules, type **1** in the **SEL** field and press **Enter**. The selected schedules will be submitted for processing.
- To see additional fields, use **F12**. To return to the original display format, use **F12** again.
- To accept all schedules to be primed, use **F13**.
- To return to the Prime Production Lines (Select) display (AMQ311), use **F19**. Go to display AMQ311.

### Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of schedules.

F12 ADDITIONAL FIELDS allows you to review a second line of fields and information on the display. Using **F12** a second time returns you to the original format of one line of fields.



F13 ACCEPT ALL SCHEDULES accepts for priming all schedules shown on the display. The Prime Production Line Audit report (AMQ3S) is placed on the job queue, and the REP Material Management menu (AMQM30) appears again.

F19 RETURN TO SELECT returns to the Select display (AMQ311) so you can select another group of schedules for priming.

F24 CANCEL JOB shows you the REP Material Management menu (AMQM30) again, so you can choose another option or end this activity.

## Fields

**WH (Warehouse) (HOUSE).** The warehouse selected on display AMQ311.

**LINE (PLINE).** The production line selected on display AMQ311.

**SCHED ITEM (FITEM).** The scheduled item selected on display AMQ311.

**S-NBR (SNMBR).** The features and options code for the item selected on display AMQ311. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**START DATE FROM/TO (FRDAT/TODAT).** The beginning and ending start date for released schedules selected on display AMQ311.

**PLANNER (PLANN).** The code of the person responsible for planning and scheduling this finished item, selected on display AMQ311.

**SEL (Select).** Required. Type in **1** next to each schedule you want to prime.

**WH (HOUSE).** The warehouse from which components are issued and the finished items are received for this schedule.

**LINE (PLINE).** The production line for this schedule.

**SCHED ITEM (FITEM).** The number and description of the finished item to be produced for this schedule.

**SCHED QTY (SCHED).** The quantity of the item to be produced on this schedule.

**START DATE (STDAT).** The beginning date of the schedule.

**SCHED DATE (ODUDT).** The date that the item's schedule is due to be completed.

**SCHED NBR (ORDNO).** The schedule number for this item.

**S-NUMBER (SNMBR).** The features and options code for the item on the selected schedule.

---

## Option 2. Print Pick List (AMQM30)

Use this option to print a listing of and generate replenishments for materials that are needed at the production line. The material is then allocated from the available inventory.

You must type in a required date range and whether you want the report sorted in line location or supply location sequence. You can print information selectively by warehouse, line range, line location range, scheduled item range, and priority items only. You have the option to print additional schedule information on the Pick List. This option also allows you to reprint Pick Lists.

### What information you need:

- The printing sequence of the report:
  - By line location
  - By supply location
  - By line location and supply location
- The warehouse whose items you want to appear on the report, if you are printing items from only one warehouse
- The beginning and ending lines, line locations, and scheduled items, if you are not printing all schedules
- The required dates if you only want components within a specified range

**What report is printed:** Pick List (AMQ3T1 or AMQ3T2).

**What forms you need:** None.

The basic steps to print pick list follow display

**Note:** If the pick list has been printed and you do not want to move the material to the line, you should follow these steps to keep the need for replenishment in your XA system.

1. Run CL transaction for zero quantity to restore the need for replenishment to your XA system.
2. Run transactions to move material to line.
3. Run Pick List to process replenishment records to status 30 so backflushing will process correctly.

## AMQ321—Print Pick List (Select)

Use this display to initiate material movement between supply locations and line locations and to allocate quantities for the selected replenishments. An authorization to move material (pick list) is printed for the options you choose on this display.

This display appears when you select option 2 on menu AMQM30.

For the **From** and **To** ranges on this display, the value you type in the **To** field must be greater than or equal to the value you type in the **From** field when both fields are used. The range begins with and includes the value you type in the **From** field; it ends with and includes the value you type in the **To** field.

If you type a value in the **From** field only, the system ends the range with the highest value for that field. If you type a value in the **To** field only, the system begins the range with the lowest value for that field. If you want to select records by a single value instead of a range, use that value in both the **From** and **To** fields.

DATE **/**/**	PRINT PICK LIST	SELECT	AMQ321 **
WAREHOUSE	aA3		
PRODUCTION LINES	FROM	TO	
LINE LOCATIONS	aaaA5	aaaA5	
SCHEDULED ITEMS	aaaaA7	aaaaA7	
COMPONENT ITEMS	aaaaaaaaA15	aaaaaaaaA15	
SCHEDULE NUMBERS	aaaaA7	aaaaA7	
PRIORITY ITEMS ONLY <Y,N>	A		
PRINT SCHEDULE INFO <Y,N>	A		
REQUIRED DATE	nnnnnn	nnnnnn	
PRINT PICK LIST BY	n		
	1 LINE LOCATION		
	2 SUPPLY LOCATION		
	3 LINE AND SUPPLY LOCATIONS		
		F09 REPRINT LIST	
		F24 CANCEL JOB	
			+

### What to do

To print or reprint the Pick Lists, type in the information you need and press **Enter**.

### Function keys

F09 REPRINT LIST shows display AMQ322 to allow you to reprint a pick list.

F24 CANCEL JOB shows you the Material Management menu (AMQM30) again, so you can choose another option or end this activity.

### Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WAREHOUSE (HOUSE) [?]**. This field contains the value of the default planning warehouse. Type in the code of the warehouse from which components are issued and the finished items received or leave blank for all warehouses.

You can select any or all of the production line, line location, scheduled item, component item, or schedule number ranges.

**PRODUCTION LINES FROM/TO (FLINE/TLINE) [?]**. Type in the first and last production line for which you want to print pick lists.

**LINE LOCATIONS FROM/TO (FLOCN/TLOCN)**. Type in the first and last location in the production area for which you want to print pick lists.

**SCHEDULED ITEMS FROM/TO (FRITM/TOITM) [?]**. Type in the first and last scheduled item that you want to print on the pick lists. If components for these schedules are commonly used on other scheduled items required in the same time period, their requirements will be included as well.

**COMPONENT ITEMS FROM/TO (FRCTM/TOCTM) [?]**. Type in the first and last component item that you want to print on the pick lists.

**SCHEDULE NUMBERS FROM/TO (FRMZZ/TOZZZ)**. Type in the first and last schedule numbers that you want to print on the pick lists. If components for these schedules are commonly used on other scheduled items required in the same time period, their requirements will be included as well.

**PRIORITY ITEMS ONLY <Y,N> (PRITM)**. Those items that need to be replenished immediately. These priority items are designated on the replenishment transaction. Type in **Y** (Yes) or **N** (No):

- Y** Prints only those selected items with priority codes.
- N** Prints all items.

**PRINT SCHEDULE INFO <Y,N> (PRTDT)**. Type in **Y** (Yes) or **N** (No):

- Y** Prints the schedule date, scheduled item, and the production line for each component reference on the Pick List.
- N** No additional schedule information is printed on the Pick List.

**REQUIRED DATE FROM/TO (WSFEDT/WSTEDT)**. Required. Type in the beginning and ending required date for which you want to limit the Pick List to print component material.

**PRINT PICK LIST BY (PTSEQ)**. Required. The print sequence for components shown on the pick lists. Type in **1** to print by line location. Type in **2** to print by supply location. Type in **3** to print a pick list by line location and a pick list by supply location.

## AMQ322—Print Pick List, Print Options (Select)

Use this display to select the print options for the Pick Lists. If you used **F09** on the Print Pick List Select display (AMQ321), the display title for display AMQ322 is Reprint Pick List and the cursor is positioned at the **PICK LIST SELECTED** field. If you pressed Enter on display AMQ321, the cursor is positioned at the **PRINT TO OUTPUT QUEUE** field. You can also print container labels from this display. You can select to print this list on a printer other than the system printer if you want the bar code information to print.

If you chose to reprint a pick list using **F09 REPRINT LIST** on display AMQ321, the report that prints will be in the sequence specified on display AMQ321. The reprint list is not necessarily a reproduction of the original list. CL transactions processed against the list will be reflected in the reprint.

This display appears when you press **Enter** or use **F09 REPRINT LIST** on display AMQ321.

For the **From** and **To** ranges on this display, the value you type in the **To** field must be greater than or equal to the value you type in the **From** field when both fields are used. The range begins with and includes the value you type in the **From** field; it ends with and includes the value you type in the **To** field.

If you type a value in the **From** field only, the system ends the range with the highest value for that field. If you type a value in the **To** field only, the system begins the range with the lowest value for that field. If you want to select records by a single value instead of a range, use that value in both the **From** and **To** fields.

DATE **/**/**	PRINT PICK LIST PRINT OPTIONS	SELECT	AMQ322 **
	FROM TO		
PICK LISTS SELECTED	nnnnn nnnnn		
PRINT SCHEDULE INFO <Y,N>	A		
PRINT TO OUTPUT QUEUE	aaaaaaaaA10		
OUTPUT QUEUE LIBRARY	aaaaaaaaA10		
NUMBER OF COPIES	nnn		
REPORT FORMAT	n 1 14-7/8 x 11 PAPER 2 8-1/2 x 11 PAPER		
PRINT CONTAINER LABELS <Y,N>	A		
F24 CANCEL JOB			

### What to do

- To print or reprint Pick Lists, type in the information you need and press **Enter**.
- To print container labels, type **Y** in the **PRINT CONTAINER LABELS** field. Go to display AMQ323.

## Function keys

F24 CANCEL JOB shows you the Material Management menu (AMQM30) again, so you can choose another option or end this activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**PICK LISTS SELECTED FROM/TO (FPICK/TPICK) [?]**. Required if pick lists are to be reprinted. Type in the first and last pick list to print. You must use the **FIELD EXIT** key to initiate a search in this field. This field is protected if you are not reprinting a pick list.

**PRINT SCHEDULE INFO (WSPSCH) <Y,N>**. Y (Yes) prints the schedule date, schedule item, and production line for each component reference on the pick list. N (No) excludes this additional information on the pick list.

**PRINT TO OUTPUT QUEUE (OUTQU)**. Required. Type in the designated output queue for the pick lists. The default is the value entered for the report using menu AMZM30, option 3, Work with Printer Overrides. If you left the Work With Printer Overrides value blank, the default will be the value in your system job description. Use DSPJOB to see job definition attributes.

**OUTPUT QUEUE LIBRARY (OUTLB)**. Type in the library that contains the output queue. The default is the value entered for the report using menu AMZM30, option 3, Work with Printer Overrides. If you left the Work With Printer Overrides value blank, the default will be the value in your system job description. Use DSPJOB to see job definition attributes.

**NUMBER OF COPIES (COPIE)**. Type in the number of copies of pick lists to print.

**REPORT FORMAT (PLFMT)**. Type in the paper size to be used for printing the pick lists.

**PRINT CONTAINER LABELS <Y,N> (LABLS)**. Type in Y (Yes) or N (No):

Y Prints container labels  
N Does not print container labels.

---

## Option 3. Print Container Labels (AMQM30)

Use this option to print part identification labels for standard containers or items in line location sequence. You can print labels for each component item in supply location sequence, or you can print a label for each container. Labels can be printed single or double width. You must type in an output queue and output queue library name. You can print information selectively by Pick List range, line reference range, and criteria to sort the labels by location or container. You can select a printer other than the system printer if you want bar code information to print.

**What information you need:** The range of Pick List numbers, and line reference numbers.

**What reports are printed:**

- Container Labels–Double (AMQ3U2)
- Container Labels–Single (AMQ3U1)

**What forms you need:** None.

The basic steps to print container labels follow display.

## AMQ323—Print Container Labels, Print Options (Select)

Use this display to select print options for container labels.

This display appears when you select option 3 on menu AMQM30 or when you enter **Y** in the **PRINT CONTAINER LABELS** from the Print Pick Lists, Print Options display (AMQ322).

For the **From** and **To** ranges on this display, the value you type in the **To** field must be greater than or equal to the value you type in the **From** field when both fields are used. The range begins with and includes the value you type in the **From** field; it ends with and includes the value you type in the **To** field.

If you type a value in the **From** field only, the system ends the range with the highest value for that field. If you type a value in the **To** field only, the system begins the range with the lowest value for that field. If you want to select records by a single value instead of a range, use that value in both the **From** and **To** fields.

DATE **/**/**	PRINT CONTAINER LABELS PRINT OPTIONS	SELECT	AMQ323 **
	PICK LIST NUMBERS	FROM nnnnn	TO nnnnn
	LINE REFERENCE NUMBERS	nnnn	nnnn
	PRINT TO OUTPUT QUEUE	aaaaaaaaA10	
	OUTPUT QUEUE LIBRARY	aaaaaaaaA10	
	NUMBER OF COPIES	nnn	
	LABEL WIDTH	n 1 SINGLE 2 DOUBLE	
	PRINT LABELS FOR EACH	n 1 ITEM/SUPPLY LOCATION 2 CONTAINER	
		F24 CANCEL JOB	+

### What to do

Typing in the information you need and pressing **Enter** causes a forms alignment message to be sent to the system operator. When you correct the alignment, the container labels are printed. The Material Management menu (AMQM30) appears again.

### Function keys

F24 CANCEL JOB shows you the Material Management menu (AMQM30) again, so you can choose another option or end this activity.

### Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.



**PICK LIST NUMBERS FROM/TO (FPICK/TPICK) [?]**. Does not appear if you selected PRINT CONTAINER LABELS from Print Pick List Print options (AMQ322). Type in the first and last pick list to print. You must use the **Field Exit** key to initiate a search in this field. This field is protected if you are reprinting a pick list. This field does not appear if you entered **Y** in the **PRINT CONTAINER LABELS** field on display AMQ322.

**LINE REFERENCE NUMBERS FROM/TO (FMREF/TOREF)**. Type in the first and last line reference number for which you want to print container labels from a previously picked pick list.

**PRINT TO OUTPUT QUEUE (OUTQC)**. Required. Type in the designated output queue for the container labels. The default is the value entered for the report using menu AMZM30, option 3, Work with Printer Overrides. If you left the Work With Printer Overrides value blank, the default will be the value in your system job description. Use DSPJOB to see job definition attributes.

**OUTPUT QUEUE LIBRARY (OUTLC)**. Type in the library that contains the output queue. The default is the value entered for the report using menu AMZM30, option 3, Work with Printer Overrides. If you left the Work With Printer Overrides value blank, the default will be the value in your system job description. Use DSPJOB to see job definition attributes.

**NUMBER OF COPIES (COPIE)**. Type in the number of container labels to print for each item. The program prints the list the number of times you specify.

**LABEL WIDTH (CLWID)**. Type in one of the following:

- 1 Single-label format
- 2 Double-label format

**PRINT LABELS FOR EACH (CLBLS)**. Type in one of the following:

- 1 Prints a container label for each component item in each line location for the components that have been picked.
- 2 Prints a container label for each container of components that have been picked.

The components that have been transferred to the line will not have labels printed.

---

## Option 4. Print Component Return List (AMQM30)

Use this option to print a list of components that are to be returned to stock. This option also allows you to print a list of excess stock at line locations. You also can reprint Component Return Lists as needed.

The Component Return List is used to identify stock reserved for active schedules that has been allocated through REP's replenishment process. Stock removed from a line location using the return list function must be reported using REP's CN transaction (Component Return to Stores).

The Excess Stock at Line Location report is used to list material not currently required at the line location. Stock removed from a line location using the excess stock function must be reported using IM's TW transaction (Interwarehouse Transfer).

You must select a sequence for the Component Return Lists. You also can print information selectively by warehouse, line range, line location range, scheduled item range, or component item range. For the Excess Stock at Line Location report, only line location and component item ranges are valid.

### What information you need:

- The printing sequence of the report:
  - By line location
  - By supply location
  - By line location and supply location
- The warehouse whose items you want to appear on the report, if you are printing items from only one warehouse
- The beginning and ending lines, line locations, scheduled items, and component items, if you are not printing all schedules

**What report is printed:** Component Return List (AMQ3R1 or AMQ3R2).  
Excess Stock at Line Location (AMQESL00).

**What forms you need:** None.

The basic steps to print a component return list follow display.

## AMQ3Q1—Print Component Return List (Select)

Use this display to print a list of components that are to be returned to the stockroom. This option also allows you to reprint Component Return Lists.

This display appears when you select option 4 on menu AMQM30.

For the **From** and **To** ranges on this display, the value you type in the **To** field must be greater than or equal to the value you type in the **From** field when both fields are used. The range begins with and includes the value you type in the **From** field; it ends with and includes the value you type in the **To** field.

If you type a value in the **From** field only, the system ends the range with the highest value for that field. If you type a value in the **To** field only, the system begins the range with the lowest value for that field. If you want to select records by a single value instead of a range, use that value in both the **From** and **To** fields.

```

DATE **/**/**          PRINT COMPONENT RETURN LIST          SELECT          AMQ3Q1  **

      WAREHOUSE                aA3

      PRODUCTION LINES          FROM                TO
      LINE LOCATIONS           aaaA5                aaaA5
      SCHEDULED ITEMS          aaaaaA7              aaaaaA7
      COMPONENT ITEMS          aaaaaaaaaA15         aaaaaaaaaA15
                                aaaaaaaaaA15         aaaaaaaaaA15

PRINT REPORT FOR EXCESS STOCK <Y,N>      A
PRINT COMPONENT RETURN LIST  <Y/N>    A

RETURN LIST SEQUENCE                n
1  LINE LOCATION
2  SUPPLY LOCATION
3  LINE AND SUPPLY LOCATIONS

                                F09 REPRINT LIST
                                F17 ACCEPT WARNING
                                F24 CANCEL JOB

```

### What to do

- To print the component return list or the report for excess stock, type in the information you need and press **Enter**. A warning message appears for you to visually confirm the select range you have entered. Use **F17** to continue.
- To reprint component return lists, use **F09**. Go to display AMQ3Q2.

### Function keys

F09 REPRINT LIST shows the Print Component Return List, Print Options display (AMQ3Q2) to allow you to reprint a component return list.

F17 ACCEPT WARNING allows you to verify that you in fact want to continue this job.

F24 CANCEL JOB shows you the Material Management menu (AMQM30) again, so you can choose another option or end this activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WAREHOUSE (HOUSE) [?]**. This field contains the value of the default planning warehouse. Type in the code of the warehouse from which components are issued and the finished items received.

You can select any or all of the production line, line location, scheduled item, and component item ranges.

**PRODUCTION LINES FROM/TO (FLINE/TLINE) [?]**. Type in the first and last production line for which you want to print component return lists.

**LINE LOCATIONS FROM/TO (FLOCW/TLOCW)**. Type in the first and last location in the production area for which you want to print a component return list or excess stock report.

**SCHEDULED ITEMS FROM/TO (FRITM/TRITM) [?]**. Type in the first and last scheduled item for which you want to print component return lists.

**COMPONENT ITEMS FROM/TO (FRITM/TRITM) [?]**. Type in the first and last component item for which you want to print a component return list or excess stock report.

**PRINT REPORT FOR EXCESS STOCK <Y,N> (PRTDT)**. Type **Y** (Yes) or **N** (No):

- Y** Print the excess stock report.
- N** No excess stock is printed.

**PRINT COMPONENT RETURN LIST <Y,N>(INSCH)**. Type **Y** (Yes) or **N** (No):

- Y** Print the component return list.
- N** No component return list is printed.

**RETURN LIST SEQUENCE (PTSEQ)**. Required. The print sequence for the component return list. Type in one of the following:

- 1** Print by line location
- 2** Print by supply location
- 3** Print a component return list by line location and by supply location.

## AMQ3Q2—Print Component Return List, Print Options (Select)

Use this display to select print options for the Component Return List (AMQ3R1). You can select to print this list on a printer other than the system printer if you want bar code information to print.

If you chose to reprint a component return list using **F09 REPRINT LIST** on display AMQ3Q1, the report that prints will be in the sequence specified on display AMQ3Q1.

This display appears when you press **Enter** or use **F09 REPRINT LIST** on display AMQ3Q1.

For the **From** and **To** ranges on this display, the value you type in the **To** field must be greater than or equal to the value you type in the **From** field when both fields are used. The range begins with and includes the value you type in the **From** field; it ends with and includes the value you type in the **To** field.

If you type a value in the **From** field only, the system ends the range with the highest value for that field. If you type a value in the **To** field only, the system begins the range with the lowest value for that field. If you want to select records by a single value instead of a range, use that value in both the **From** and **To** fields.

```

DATE **/**/**          PRINT COMPONENT RETURN LIST   SELECT   AMQ3Q2  **
                        PRINT OPTIONS

COMPONENT RETURN LIST NUMBER  FROM   TO
                                nnnnn  nnnnn
PRINT TO OUTPUT QUEUE         aaaaaaaA10
OUTPUT QUEUE LIBRARY         aaaaaaaA10
NUMBER OF COPIES              nnn
REPORT FORMAT                  n
                                1  14-7/8 x 11 PAPER
                                2  8-1/2 x 11 PAPER

                                F24 CANCEL JOB
                                +

```

### What to do

To print the component return lists, type in the information you need and press **Enter**.

### Function keys

F24 CANCEL JOB shows you the Material Management menu (AMQM30) again, so you can choose another option or end this activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**COMPONENT RETURN LIST NUMBER FROM/TO (FPICK/TPICK) [?]**. Type in the first and last component return list number to print. You must use the **Field Exit** key to initiate a search in this field.

**PRINT TO OUTPUT QUEUE (OUTQU)**. Type in the designated output queue for the component return lists. The default is the value entered for the report using menu AMZM30, option 3, Work with Printer Overrides. If you left the Work With Printer Overrides value blank, the default will be the value in your system job description. Use DSPJOB to see job definition attributes.

**OUTPUT QUEUE LIBRARY (OUTLB)**. Type in the library that contains the output queue. The default is the value entered for the report using menu AMZM30, option 3, Work with Printer Overrides. If you left the Work With Printer Overrides value blank, the default will be the value in your system job description. Use DSPJOB to see job definition attributes.

**NUMBER OF COPIES (COPIE)**. Type in the number of copies of component return lists to print.

**REPORT FORMAT (PLFMT)**. Type in the paper size to be used for printing the component return lists:

- 1 14 7/8 by 11 paper
- 2 8 1/2 by 11 paper

## Option 5. Enter Transactions (AMQM30)

Use this option to enter or maintain transactions that affect production line status, schedule performance, and component material movement.

You can select an existing batch number or enter a new one.

**What information you need:** None.

**What reports are printed:** None.

**What forms you need:** None.

The basic steps to enter transactions follow display.

### AMQ3ZA—Enter Transactions, Data Entry Control

Use this display to select a batch to enter transactions.

This display appears when you select option 5 on menu AMQM30.

```

DATE **/**/**                    ENTER TRANSACTIONS                AMQ3ZA  **
                                 DATA ENTRY CONTROL
                                 BATCHES CURRENTLY IN USE ***
                                 LOCATE BATCH nnn

ENTER BATCH NUMBER   nnn

  BATCH  *--ORIGINAL--*  *---LAST---*
  NO.    WSID   OPER    WSID   OPER    STATUS    DATE     USED   ERRORS
  ***    *****   ***  *****   ***  *
  ***    *****   ***  *****   ***  *
  ***    *****   ***  *****   ***  *
  ***    *****   ***  *****   ***  *
  ***    *****   ***  *****   ***  *
  ***    *****   ***  *****   ***  *
  ***    *****   ***  *****   ***  *
  ***    *****   ***  *****   ***  *
  ***    *****   ***  *****   ***  *
  ***    *****   ***  *****   ***  *
  ***    *****   ***  *****   ***  *
  ***    *****   ***  *****   ***  *
  ***    *****   ***  *****   ***  *
  ***    *****   ***  *****   ***  *
  ***    *****   ***  *****   ***  *
  ***    *****   ***  *****   ***  *
  ***    *****   ***  *****   ***  *

                                     USE ROLL UP/DOWN
                                     F04 NEW BATCH
                                     F24 CANCEL THE JOB

                                     +
```

#### What to do

- To enter a new batch for processing, use **F04**. Go to display
- To select an existing batch for processing, type in the batch number and press **Enter**. Go to display AMQ34J.

#### Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of batches.

F04 NEW BATCH goes to display AMQ34A to allow you to select the type of transaction that you want to enter.

F24 CANCEL THE JOB shows you the Material Management menu (AMQM30) again, so you can choose another option or end this activity.

## Fields

**ENTER BATCH NUMBER (BCHIN).** Required. Type in the number of the batch to review or change.

**BATCHES CURRENTLY IN USE (MBRUS).** The number of batches in process regardless of their status.

**LOCATE BATCH (LOCBH).** Type in the number of the batch to search for to review or change.

**BATCH NO. (BNUMB).** The sequential number assigned to each batch.

**ORIGINAL WSID (OIDNO).** The work station where the batch was originally entered.

**ORIGINAL OPER (OOPNO).** The operator station where the batch was originally entered.

**LAST WSID (LIDNO).** The work station from which the batch was last selected.

**LAST OPER (LOPNO).** The operator station from which the batch was last selected.

**STATUS (BSTUS).** This field identifies the status of the entered batch as ACTIVE, SUSPEND, CLOSED, UPDATE, FINISH, or RECOVER.

**DATE (DATE).** The date the batch was created.

**RECORDS USED (RUSED).** The number of transaction records in the batch.

**RECORDS ERRORS (REROR).** The number of records in error in the batch.



## AMQ34A—Enter Transactions (Select)

Use this display to select the type of transaction you want to work with. You can enter the number of the transaction or the transaction ID.

This display appears when you use **F04 NEW BATCH** on display AMQ3ZA or if you use **F19 RETURN TO SELECT** on any Transaction Entry display.

```

DATE **/**/**          ENTER TRANSACTIONS          SELECT          AMQ34A  **

SELECT TRANSACTION aA3
1 (RLS) REPLENISHMENT BY SCHEDULE
2 (RL)  REPLENISHMENT BY LOCATION
3 (CL)  COMPONENT TRANSFER TO LINE
4 (CN)  COMPONENT RETURN TO STORES
5 (RM)  SCHEDULE RECEIPTS
6 (RO)  OPERATION REPORTING
7 (SM)  SCHEDULE SCRAP
8 (SC)  COMPONENT SCRAP
9 (PS)  PRODUCTION STATUS

F09 REVIEW ALL
F24 DISPLAY STATUS
+

```

### What to do

- To select the type of transaction to be entered in the batch, do one of the following:
  - To enter a Replenishment by Schedule transaction, type **1** or **RLS** in the **SELECT TRANSACTION** field, press **Enter**. Go to display AMQ34B3.
  - To enter a Replenishment by Location transaction, type **2** or **RLL** in the **SELECT TRANSACTION** field, press **Enter**. Go to display AMQ34B1.
  - To enter a Component Transfer to Line transaction, type **3** or **CL** in the **SELECT TRANSACTION** field, press **Enter**. Go to display AMQ34C1.
  - To enter a Component Return to Stores transaction, type **4** or **CN** in the **SELECT TRANSACTION** field, press **Enter**. Go to display AMQ34D1.
  - To enter a Schedule Receipts transaction, type **5** or **RM** in the **SELECT TRANSACTION** field, press **Enter**. Go to display AMQ34E1.
  - To enter an Operation Reporting transaction, type **6** or **RO** in the **SELECT TRANSACTION** field, press **Enter**. Go to display AMQ34F1.
  - To enter a Schedule Scrap transaction, type **7** or **SM** in the **SELECT TRANSACTION** field, press **Enter**. Go to display AMQ34G1.
  - To enter a Component Scrap transaction, type **8** or **SC** in the **SELECT TRANSACTION** field, press **Enter**. Go to display AMQ34H1.
  - To enter a Production Status transaction, type **9** or **PS** in the **SELECT TRANSACTION** field, press **Enter**. Go to display AMQ34I1.

- To review the transactions entered in the batch, use **F09**. Go to display AMQ34J.

### Function keys

F09 REVIEW ALL causes the Enter Transactions, Review Summary (Review) display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F24 DISPLAY STATUS goes to display AMQ34K, which shows the number of records maintained.

### Fields

**SELECT TRANSACTION (TRCDE)**. Required. Type in one of the following transaction codes:

- 1 (RLS) Replenishment request by schedule
- 2 (RLL) Replenishment request by location
- 3 (CL) Component transfer to line
- 4 (CN) Component return to stores
- 5 (RM) Schedule receipts
- 6 (RO) Operation reporting
- 7 (SM) Schedule scrap
- 8 (SC) Component scrap
- 9 (PS) Production status

## AMQ34BR—Enter Transactions, Replenishment (Review)

Use this display to reverse transactions in the batch, review previously reversed transactions, or correct error transactions from offline entry.

This display appears after you select a Replenishment transaction on the Enter Transactions, Review Summary display (AMQ34J).

```

DATE **/**/**                ENTER TRANSACTIONS          REVIEW    AMQ34BR **
                              REPLENISHMENT

REV                             PRTY      SCHEDULE      S-NUMBER
A                               *          *****
*****

WH  LINE  SCHED ITEM          *****          SCHED DATE
***  *****  *****          *****          **/**/**

SEQ  COMPONENT          *****          TRAN DATE
***  *****          *****          **/**/**

LINE LOC  --- QUANTITY ---
*****  CNTRS  PIECES
*****  ***  ***** .***

REASON  REFERENCE          F02 NEXT TRANSACTION
*****  *****          F09 REVIEW ALL
*****  *****          F19 RETURN TO SELECT
*****  *****          F20 DELETE RECORD
+

```

## What to do

If the **REV** field is blank, you can type in **R** to reverse the transaction. If the **REV** field already shows an **R**, then all other fields on the display are output only. If the **REV** field shows an **E**, then you can type in corrections for the transaction.

- To review the next selected transaction, use **F02**.

**Note:** If other transaction types have been selected, those review displays will be shown. If no more transactions have been selected, go to display AMQ34J.

- To review the transactions you entered in the batch, use **F09**. Go to display AMQ34J.
- To return to the Enter Transactions (Select) display (AMQ34A), use **F19**.
- To delete an error transaction, use **F20**.

**Note:** If other transaction types have been selected, those review displays will be shown. If no more transactions have been selected, go to display AMQ34J.

## Function keys

F02 NEXT TRANSACTION presents the next selected transaction for review.

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another transaction.

F20 DELETE RECORD deletes the record shown from the batch after you use the function key twice.

## Fields

All fields on this display are optional if the **REV** field is E (Error). If the **REV** field is not E, they are for information only.

**REV (Reversal Code) (REVCD).** Type in the reversal code for the transaction record:

**blank** Normal transaction. This code appears for valid transactions. Files were updated.

**E** Error. Transaction has failed an edit check. The files were not updated. An error transaction will become a normal transaction when corrected and posted.

**R** Reversed. If you type in R, the transaction is reversed and processed again. You cannot change a reversed transaction.

**PRTY (Priority) (PRDRT).** The priority code for components.

**Y** Yes. Item is immediately needed at its line location.

**N** No. Item can be sent to the line location within the normal replenishment cycle.

**SCHEDULE.** The schedule number assigned to each scheduled item.

**S-NUMBER (SNMBR).** The features and options code for the scheduled item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**WH (Warehouse) (HOUSE).** The warehouse from which components are issued and the finished items are received.

**LINE (PLINE).** The code of the production line.

**SCHED ITEM (FITEM).** The scheduled item.

**SCHED DATE (ODUDT).** The date that the item's schedule is due to be completed.

**SEQ (USRSQ).** The user-defined sequence number used to uniquely identify the component.

**COMPONENT (CITEM).** The material used in the production of the scheduled item.

**TRAN DATE (TDATE).** The date that the transaction occurred.

**LINE LOC (DLOCN).** The location on the production line where the component is normally delivered.

**QUANTITY CNTRS (CNQTY).** The number of full containers selected for this transaction, but not exceeding the maximum quantity allowed.

**QUANTITY PIECES (PCQTY).** The number of pieces in a partial container to satisfy this transaction.

**REASON (REASN).** A code that explains the reason for this transaction. This code is assigned by your company.

**REFERENCE (REFNO).** The user-defined code used to provide additional information.

## AMQ34B1—Enter Transactions, Replenishment by Location (Select)

Use this display to select a location to enter a replenishment request based on component usage. If requirements still exist, they will print on the pick list based on replenishment rules defined in the Location Component file. All schedules with components in that location are shown.

This display appears after you select REPLENISHMENT BY LOCATION (RLL) on display AMQ34A.

```
DATE **/**/**          ENTER TRANSACTIONS          SELECT    AMQ34B1 **
                        REPLENISHMENT BY LOCATION

WH aA3  LINE LOC aaaaaA7  LINE aaaA5  COMPONENT aaaaaaaaaaaaaA15

                                F09 REVIEW ALL
                                F19 RETURN TO SELECT
                                +
```

### What to do

- To enter a transaction, type in the information you need and press **Enter**. Go to display AMQ34B2.
- To review the transactions you entered in the batch, use **F09**. Go to display AMQ34J.
- To return to the Enter Transactions (Select) display (AMQ34A), use **F19**.

### Function keys

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another record.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WH (Warehouse) (HOUSE) [?]**. Required. This field contains the value of the default planning warehouse. Type in the code of the warehouse from which components are issued and the finished items received.

**LINE LOC (DLOCN)**. Type in the location on the production line where the component is normally delivered.

**LINE (PLINE) [?]**. Type in the production line where the usage occurred.

**COMPONENT (CITEM) [?]**. Type in the material used in the production of the scheduled item.

## AMQ34B2—Enter Transactions, Replenishment by Location (Entry)

Use this display to enter component usage at specific line locations. This transaction may initiate a replenishment for the used material if allocations for the schedule still exist. **F11 POSITION TO** shows you a window that allows you to go to a specific line location, line, and component.

This display appears after you enter valid location data on display AMQ34B1.

```

DATE **/**/**                ENTER TRANSACTIONS          ENTRY      AMQ34B2 **
                             REPLENISHMENT BY LOCATION

WH ***  LINE LOC *****  LINE *****  COMPONENT *****

NUMBER OF RECORDS TO ROLL nnnn

LINE LOC LINE  COMPONENT          SEQ          --- QUANTITY ---
TRAN DATE REASON REFERENCE  SCHED DATE SCHED ITEM  CNTRS  PIECES PRY
                               S-NUMBER
*****  *****  *****  *****  *****  *****  *****  *****
999999  aaaaA6  aaaaaaaA10  **/**/**  *****  *****  *****  ***
*****  *****  *****  *****  *****  *****  *****  *****
999999  aaaaA6  aaaaaaaA10  **/**/**  *****  *****  *****  ***
*****  *****  *****  *****  *****  *****  *****  *****
999999  aaaaA6  aaaaaaaA10  **/**/**  *****  *****  *****  ***

                               F12 ADDITIONAL FIELDS
                               F18 REFRESH DISPLAY
                               F19 RETURN TO SELECT
                               +

USE ROLL UP/DOWN          F09 REVIEW ALL
F03 PREVIOUS DISPLAY      F11 POSITION TO

```

### What to do

- To update the transaction file, enter the information you need and press **Enter**. Go to display AMQ34B1.
- To return to the Enter Transactions Replenishment by Location (RLL) (Select) display (AMQ34B1), use **F03**. Go to display AMQ34B1.

- To review all the transactions you entered in the batch, use **F09**. Go to display AMQ34J.
- To view a specific transaction, use **F11** and type the required information in the **POSITION TO** window. Press **Enter** to skip to the specific record. The window disappears when you press **Enter** a second time.
- To see additional fields, use **F12**. To return to the original display format, use **F12** again.
- To cancel what you typed in on this display, use **F18**.
- To go to the Enter Transactions (Select) display (AMQ34A), use **F19**.

## Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of locations.

F03 PREVIOUS DISPLAY shows you the Replenishment by Location display (AMQ34B1).

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F11 POSITION TO shows you a window that allows you to find a specific location, line, and component.

F12 ADDITIONAL FIELDS allows you to review the second line of fields on the display. Using **F12** a second time returns you to the original format of one line of fields.

F18 REFRESH DISPLAY shows the display again without any changes made.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another transaction.

## Fields

**WH (Warehouse) (HOUSE)**. The warehouse from which components are issued and the finished items are received.

**LINE LOC (DLOCN)**. The location on the production line where the component is normally used.

**LINE (PLINE)**. The code of the production line where the transaction occurred.

**COMPONENT (CITEM)**. The material used in the production of the scheduled item.

**NUMBER OF RECORDS TO ROLL (ROLFC)**. Type in the number of records that you want to skip as you page through the records.

**LINE LOC (DLOCN)**. The location on the production line where the component is normally used.

**LINE (PLINE)**. The code of the production line where the transaction occurred.

**COMPONENT (CITEM).** The material used in the production of the scheduled item.

**SEQ (USRSQ).** The component user-defined sequence number for this transaction.

**QUANTITY CNTRS (CNQTY).** Required. Type in the number of full containers used at a location.

**QUANTITY PIECES (PCQTY).** Required. Type in the number of pieces in a partial container used at a location.

**PRTY (Priority) (PRORT).** The priority code for components. Type in **Y** (Yes) or **N** (No):

**Y** Item is immediately needed at its line location.

**N** Item can be sent to the line location within the normal replenishment cycle.

**TRAN DATE (TDATE).** Type in the date that the transaction occurred.

**REASON (REASN).** Type in a code that explains the reason for this transaction. This code is assigned by your company.

**REFERENCE (REFNO).** Type in the user-defined code used to provide additional information.

**SCHED DATE (ODUPT).** The date that the item's schedule is due to be completed.

**SCHED ITEM (FITEM).** The scheduled item for which you used this material.

**SCH NBR (ORDNO).** The schedule number for the item for which you used this material.

**RUN SEQ .** The run sequence number for the schedule for this item.

**S-NUMBER (SNMBR).** The features and options code for the scheduled item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.



## AMQ34B3—Enter Transactions, Replenishment by Schedule (Select)

Use this display to select items to enter a replenishment request based on component usage by schedule and to generate any additional replenishment requirements. If requirements still exist they will print on the pick list based on replenishment rules defined in the Location Component file. The selected schedule will appear on the next display (AMQ34B4). You can select a specific schedule by entering the number in the **SCHED NUMBER** field.

This display appears after you select REPLENISHMENT BY SCHEDULE (RLS) on display AMQ34A.

```
DATE **/**/**                ENTER TRANSACTIONS          SELECT    AMQ34B3 **
                             REPLENISHMENT BY SCHEDULE

WH aA3  LINE aaaA5  SCHED ITEM aaaaaaaaaaaaaA15 *****
SCHED DATE nnnnnn  S-NUMBER aaaaaaaaaaaaaA20
OR
SCHED NUMBER aaaaaA7

                                     F09 REVIEW ALL
                                     F19 RETURN TO SELECT
                                     +
```

### What to do

- To enter a transaction, type in the information you need and press **Enter**. Go to display AMQ34B4.
- To review the transactions entered in the batch, use **F09**. Go to display AMQ34J.
- To return to the Enter Transactions (Select) display (AMQ34A), use **F19**.

### Function keys

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another record.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

If you do not enter the schedule number, all of the fields on this display are required.

**WH (Warehouse) (HOUSE) [?]**. This field contains the value of the default planning warehouse. Type in the code of the warehouse from which components are issued and the finished items received.

**LINE (PLINE) [?]**. Type in the production line where the schedule is produced.

**SCHED ITEM (FITEM) [?]**. Type in the scheduled item against which you want to report.

**SCHED DATE (ODUDT)**. Type in the date that the item's schedule is due to be completed.

**S-NUMBER (SNMBR) [?]**. Type in the features and options code for the scheduled item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**SCHED NUMBER (ORDNO)**. Type in the schedule number for which you want to report. This is an optional field.

## AMQ34B4—Enter Transactions, Replenishment by Schedule (Entry)

Use this display to report component usage by line locations for a selected schedule. If additional replenishment requirements exist for the schedules, you can use the display to generate the requirements on the Replenishments file. **F11 POSITION TO** shows you a window that allows you to go to a line location and component.

This display appears after you enter valid schedule data on display AMQ34B3.

```

DATE **/**/**                ENTER TRANSACTIONS                ENTRY                AMQ34B4 **
                             REPLENISHMENT BY SCHEDULE

WH ***  LINE *****  SCHED ITEM *****
SCHED DATE *****  SCHED NUMBER *****  S-NUMBER *****

NUMBER OF RECORDS TO ROLL nnnn

LINE LOC  COMPONENT      SEQ  --- QUANTITY ---  TRAN
*****  *****  *****  CNTRS  PIECES  PRTY  DATE  REASON  REFERENCE
*****  *****  *****  nnn  nnnnnnn.nnn  A  nnnnnn  aaaaA6  aaaaaaaA1
*****  *****  *****  nnn  nnnnnnn.nnn  A  nnnnnn  aaaaA6  aaaaaaaA1
*****  *****  *****  nnn  nnnnnnn.nnn  A  nnnnnn  aaaaA6  aaaaaaaA1
*****  *****  *****  nnn  nnnnnnn.nnn  A  nnnnnn  aaaaA6  aaaaaaaA1
*****  *****  *****  nnn  nnnnnnn.nnn  A  nnnnnn  aaaaA6  aaaaaaaA1
*****  *****  *****  nnn  nnnnnnn.nnn  A  nnnnnn  aaaaA6  aaaaaaaA1
*****  *****  *****  nnn  nnnnnnn.nnn  A  nnnnnn  aaaaA6  aaaaaaaA1
*****  *****  *****  nnn  nnnnnnn.nnn  A  nnnnnn  aaaaA6  aaaaaaaA1
*****  *****  *****  nnn  nnnnnnn.nnn  A  nnnnnn  aaaaA6  aaaaaaaA1
*****  *****  *****  nnn  nnnnnnn.nnn  A  nnnnnn  aaaaA6  aaaaaaaA1

USE ROLL UP/DOWN          F09 REVIEW ALL          F18 REFRESH DISPLAY
F03 PREVIOUS DISPLAY      F11 POSITION TO          F19 RETURN TO SELECT
                                                                    +

```

```

DATE **/**/**                ENTER TRANSACTIONS                ENTRY                AMQ34B4 **
                             REPLENISHMENT BY SCHEDULE=====
WH ***  LINE *****  SCHED ITEM *****  | POSITION TO
SCHED DATE *****  SCHED NUMBER *****  S-NUMBE | LINE LOC aaaaaA7
                                                | COMPONENT aaaaaaaaaA15
                                                =====

```

### What to do

- To update the transaction file, enter the information you need and press **Enter** Go to display AMQ34B3.
- To return to the Enter Transactions Replenishment by Schedule (RLS) (Select) display (AMQ34B3), use **F03**. Go to display AMQ34B3.
- To review all the transactions you entered in the batch, use **F09**. Go to display AMQ34J.
- To view a specific transaction, use **F11** and type the required information in the **POSITION TO** window. Press **Enter** to skip to the specific record. The window disappears when you press **Enter** a second time.
- To cancel what you typed in on this display, use **F18**.
- To go to the Enter Transactions (Select) display (AMQ34A), use **F19**.

### Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of locations.

F02 NEXT SCHEDULE shows you the next schedule in the list.

F03 PREVIOUS DISPLAY shows you the Select display (AMQ34B3).

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F11 POSITION TO shows you a window that allows you to go to a specific line location or component.

F18 REFRESH DISPLAY shows the display again without any changes made since the last update.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another record.

## Fields

**WH (Warehouse) (FITWH).** The warehouse from which components are issued and finished items are received.

**LINE (PLINE).** The production line you selected on the previous display.

**SCHED ITEM (FITEM).** The item for which you want to enter transactions.

**SCHED DATE (ODUDT).** The date that the item's schedule is due to be completed.

**SCHED NUMBER (ORDNO).** The schedule number for the item.

**S-NUMBER (SNMBR).** The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**NUMBER OF RECORDS TO ROLL (ROLFC).** Type in the number of records that you want to skip as you page through the records.

**LINE LOC (DLOCN).** The location on the production line where the component is normally delivered/used.

**COMPONENT (CITEM).** The material used in the production of the scheduled item.

**SEQ (USRSQ).** The user-defined sequence number used to uniquely identify the component.

**QUANTITY CNTRS (CNQTY).** Required. Type in the number of full containers used at a location.

**QUANTITY PIECES (PCQTY).** Required. Type in the number of pieces in a partial container used at a location.

**PRTY (Priority) (PRORT).** The priority code for components.

**Y** Yes. Item is immediately needed at its line location.

**N** No. Item can be sent to the line location within the normal replenishment cycle.

**TRAN DATE (TDATE).** Type in the date that the transaction occurred.

**REASON (REASN).** Type in a code that explains the reason for this transaction. This code is assigned by your company.

**REFERENCE (REFNO).** Type in the user-defined code used to provide additional information.

## AMQ34CR—Enter Transactions, Component Transfer to Line (Review)

Use this display to reverse transactions, review previously reversed transactions, or correct error transactions from offline entry.

This display appears after you select a COMPONENT TRANSFER TO LINE (CL) transaction on display AMQ34J.

```

DATE **/**/**          ENTER TRANSACTIONS          REVIEW          AMQ34CR **
                        COMPONENT TRANSFER TO LINE

REV                     PICK NBR    REF NBR
A                       *****    ****

WH
***

                        COMPONENT
                        *****

LINE LOC                --- PICK QTY ---
                        CNTRS    PIECES  CNL BATCH/LOT    FIFO
*****                 ***  *****.***  *  *****    **/**/**

SPL LOC                 --- REPLN QTY ---
                        CNTRS    PIECES
*****                 ***  *****.***

REASON  REFERENCE
*****  *****

F02 NEXT TRANSACTION
F09 REVIEW ALL
F19 RETURN TO SELECT
F20 DELETE RECORD
    
```

### What to do

If the **REV** field is blank, you can type in **R** to reverse the transaction. If the **REV** field already shows an R, then all other fields on the display are output only. If the **REV** field shows an E, then you can type in corrections for the transaction.

- To review the next selected transaction, use **F02**.

**Note:** If other transaction types have been selected, those review displays will be shown. If no more transactions have been selected, go to display AMQ34J.

- To review the transactions you entered in the batch, use **F09**. Go to display AMQ34J.

- To return to the Enter Transactions (Select) display (AMQ34A), use **F19**.
- To delete an error transaction, use **F20**.

**Note:** If other transaction types have been selected, those review displays will be shown. If no more transactions have been selected, go to display AMQ34J.

## Function keys

F02 NEXT TRANSACTION presents the next transaction selected from the Enter Transactions, Review Summary display (AMQ34J) for review.

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another transaction.

F20 DELETE RECORD deletes the selected record from the batch after you use the function key twice.

## Fields

All fields on this display are optional if the **REV** field is E (Error). If the **REV** field is not E, they are for information only.

**REV (Reversal Code) (REVCD).** Type in the reversal code for the transaction record:

**blank** Normal transaction. This code appears for valid transactions. Files were updated.

**E** Error. Transaction has failed an edit check. The files are not updated. An error transaction will become a normal transaction when corrected and posted.

**R** Reversed. If you type in R, the transaction is reversed and processed again. You cannot change a reversed transaction.

**PICK NBR (PLIST).** The pick list number for the replenishment record shown.

**REF NBR (PNREF).** The reference number that identifies a specific line number on a return list.

**SCHEDULE.** The schedule number that you entered into the offline file.

**WH (Warehouse) (HOUSE).** The warehouse from which components are issued and the finished items are received.

**COMPONENT (CITEM).** The material used in the production of the scheduled item.

**TRAN DATE (TDATE).** The date that the transaction occurred.

**LINE LOC (DLOCN).** The location on the production line where the component is normally delivered.

**PICK QTY CNTRS (CNQTY).** The number of full containers used at a location.

**PICK QTY PIECES (PCQTY).** The number of pieces in a partial container used at a location.

**CNL (CNLRP).** The cancel replenishment code that designates if a replenishment record is to be deleted.

**blank** Do not delete the record  
**1** Delete the record.

**BATCH/LOT (LBHNO).** The batch/lot number assigned to this item lot. You can only edit batch/lot numbers if you select batch/lot support during Inventory Management application tailoring.

**FIFO (First In First Out) (FDATE).** The date that the item was originally received into inventory. FIFO dates appear if you select FIFO support during Inventory Management application tailoring.

**SPL LOC (Supply Location) (SLOCN).** The location that supplies components to the line locations for replenishment.

**REPLN QTY CNTRS (REQQC).** The container quantity required for the schedule or component.

**REPLN QTY PIECES (REQQP).** The pieces in a partial container required for the schedule or component.

**REASON (REASN).** A code that explains the reason for this transaction. This code is assigned by your company.

**REFERENCE (REFNO).** The user-defined code used to provide additional information.

## AMQ34C1—Enter Transactions, Component Transfer to Line (Select)

Use this display to select Pick Lists to report the movement of components from the supply location to the line locations.

This display appears after you select a COMPONENT TRANSFER TO LINE transaction on display AMQ34A.

```
DATE **/**/**          ENTER TRANSACTIONS          SELECT          AMQ34C1 **
                        COMPONENT TRANSFER TO LINE
                        PICK LIST NBR  nnnnn

F09 REVIEW ALL
F19 RETURN TO SELECT  +
```

### What to do

- To enter a transaction, type in the information you need and press **Enter**. Go to display AMQ34C2.
- To review the transactions you entered in the batch, use **F09**. Go to display AMQ34J.
- To return to the Enter Transactions (Select) display (AMQ34A), use **F19**.

### Function keys

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another record.

### Fields

**PICK LIST NBR (PLIST)**. Required. Type in a pick list that is assigned to the replenishments.



## AMQ34C2—Enter Transactions, Component Transfer to Line (Entry)

Use this display to report the movement of components from supply locations to line locations.

This display appears after you enter a valid pick list number on display AMQ34C1.

```
DATE **/**/**                ENTER TRANSACTIONS      ENTRY      AMQ34C2 **
                              COMPONENT TRANSFER TO LINE

POSITION TO REFERENCE NBR nnnn  PICK LIST NBR *****   FINAL TRANSFER <Y,N> A

REF      LINE      --- PICK QTY ---      TRAN
 NBR COMPONENT      LOC      REPLN QTY CNTRS  PIECES CNL SPL LOC DATE
WH      REASON REFERENCE BATCH/LOT FIFO
****  *****  *****  ***** .*** nnn nnnnnnn.nnn * ***** nnnnnn
***  *****  *****  ***** aaaaA6 aaaaaaaA10 ***** **/**/**
****  *****  *****  ***** .*** nnn nnnnnnn.nnn * ***** nnnnnn
***  *****  *****  ***** aaaaA6 aaaaaaaA10 ***** **/**/**
****  *****  *****  ***** .*** nnn nnnnnnn.nnn * ***** nnnnnn
***  *****  *****  ***** aaaaA6 aaaaaaaA10 ***** **/**/**
****  *****  *****  ***** .*** nnn nnnnnnn.nnn * ***** nnnnnn
***  *****  *****  ***** aaaaA6 aaaaaaaA10 ***** **/**/**
****  *****  *****  ***** .*** nnn nnnnnnn.nnn * ***** nnnnnn
***  *****  *****  ***** aaaaA6 aaaaaaaA10 ***** **/**/** +

USE ROLL UP/DOWN      F09 REVIEW ALL   F14 ZERO PICK/RTN   F18 REFRESH DISPLAY
F03 PREVIOUS DISPLAY  F12 ADDITIONAL FIELDS      F19 RETURN TO SELECT
                                                                +
```

### What to do

- To update the transaction file, press **Enter**. Go to display AMQ34C1.
- To return to the Enter Transactions Component Transfer to Line (CL) (Select) display (AMQ34C1), use **F03**. Go to display AMQ34C1.
- To review all the transactions you entered in the batch, use **F09**. Go to display AMQ34J.
- To see additional fields, use **F12**. To return to the original display format, use **F12** again.
- To cancel what you typed in on this display, use **F18**.
- To go to the Enter Transactions (Select) display (AMQ34A), use **F19**.

### Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of transactions.

F03 PREVIOUS DISPLAY shows you the previous display (AMQ34C1).

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F12 ADDITIONAL FIELDS allows you to review the second line of fields on the display. Using **F12** a second time returns you to the original format of one line of fields.

**Note:** Using **F12** will remove all prior changes from the display.

F14 ZERO PICK/RTN allows you to set the Pick quantity in the **CNTRS** field and PIECES field to zero for all components displayed.

F18 REFRESH DISPLAY shows the display again without any changes made.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another record.

## Fields

**POSITION TO REFERENCE NBR (POSTO).** Type in the reference number you want to review.

**Note:** When using the Position to field, you must press **Enter** after typing the quantity for each reference number.

**PICK LIST NBR (PLIST).** The pick list for the replenishment record shown.

**FINAL TRANSFER <Y,N> (LASTT).** Type in **Y** (Yes) or **N** (No):

**Y** This is the last transfer transaction for this Pick List number. Items with a pick quantity of zero and partially picked items will appear on a future list.

**N** This is not the last transfer transaction for this Pick List number. Items with a pick quantity of zero and partially picked items will appear on a future list.

**Note:** The status screen will show no transaction if you do a CL transaction for zero quantity with N for final transfer.

**REF NBR (PNREF).** The reference number that identifies a specific line number on a pick list.

**COMPONENT (CITEM).** The material that is to be transferred to the line location.

**LINE LOC (DLOCN).** The location on the production line where the component is normally delivered.

**REPLN QTY (TOLQY).** The quantity required by a line location to bring it up to maximum containers.

**PICK QTY CNTRS (CNQTY).** Type in the number of full containers to be transferred to a line location.

**PICK QTY PIECES (PCQTY).** Type in the number of pieces in a partial container to be transferred to a line location.

**CNL (CNLRP).** The cancel replenishment code which designates if a replenishment record is to be deleted. Type in **1** to delete a replenishment record.

**SPL LOC (Supply Location) (SLOCN).** The location in the warehouse from which items are to be transferred.

**TRAN DATE (TDATE).** Type in the date that the transaction occurred.

**WH (Warehouse) (HOUSE).** The warehouse from which components are issued and the finished items are received.

**REASON (REASN).** Type in a code that explains the reason for this transaction. This code is assigned by your company.

**REFERENCE (REFNO).** Type in the user-defined code used to provide additional information.

**BATCH/LOT (LBHNO).** The batch/lot number assigned to an item lot. You can only edit batch/lot numbers if you selected batch/lot support during application tailoring.

**FIFO (First In First Out) (FDATE).** The date the item was originally received into inventory. FIFO dates appear if you select FIFO support during application tailoring.

## AMQ34DR—Enter Transactions, Component Return to Stores (Review)

Use this display to reverse transactions, review previously reversed transactions, or correct error transactions from offline entry.

This display appears after you select a COMPONENT RETURN TO STORES (CN) transaction on the Enter Transactions, Review Summary display (AMQ34J).

```

DATE **/**/**                ENTER TRANSACTIONS          REVIEW    AMQ34DR **
                              COMPONENT RETURN TO STORES

REV      RETURN NBR REF NBR
A        *****      ****

WH
***

                              COMPONENT                      TRAN DATE
                              *****                      **/**/**

LINE LOC  -- RETURN QTY --
          CNTRS  PIECES    BATCH/LOT    FIFO
          ***** **  *****.**  ***** **/**/**

STK LOC   - ADJUSTED QTY -
          CNTRS  PIECES    TRANSFERRED QTY
          ***** **  *****.**  CNTRS  PIECES
          ***** **  *****.**

REASON  REFERENCE  RESUPPLY
*****  *****  *
                                         F02 NEXT TRANSACTION
                                         F09 REVIEW ALL
                                         F19 RETURN TO SELECT
                                         F20 DELETE RECORD
    
```

### What to do

If the **REV** field is blank, you can type in **R** to reverse the transaction. If the **REV** field already shows an R, then all other fields on the display are output only. If the **REV** field shows an E, then you can type in corrections for the transaction.

- To review the next selected transaction, use **F02**.

**Note:** If other transaction types have been selected, those review displays will be shown. If no more transactions have been selected, go to display AMQ34J.

- To review the transactions you entered in the batch, use **F09**. Go to display AMQ34J.
- To return to the Enter Transactions (Select) display (AMQ34A), use **F19**.
- To delete an error transaction, use **F20**.

**Note:** If other transaction types have been selected, those review displays will be shown. If no more transactions have been selected, go to display AMQ34J.

## Function keys

**F02 NEXT TRANSACTION** presents the next transaction selected on the Enter Transactions, Review Summary display (AMQ34J) for review.

**F09 REVIEW ALL** causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

**F19 RETURN TO SELECT** returns to the Select display (AMQ34A) so you can select another record.

**F20 DELETE RECORD** deletes the selected record from the batch after you select the function key twice.

## Fields

All fields on this display are optional if the **REV** field is E (Error). If not, they are for information only.

**REV (Reversal Code) (REVCD).** Type in the reversal code for the transaction record:

**blank** Normal transaction. This code appears for valid transactions. Files were updated.

**E** Error. Transaction has failed an edit check. The files were not updated. An error transaction will become a normal transaction when corrected and posted.

**R** Reversed. If you type in **R**, the transaction is reversed and processed again. You cannot change a reversed transaction.

**RETURN NBR (RLIST).** The return list number that is assigned to components being returned to supply locations from their line locations.

**REF NBR (RNREF).** The reference number that identifies a specific line number on a return list.

**SCHEDULE.** The schedule number that you entered into the offline file.

**WH (Warehouse) (HOUSE).** The warehouse from which components are issued and the finished items are received.

**COMPONENT (CITEM).** The material used in the production of the scheduled item.

**TRAN DATE (TDATE).** The date the transaction occurred.

**LINE LOC (DLOCN).** The location on the production line where the component is normally delivered.

**RETURN QTY CNTRS (CNQTY).** The number of full containers returned to stores.

**RETURN QTY PIECES (PCQTY).** The number of pieces in a partial container returned to stores.

**BATCH/LOT (LBHNO).** The batch/lot number assigned to an item lot. You can only edit batch/lot numbers if you selected batch/lot support during application tailoring.

**FIFO (First In First Out) (FDATE).** The date the item lot was originally received into inventory. FIFO dates appear if you select FIFO support during application tailoring.

**STK LOC (Stock Location) (SLOCN).** The location of an item in the warehouse.

**TRANSFERRED QTY CNTRS (REQQC).** The quantity of containers picked for the schedule or component.

**TRANSFERRED QTY PIECES (REQQP).** The quantity of pieces in partial containers picked for the schedule or component.

**REASON (REASN).** A code that explains the reason for this transaction. This code is assigned by your company.

**REFERENCE (REFNO).** The user-defined code used to provide additional information.

**RESUPPLY (RSPFA).** A code that tells the replenishment system whether or not material needs to be resupplied at the line location:

- 0** No. Material does not need to be resupplied at the line location.
- 1** Yes. Material needs to be resupplied at the line location.

## AMQ34D1—Enter Transactions, Component Return to Stores (Select)

Use this display to select return lists to move components from the line location to the stock location. This number will automatically generate transactions for all items on the list.

This display appears after you select a COMPONENT RETURN TO STORES transaction on display AMQ34A.

```
DATE **/**/**          ENTER TRANSACTIONS          SELECT          AMQ34D1 **
                        COMPONENT RETURN TO STORES
                        RETURN LIST NBR  nnnnn

F09 REVIEW ALL
F19 RETURN TO SELECT  +
```

### What to do

- To enter a transaction, type in the information you need and press **Enter**. Go to display AMQ34D2.
- To review the transactions you entered in the batch, use **F09**. Go to display AMQ34J.
- To return to the Enter Transactions (Select) display (AMQ34A), use **F19**.

### Function keys

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another record.

### Fields

**RETURN LIST NBR (RLIST)**. Required. Type in a return list number that is assigned to the returning components.

## AMQ34D2—Enter Transactions, Component Return to Stores (Entry)

Use this display to report the movement of components from the line location back to the stock location.

This display appears after you enter valid data on the Select display (AMQ34D1).

```

DATE **/**/**          ENTER TRANSACTIONS          ENTRY          AMQ34D2 **
                        COMPONENT RETURN TO STORES

POSITION TO REFERENCE NBR nnnnn RETURN LIST NBR ***** FINAL TRANSFER <Y,N> A

REF COMPONENT          LINE LOC  TRNSFR QTY  -- RETURN QTY --  STK LOC  TRAN DATE
WH                                ADJUST QTY  REASON  REFERENCE
BATCH/LOT  FIFO DATE                                CNTRS    PIECES
**** *****          *****          ***** .***  nnn nnnnnnn.nnn  aaaaaA7  nnnnnn
*** *****          *****          *****          nnn nnnnnnn.nnn  aaaaA6  aaaaaaA10
***** **/**/**
**** *****          *****          ***** .***  nnn nnnnnnn.nnn  aaaaaA7  nnnnnn
*** *****          *****          *****          nnn nnnnnnn.nnn  aaaaA6  aaaaaaA10
***** **/**/**
**** *****          *****          ***** .***  nnn nnnnnnn.nnn  aaaaaA7  nnnnnn
*** *****          *****          *****          nnn nnnnnnn.nnn  aaaaA6  aaaaaaA10
***** **/**/**
**** *****          *****          ***** .***  nnn nnnnnnn.nnn  aaaaaA7  nnnnnn
*** *****          *****          *****          nnn nnnnnnn.nnn  aaaaA6  aaaaaaA10
***** **/**/**

USE ROLL UP/DOWN      F09 REVIEW ALL   F14 ZERO PICK/RTN  F18 REFRESH DISPLAY
F03 PREVIOUS DISPLAY  F12 ADDITIONAL FIELDS          F19 RETURN TO SELECT
  
```

### What to do

- To update the transaction file, type in the information you need and press **Enter**. Go to display AMQ34D1.
- To return to the Enter Transactions Component Return to Stores (CN) (Select) display (AMQ34D1), use **F03**. Go to display AMQ34D1.
- To review all the transactions you entered in the batch, use **F09**. Go to display AMQ34J.
- To see additional fields, use **F12**. To return to the original display format, use **F12** again.
- To cancel what you typed in on this display, use **F18**.
- To go to the Enter Transactions (Select) display (AMQ34A), use **F19**.

### Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of return list numbers.

F03 PREVIOUS DISPLAY shows you the previous display (AMQ34D1).

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F12 ADDITIONAL FIELDS allows you to review the second and third lines of fields on the display. Using **F12** a second time returns you to the original format of one line of fields.

F14 ZERO PICK/RTN allows you to set the return quantity in the **CNTRS** field and **PIECES** field to zero for all components displayed.

F18 REFRESH DISPLAY shows the display again without any changes made.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another record.

## Fields

**POSITION TO REFERENCE NBR (POSTO)**. Type in the reference number to review.

**RETURN LIST NBR**. The return list number that is assigned to components being returned from the production line.

**FINAL TRANSFER <Y,N> (LASTT)**. Type in **Y** (Yes) or **N** (No):

**Y** This is the last transaction for this return list number. Items with a return quantity of zero will appear on a future list. Partially returned items will also appear on a future list.

**N** This is not the last transfer transaction for the return list number. Items with a return quantity of zero will remain on this list. Partially returned items will appear on a future list.

**REF (RNREF)**. The reference number that identifies a specific line number on a return list.

**COMPONENT (CITEM)**. The material that is to be returned to the supply location.

**LINE LOC (DLOCN)**. The location on the production line from which the component is to be returned.

**TRNSFR QTY (TOLQY)**. The calculated quantity available to be returned (picked quantity minus backflushed quantity minus returned quantity).

**RETURN QTY CNTRS (CNQTY)**. Required. Type in the number of full containers to return to a stock location.

**RETURN QTY PIECES (PCQTY)**. Required. Type in the number of pieces in a partial container to return to a stock location.

**STK LOC (SLOCN)**. Type in the location in the warehouse to which the items are to be transferred.

**TR DTE (Transaction date) (TDATE)**. Type in the date that the transaction occurred.



**R/S (RESUPPLY) (RSPFA).** Type in the code that tells the replenishment system whether or not material needs to be resupplied at the line location:

- 0** No. Material does not need to be resupplied at the line location.
- 1** Yes. Material needs to be resupplied at the line location.

**WH (Warehouse) (FITWH).** The warehouse from which components are issued and the finished items are received.

**REASON (REASN).** Type in a code that explains the reason for this transaction. This code is assigned by your company.

**REFERENCE (REFNO).** Type in the user-defined code used to provide additional information.

**BATCH/LOT (LBHNO).** The batch/lot number assigned to an item lot. You can only edit batch/lot numbers if you selected batch/lot support during application tailoring.

**FIFO (First In First Out) (FDATE).** The date the item lot was originally received into inventory. FIFO dates appear if you select FIFO support during application tailoring.

## AMQ34ER—Enter Transactions, Schedule Receipts (Review)

Use this display to reverse transactions, review previously reversed transactions, or correct error transactions from offline entry.

This display appears after you select a SCHEDULE RECEIPTS (RM) transaction on the Enter Transactions, Review Summary display (AMQ34J).

DATE **/**/**	ENTER TRANSACTIONS SCHEDULE RECEIPTS				REVIEW	AMQ34ER **
REV A	LAST TRAN A	<Y,N>	SCHEDULE *****	S-NUMBER *****		
WH	LINE	SCHED ITEM	REVISION			
***	*****	*****	*****			
				SCHED DATE **/**/**	TRAN DATE **/**/**	
		--- QUANTITY --- CNTRS      PIECES	BATCH/LOT	FIFO		
RCPT LOC *****	***	*****	*****	**/**/**		
REASON *****	REFERENCE *****	SHIFT *	CREW ***	REWORK <Y,N> *	F02 NEXT TRANSACTION F09 REVIEW ALL F19 RETURN TO SELECT F20 DELETE RECORD	+

### What to do

If the **REV** field is blank, you can type in **R** to reverse the transaction. If the **REV** field already shows an **R**, then all other fields on the display are output only. If the **REV** field shows an **E**, then you can type in corrections for the transaction.

- To review the next selected transaction, use **F02**.

**Note:** If other transaction types have been selected, those review displays will be shown. If no more transactions have been selected, go to display AMQ34J.

- To review the transactions you entered in the batch, use **F09**. Go to display AMQ34J.
- To return to the Enter Transactions (Select) display (AMQ34A), use **F19**.
- To delete an error transaction, use **F20**.

**Note:** If other transaction types have been selected, those review displays will be shown. If no more transactions have been selected, go to display AMQ34J.

## Function keys

**F02 NEXT TRANSACTION** presents the next transaction selected from the Enter Transactions, Review Summary display (AMQ34J) for review.

**F09 REVIEW ALL** causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

**F19 RETURN TO SELECT** returns to the Select display (AMQ34A) so you can select another record.

**F20 DELETE RECORD** deletes the selected record from the batch after you select the function key twice.

## Fields

All fields on this display are optional if the **REV** field is E (Error). If not, they are for information only.

**REV (Reversal Code) (WREVCD)**. Type in the reversal code for the transaction record:

**blank** Normal transaction. This code appears for valid transactions. Files were updated.

**E** Error. Transaction has failed an edit check. The files were not updated. An error transaction will become a normal transaction when corrected and posted.

**R** Reversed. If you type in **R**, the transaction is reversed and processed again. You cannot change a reversed transaction.

**Note:** If the corrected transaction is the only transaction in the batch, the next display shown is the Enter Transactions (Select) display (AMQ34A) with a message that no active or error records are in the batch. The message appears because a new record is being created and the old record has been deleted.

**LAST TRAN <Y,N>(WLAST)**. This field shows the last transaction flag:

**Y** The schedule has been completed and no more transactions are expected.

**N** The schedule has not been completed. More transactions are expected.

**SCHEDULE (WSSCH)**. The schedule number that you entered into the offline file.

**S-NUMBER (WSNMBR) [?]**. The features and options code for the scheduled item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**WH (Warehouse) (WHOUSE)**. The warehouse from which components are issued and the finished items are received.

**LINE (WPLINE)**. The code of the production line where the schedule is produced.

**SCHED ITEM (WFITEM)**. The item that you want to review.

**REVISION (WREVSN)**. This field appears only if EPDM is activated. The revision identifier associated with this item.

**SCHED DATE (WODUDT)**. The date that the item's schedule is due to be completed.

**TRAN DATE (WTDATE)**. The date that the transaction occurred.

**RCPT LOC (WWHSLC)**. The code that indicates a receipt location within a warehouse where an item is stored after completion on the production line.

**QUANTITY CNTRS (WCNQTY)**. The number of full containers received at a location.

**QUANTITY PIECES (WPCQTY)**. The number of pieces in a partial container received at a location.

**BATCH/LOT (WLBHNO)**. The batch/lot number assigned to an item lot. You can only edit batch/lot numbers if you selected batch/lot support during application tailoring.

**FIFO (First In First Out) (WFIFO)**. The date the item lot was originally received into inventory. FIFO dates appear if you select FIFO support during application tailoring.

**REASON (WREASN)**. A code that explains the reason for this transaction. This code is assigned by your company.

**REFERENCE (WREF)**. The user-defined code used to provide additional information.

**SHIFT (WSHIFT)**. A code (1, 2, or 3) that indicates which production shift reported the transaction.

**CREW (WCREWN)**. The user-defined code to identify the production crew.

**REWORK <Y,N>(WREWRK)**. The code that identifies if the receipt is for rework.

Y	Rework
N	No rework

## AMQ34E1—Enter Transactions, Schedule Receipts (Select)

Use this display to select items to enter as being completed. Schedules that match the selections you enter on this display are retrieved. You can select a specific schedule by entering the number in the **SCHED NUMBER** field.

This display appears after you select a SCHEDULE RECEIPTS (RM) transaction on display AMQ34A.

```

DATE **/**/
**          Enter Transactions          Select          AMQ34E1 **
              Scheduled Receipts

Select:
Warehouse . . . . . : aA3
Line . . . . . : aaaaA5
Scheduled item . . . : aaaaaaaaaaaaaA15
Revision . . . . . : aaaaA6
Schedule number . . . : aaaaaA6
S-number . . . . . : aaaaaaaaaaaaaaaaaA20
FIFO date . . . . . : nnnnnn
Transaction date . . : nnnnnn

Defaults:
Receipt location . . : aaaaaA7
Batch/lot ID . . . . : aaaaaaaA10
Shift . . . . . : N
Crew ID . . . . . : aA3
Receipt tolerance . . : nnn %

F09 Review All      F19 Return to Select
  
```

### What to do

- To enter a transaction, type in the schedule information you need and press **Enter**. If the system finds any schedules, go to display AMQ34E2.
- To review the transactions you entered in the batch, use **F09**. Go to display AMQ34J.
- To return to the Enter Transactions (Select) display (AMQ34A), use **F19**.

### Function keys

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another transaction.

### Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**Warehouse (WHSE1) [?]**. Type the code of the warehouse from which the components are issued and the finished items received. The original value is the default planning warehouse.

**Line (PLINE1) [?]**. Type a production line name to see a list of released schedules for this line. If left blank, all production lines for the selected warehouse will be selected.

**Scheduled item (FITEM1) [?]**. Type a scheduled item number to see a list of released schedules for this item. If left blank, all scheduled item numbers for the selected warehouse and line will be selected.

**Revision (REVSN1) [?]**. This field appears only if EPDM is activated. Accept the default of \*ALL to see all revisions. Type \*CUR to see the current revision based on the current system. Type a revision identifier instead of a schedule number to see a specific revision.

**Schedule number (ORDNO1)**. Type a schedule number to see a specific released schedule for this item. If left blank, all released schedules for the selected warehouse, line and scheduled item will be selected.

**S-Number (SNMBR1) [?]**. Required if this item has features and options. Type in the features and options code for the scheduled item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**FIFO date (First In First Out) (FIFO1)**. The date the item is to be received into inventory. FIFO date field appears only if you select FIFO support during application tailoring. It is required.

**Transaction Date (TDATE1)**. Type the transaction date. The system date appears initially. If the system date or the date you enter is not found in the CALNDR file, the previous CALNDR file date is used.

The following fields are default fields, and will be applied to each transaction. They remain in effect until changed or until the entry session is ended.

**Receipt location (WHS LC1)**. Type the code that indicates a receipt location within a warehouse where an item is stored after completion on the production line. The default value comes from the ITEM BL file.

**Batch/lot ID (LBHNO1)**. Type the batch/lot number assigned to an item. You can enter batch/lot numbers only if you selected batch/lot support during application tailoring.

**Shift (SHIFT1)**. Type the code (1, 2, or 3) that indicates which production shift reported the transaction. The default value is 1.

**Crew ID (CREWN1)**. Type the user-defined code to identify the production crew.

**Receipt tolerance (RCPT1)**. Type the percentage by which the receipt quantity for an item can exceed the open schedule quantity. The default value is defined in the REPCTL record. You can change it for this session. A blank value indicates no error checking is to be performed.

## AMQ34E2—Enter Transactions, Schedule Receipts (Entry)

Use this display to enter units completed against a schedule.

This display appears after a schedule is found to match the schedule information you enter on display AMQ34E1. The cursor is positioned to enter a container quantity. If only pieces can be entered, the cursor is positioned at the pieces field. You can signal that the schedule is to be closed by entering **Y** in the **Last Transaction** field and leave the transaction quantity at zero. The display has two views. The information on each view is layered, with View 1 allowing you to key the most commonly entered information on one line. Less commonly used information is entered through View 2.

```

Date **/**/**                Enter Transactions          Entry      AMQ34E2 **
                             Schedule Receipts

Warehouse *** Transaction date **/**/
**                               View 1 of 2

Line  Scheduled  Rev  Schedule  ----- Quantity ----- Last
   item          date    date    Remaining  Cntr    Pieces    tran

****  *****
S***** S-Nbr ***** Batch/Lot  aaaaaaaaaA10  FIFO nnnnnn  A
****  *****
S***** S-Nbr ***** Batch/Lot  aaaaaaaaaA10  FIFO nnnnnn  A
****  *****
S***** S-Nbr ***** Batch/Lot  aaaaaaaaaA10  FIFO nnnnnn  A
****  *****

Use Roll up/down      F03 View 2      F09 Review all      F11 Position to
F12 Additional fields  F18 Refresh display  F19 Return to Select

```

### What to do

- To update the transaction file, press **Enter**. Transactions are edited and processed. If no errors are detected, or after the errors are corrected, display AMQ34E1 appears.
- To review all the transactions you entered in the batch, use **F09**. Go to display AMQ34J.

### Function keys

F03 VIEW 1/ VIEW 2 allows you to toggle between the two views so you can review or enter reason and reference information.

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F11 POSITION TO shows you the Position to window so you can enter the specific line, item, or S-number for the transaction you want to see.

F12 ADDITIONAL FIELDS allows you to toggle between single and multiple lines per transaction.

F18 REFRESH DISPLAY shows the display again, without any changes made.

F19 RETURN TO SELECT returns to the Select display (AMQ34E1) so you can select another record.

## Fields

**WAREHOUSE (WHOUSE).** The warehouse code from the previous display.

**TRANSACTION DATE (WTDATE).** The transaction date from the previous display.

**LINE (WPLINE).** The production line where the scheduled receipt is produced.

**SCHEDULED ITEM (WFITEM).** The scheduled item being produced.

**REV (Revision).** This field appears only if EPDM is activated. The revision identifier associated with the item being produced.

**SCHEDULE DATE (WODUDT).** The date the schedule is due. If the 'post to oldest' function is active, the date displayed is the latest due date of the schedules grouped into the transaction.

**QUANTITY REMAINING (@OPEN).** The open quantity for the schedule. If the 'post to oldest' function is active, this will be the total of the open quantities of all the schedules grouped into the transaction.

**QUANTITY CNTR (WCNQTY).** Required. Type in the number of full containers completed. If this item is reported only in pieces, this field is not input capable.

**QUANTITY PIECES (WPCQTY).** Required. Type in the number of pieces in a partial container completed.

**LAST TRAN <Y,N>(WLAST).** Type in **Y** (Yes) or **N** (No):

- Y** The schedule has been completed and no more transactions are expected.
- N** The schedule has not been completed. More transactions are expected.

This field is displayed only for a transaction for a single schedule. If the 'post to oldest' function is active, and this transaction is for a group of schedules, this field does not appear. The 'post to oldest' function will control the last transaction flag.

**SCHED NUMBER (WSSCH).** The schedule number is displayed if this is a single schedule. If the 'post to oldest' function is active and the transaction is for a group of schedules, this field is blank.

**S-NUMBER (WSNMBR).** The S-number selected on the previous display.

**BATCH/LOT (WLBHNO).** Type the batch/lot number assigned to an item lot. The original value comes from the previous display. This field is not displayed if batch/lot support was not selected during application tailoring.

**FIFO (First In First Out) (WFIFO).** Type the date the item lot is to be received into inventory. FIFO dates do not appear if you did not select FIFO support during application tailoring.

The following fields appear only on View 2:

**REASON (WREASN).** Type in a code that explains the reason for this transaction. This code is assigned by your company.

**REWORK <Y,N>(WREWRK).** Type in the code that identifies if the receipt is for rework.

**Y**        Rework  
**N**        No rework

**REFERENCE (WREF).** Type in the user-defined code used to provide additional information.

**RECEIPT LOCATION (WWHSLC).** Type in the code that indicates a receipt location within a warehouse where an item is stored after completion on the production line. The original value is from the previous display.

**SHIFT (WSHIFT).** Type in **1**, **2**, or **3** that indicates which production shift reported the transaction. The original value is from the previous display.

**CREW (WCREWN).** Type in the user-defined code to identify the production crew. The original value is from the previous display.

## AMQ34FR—Enter Transactions, Operation Reporting (Review)

Use this display to reverse transactions in the batch, review previously reversed transactions, or correct error transactions from offline entry.

This display appears after you select an OPERATION REPORTING (RO) transaction on display AMQ34J.

DATE **/**/**	ENTER TRANSACTIONS OPERATION REPORTING	REVIEW	AMQ34FR **
REV OPER A ****	SCHEDULE *****	S-NUMBER *****	
WH LINE SCHED ITEM *** *****	*****		REVISION *****
		SCHED DATE **/**/**	TRAN DATE **/**/**
	--- QUANTITY --- CNTRS        PIECES ***        *****    ***		
REASON REFERENCE SHIFT CREW *****        *****        *        ***		F02 NEXT TRANSACTION F09 REVIEW ALL F19 RETURN TO SELECT F20 DELETE RECORD	+



## What to do

If the **REV** field is blank, you can type in **R** to reverse the transaction. If the **REV** field already shows an R, then all other fields on the display are output only. If the **REV** field shows an E, then you can type in corrections for the transaction.

- To review the next selected transaction, use **F02**.

**Note:** If other transaction types have been selected, those review displays will be shown. If no more transactions have been selected, go to display AMQ34J.

- To review the transactions you entered in the batch, use **F09**. Go to display AMQ34J.
- To return to the Enter Transactions (Select) display (AMQ34A), use **F19**.
- To delete an error transaction, use **F20**.

**Note:** If other transaction types have been selected, those review displays will be shown. If no more transactions have been selected, go to display AMQ34J.

## Function keys

F02 NEXT TRANSACTION presents the next transaction selected from the Enter Transactions, Review Summary display (AMQ34J) for review.

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another record.

F20 DELETE RECORD deletes the selected record from the batch after you select the function key twice.

## Fields

All fields on this display are optional if the **REV** field is E (Error). If not, they are for information only.

**REV (Reversal Code) (WREVCD).** Type in the reversal code for the transaction record:

**blank** Normal transaction. This code appears for valid transactions. Files were updated.

**E** Error. Transaction has failed an edit check. The files were not updated. An error transaction will become a normal transaction when corrected and posted.

**R** Reversed. If you type in R, the transaction is reversed and processed again. You cannot change a reversed transaction.

**Note:** If the corrected transaction is the only transaction in the batch, the next display shown is the Enter Transactions (Select) display (AMQ34A) with a message that no active or error records are in the batch. The message appears because a new record is being created and the old record has been deleted.

**OPER (Operation) (WOPSEQ).** The operation sequence number that identifies a reporting point where the transaction occurred.

**SCHEDULE (WSSCH).** The schedule number that you entered into the offline file.

**S-NUMBER (WSNMBR).** The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**WH (Warehouse) (WHOUSE).** The warehouse from which components are issued and the finished items are received.

**LINE (WPLINE).** The code of the production line where the schedule is produced.

**SCHED ITEM (WFITEM).** The scheduled item reported complete.

**REVISION (WREVSN).** This field appears only if EPDM is activated. The revision identifier associated with this item.

**SCHED DATE (WODUDT).** The date that the item's schedule is due to be completed.

**TRAN DATE (WTDATE).** The date that the transaction occurred.

**QUANTITY CNTRS (WCNQTY).** The number of full containers produced at the location.

**QUANTITY PIECES (WPCQTY).** The number of pieces in a partial container produced at the operation.

**REASON (WREASN).** A code that explains the reason for this transaction. This code is assigned by your company.

**REFERENCE (WREF).** The user-defined code used to provide additional information.

**SHIFT (WSHIFT).** A code (1, 2, or 3) for the production period established for labor and material reporting.

**CREW (WCREWN).** The user-defined code to identify the production crew.

## AMQ34F1—Enter Transactions, Operation Reporting (Select)

Use this display to select a schedule to report the quantity completed for an operation. Operations that match the selections you enter on this display are retrieved. You can select a specific schedule by entering the number in the **SCHED NUMBER** field.

This display appears after you select an OPERATION REPORTING (RO) transaction on display AMQ34A.

```
DATE **/**/
**          Enter Transactions          Select          AMQ34F1 **
              Operation Reporting

Select:
Warehouse . . . . . : aA3
Line . . . . . : aaaA5
Scheduled item . . . . . : aaaaaaaaaaaaA15
Revision . . . . . : aaaaA6
Operation . . . . . : aaA4
Schedule number . . . . . : SaaaaA6
S-number . . . . . : aaaaaaaaaaaaaaaaaA20
Transaction date . . . . . : nnnnnn

Defaults:
Shift . . . . . : N
Crew ID . . . . . : aA3
Operation tolerance . . . . . : nnn %

F09 Review All      F19 Return to Select
```

### What to do

- To enter a transaction, type in the schedule information you need and press **Enter**. If the system finds any schedules, go to display AMQ34F2.
- To review the transactions you entered in the batch, use **F09** and go to display AMQ34J.
- To return to the Enter Transactions (Select) display (AMQ34A), use **F19**.

### Function keys

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another record.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WAREHOUSE (WHSE1) [?]**. Required. Type the code of the warehouse from which components are to be issued and the finished items received. The original value is the default planning warehouse.

**LINE (PLINE1) [?]**. Type a production line to see a list of schedules released for that production line. If left blank, all production lines for the selected warehouse will be selected.

**SCHEDULED ITEM (FITEM1) [?]**. Type a scheduled item number to see a list of released schedules for that item. If left blank, all scheduled item numbers for the selected warehouse and line will be selected.

**REVISION (REVS1) [?]**. This field appears only if EPDM is activated. Accept the default of \*ALL to see all revisions. Type \*CUR to see the current revision based on the current system. Type a revision identifier instead of a schedule number to see a specific revision.

**OPERATION (Operation) (OPSEQ1) [?]**. Required. Type the sequence number of the operation you wish to report against. This operation sequence number must be a reporting point.

**SCHEDULE NUMBER (ORDNO1)**. Type a schedule number to see a specific released schedule. If left blank, all released schedules for the selected warehouse, line and scheduled item will be selected.

**S-NUMBER (SNM1) [?]**. Required if this item has features/options. Type the features and options code for the scheduled item entered in the scheduled item field. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**TRANSACTION DATE (TDATE1)**. Type the transaction date. This field initially shows the system date. If the system date, or the date you enter, is not in the CALNDR file, the previous CALNDR file date is used.

The following fields are default fields and will be applied to each transaction. They remain in effect until changed or the entry session is ended.

**SHIFT (SHIFT1)**. Type in 1, 2, or 3 for the production shift that reported the transaction. The default value is 1.

**CREW ID (CREW1)**. Type in the user-defined code to identify the production crew.

**OPERATION TOLERANCE (RCPT1)**. Type in the percentage by which the operation quantity for an item can exceed the open schedule quantities for the item. The default value is defined in the REPCFILE file. You can change it for this session. A blank value indicates no error checking is to be performed.

## AMQ34F2—Enter Transactions, Operation Reporting (Entry)

Use this display to enter the number of partially completed items that were reported at an operation reporting point. You begin the backflushing operation from this display.

This display appears after you enter and edit data on display AMQ34F1.

The cursor is positioned to enter a container quantity. If only pieces can be entered, the cursor is positioned at the pieces field. The display has two views. The information on each view is layered, with View 1 allowing you to key the most commonly entered information on one line. Less commonly used information is entered through View 2.

```

Date **/**/
**          Enter Transactions      Entry      AMQ34F2  **
              Operation Reporting

Warehouse *** Transaction date **/**/
** Operation **** View 1 of 2

Line  Scheduled      Rev      Schedule  ----- Quantity -----
      item           date      date      Remaining  Cntr      Pieces

*****
S***** S-Nbr ***** **/**/** * ,***,***.*** nnn nnnnn.nnn
***** **/**/** * ,***,***.*** nnn nnnnn.nnn
S***** S-Nbr ***** **/**/** * ,***,***.*** nnn nnnnn.nnn
***** S-Nbr ***** **/**/** * ,***,***.*** nnn nnnnn.nnn

Use Roll up/down      F03 View 2      F09 Review all  F11 Position to
F12 Additional fields  F18 Refresh display  F19 Return to Select

```

### What to do

- To update the transaction file, press **Enter**. Transactions are edited and processed. If no errors are detected, or after the errors are corrected, display AMQ34F1 appears.
- To review all the transactions you entered in the batch, use **F09**. Go to display AMQ34J.

### Function keys

F03 VIEW 1/ VIEW 2 allows you to toggle between the two views so you can review or enter reason and reference information.

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F11 POSITION TO shows you the Position to window so you can enter the specific line, item, or S-number for the transaction you want to see.

F12 ADDITIONAL FIELDS allows you to toggle between single and multiple lines per transaction.

F18 REFRESH DISPLAY shows the display again, without any changes made.

F19 RETURN TO SELECT returns to the Select display (AMQ34E1) so you can select another record.

## Fields

**Warehouse (WHOUSE).** The warehouse code from the previous display.

**TRANSACTION DATE (WTDATE).** The transaction date from the previous display.

**OPERATION (WOPSEQ).** The operation sequence number from the previous display.

**LINE (WPLINE).** The production line where the scheduled receipt is produced.

**SCHEDULED ITEM (WFITEM).** The item number being produced.

**REV (WREVSN).** This field appears only if EPDM is activated. The revision identifier associated with this item.

**SCHEDULE DATE (WODUDT).** The date the schedule is due.

**QUANTITY REMAINING (@OPEN) .** The open quantity at the reporting point for this schedule. If the 'post to oldest' function is active, this will be the total of the open quantities at this reporting point of all the schedules grouped into the transaction.

**QUANTITY CNTR (WCNQTY).** Required. Type in the number of full containers completed. If this item is reported only in pieces, this field is not input capable.

**QUANTITY PIECES (WPCQTY).** Required. Type in the number of pieces in a partial container completed.

**SCHEDULE NUMBER (WSSCH).** The schedule number is displayed if this is a single schedule. If the 'post to oldest' function is active and the transaction is for a group of schedules, this will be blank.

**S-NUMBER (WSNMBR).** The S-number selected on the previous display.

The following fields appear only on View 2:

**REASON (WREASN).** Type in a code that explains the reason for this transaction. This code is assigned by your company.

**REFERENCE (WREF).** Type in the user-defined code used to provide additional information.

**SHIFT (WSHIFT).** Type in **1, 2,** or **3** that indicates which production shift reported the transaction. The original value is from the previous display.

**CREW (WCREWN).** Type in the user-defined code to identify the production crew. The original value is from the previous display.

## AMQ34GR—Enter Transactions, Schedule Scrap (Review)

Use this display to reverse transactions in the batch, review previously reversed transactions, or correct error transactions from offline entry.

This display appears after you select a SCHEDULE SCRAP (SM) transaction on display AMQ34J.

```

DATE **/**/**          ENTER TRANSACTIONS          REVIEW          AMQ34GR **
                        SCHEDULE SCRAP

REV  OPER              SCHEDULE              S-NUMBER
A    ****              *****              *****

WH   LINE  SCHED ITEM          REVISION
***  *****  *****

                                SCHED DATE  TRAN DATE
                                **/**/**   **/**/**

                                --- QUANTITY ---
                                CNTRS    PIECES
                                ***  *****.*

REASON  REFERENCE  SHIFT  CREW          F02 NEXT TRANSACTION
*****  *****  *    ***          F09 REVIEW ALL
                                F19 RETURN TO SELECT
                                F20 DELETE RECORD
                                +
    
```

### What to do

If the **REV** field is blank, you can type in **R** to reverse the transaction. If the **REV** field already shows an **R**, then all other fields on the display are output only. If the **REV** field shows an **E**, then you can type in corrections for the transaction.

- To review the next selected transaction, use **F02**.

**Note:** If other transaction types have been selected, those review displays will be shown. If no more transactions have been selected, go to display AMQ34J.

- To review the transactions you entered in the batch, use **F09**. Go to display AMQ34J.
- To return to the Enter Transactions (Select) display (AMQ34A), use **F19**.
- To delete an error transaction, use **F20**.

**Note:** If other transaction types have been selected, those review displays will be shown. If no more transactions have been selected, go to display AMQ34J.

## Function keys

F02 NEXT TRANSACTION presents the next selected transaction for review.

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another record.

F20 DELETE RECORD deletes the selected record from the batch after you select the function key twice.

## Fields

All fields on this display are optional if the **REV** field is E (Error). If the **REV** field is not E, they are for information only.

**REV (Reversal Code) (WREVCD)**. Type in the reversal code for the transaction record:

**blank** Normal transaction. This code appears for valid transactions. Files were updated.

**E** Error. Transaction has failed an edit check. The files were not updated. An error transaction will become a normal transaction when corrected and posted.

**R** Reversed. If you type in **R**, the transaction is reversed and processed again. You cannot change a reversed transaction.

**Note:** If the corrected transaction is the only transaction in the batch, the next display shown is the Enter Transactions (Select) display (AMQ34A) with a message that no active or error records are in the batch. The message appears because a new record is being created and the old record has been deleted.

**OPER (Operation) (WOPSEQ)**. The operation sequence number that identifies a reporting point where the transaction occurred.

**SCHEDULE (WSSCH)**. The schedule number assigned to each schedule item.

**S-NUMBER (WSNMBR)**. The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**WH (Warehouse) (WHOUSE)**. The warehouse from which components are issued and the finished items are received.

**LINE (WLINE)**. The code of the production line you want to review.

**SCHED ITEM (WFITEM)**. The item to review.

**REVISION (WREVSN)**. This field appears only if EPDM is activated. The revision identifier associated with this item.

**SCHED DATE (WODUDT)**. The date that the item's schedule is due to be completed.



**TRAN DATE (WTDATE).** The date that the transaction occurred.

**QUANTITY CNTRS (WCNQTY).** The number of full containers scrapped at the operation.

**QUANTITY PIECES (WPCQTY).** The number of pieces in a partial container scrapped at the operation.

**REASON (WREASN).** A code that explains the reason for this transaction. This code is assigned by your company.

**REFERENCE (WREF).** The user-defined code used to provide additional information.

**SHIFT (WSHIFT).** A code (1, 2, or 3) that indicates which production shift reported the transaction. The original value is from the previous display.

**CREW (WCREWN).** The user-defined code that identifies the production crew. The original value is from the previous display.

## AMQ34G1—Enter Transactions, Schedule Scrap (Select)

Use this display to select items to enter as being scrapped. Schedules that match the selections you enter are retrieved. You can select a specific schedule by entering the number in the **SCHED NUMBER** field.

This display appears when you select SCHEDULE SCRAP (SM) on display AMQ34A.

```

DATE **/**/
**                Enter Transactions          Select      AMQ34G1 **
                   Schedule Scrap

Select:
Warehouse . . . . . : aA3
Line . . . . . : aaaA5
Scheduled item . . . : aaaaaaaaaaaaA15
Revision . . . . . : aaaaA6
Operation . . . . . : aaA4
Schedule number . . . : SaaaaA6
S-number . . . . . : aaaaaaaaaaaaaaaaaA20
Transaction date . . . : nnnnnn

Defaults:
Shift . . . . . : N
Crew ID . . . . . : aA3
Scrap tolerance . . . : nnn %

F09 Review All      F19 Return to Select
    
```

### What to do

- To enter a transaction, type in the schedule information you need and press **Enter**.
- To review the transactions you entered in the batch, use **F09**. Go to display AMQ34J.

- To return to the Enter Transactions (Select) display (AMQ34A), use **F19**.

## Function keys

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another record.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WAREHOUSE (WHSE1) [?]**. Required. Type the code of the warehouse from which components are to be issued and the finished items received. The original value is the default planning warehouse.

**LINE (PLINE1) [?]**. Type a production line to see a list of schedules released for that production line. If left blank, all production lines for the selected warehouse will be selected.

**SCHEDULED ITEM (FITEM1) [?]**. Type a scheduled item number to see a list of released schedules for that item. If left blank, all scheduled item numbers for the selected warehouse and line will be selected.

**REVISION (REVS1) [?]**. This field appears only if EPDM is activated. Accept the default of \*ALL to see all revisions. Type \*CUR to see the current revision based on the current system. Type a revision identifier instead of a schedule number to see a specific revision.

**OPERATION (Operation) (OPSEQ1) [?]**. Required. Type the sequence number of the operation you wish to report against.

**SCHEDULE NUMBER (ORDNO1)**. Type a schedule number to see a specific released schedule. If left blank, all released schedules for the selected warehouse, line and scheduled item will be selected.

**S-NUMBER (SNM1) [?]**. Required if this item has features/options. Type the features and options code for the scheduled item entered in the scheduled item field. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**TRANSACTION DATE (TDATE1)**. Type the transaction date. This field initially shows the system date. If the system date, or the date you enter, is not in the CALNDR file, the previous CALNDR file date is used.

The following fields are default fields and will be applied to each transaction. They remain in effect until changed or the entry session is ended.

**SHIFT (SHIFT1)**. Type in **1**, **2**, or **3** for the production shift that reported the transaction. The default value is 1.

**CREW ID (CREW1)**. Type in the user-defined code to identify the production crew.

**SCRAP TOLERANCE (SCPT1).** Type in the percentage by which the scrap quantity for an item can exceed the expected scrap quantity for the item. The default value is defined in the REPCCTL file. A blank value indicates no error checking is to be performed.

## AMQ34G2—Enter Transactions, Schedule Scrap (Entry)

Use this display to enter the number of items scrapped in the process of building this item at the operation specified. Components assigned to this item are backflushed through each operation to the previous reporting point. The information you can enter in the body of the display includes operation, quantity, and transaction date. Standard labor and materials from this and all preceding operations will be charged to scrap.

This display appears after you enter valid data on display AMQ34G1. The cursor is positioned to enter a container quantity. If only pieces can be entered, the cursor is positioned at the pieces field. The display has two views. The information on each view is layered, with View 1 allowing you to key the most commonly entered information on one line. Less commonly used information is entered through View 2.

```

Date **/**/
**
Enter Transactions      Entry      AMQ34G2  **
Schedule Scrap

Warehouse *** Transaction date **/**/
** Operation ****      View 1 of 2

Line   Scheduled      Rev   Schedule  ----- Quantity -----
       item           Rev   date      Remaining  Cntr      Pieces

***** ***** **/**/** * , ** , ** . ** nnn nnnnn.nnn
S***** S-Nbr *****
***** ***** **/**/** * , ** , ** . ** nnn nnnnn.nnn
S***** S-Nbr *****
***** ***** **/**/** * , ** , ** . ** nnn nnnnn.nnn
S***** S-Nbr *****

Use Roll up/down      F03 View 2      F09 Review all  F11 Position to
F12 Additional fields  F18 Refresh display  F19 Return to Select
    
```

### What to do

- To update the transaction file, press **Enter**. Transactions are edited and processed. If no errors are detected, or after the errors are corrected, display AMQ34F1 appears.
- To review all the transactions you entered in the batch, use **F09**. Go to display AMQ34J.

### Function keys

F03 VIEW 1/ VIEW 2 allows you to toggle between the two views so you can review or enter reason and reference information.

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F11 POSITION TO shows you the Position to window so you can enter the specific line, item, or S-number for the transaction you want to see.

F12 ADDITIONAL FIELDS allows you to toggle between single and multiple lines per transaction.

F18 REFRESH DISPLAY shows the display again, without any changes made.

F19 RETURN TO SELECT returns to the Select display (AMQ34G1) so you can select another record.

## Fields

**Warehouse (WHOUSE).** The warehouse code from the previous display.

**TRANSACTION DATE (WTDATE).** The transaction date from the previous display.

**OPERATION (WOPSEQ).** The operation sequence number from the previous display.

**LINE (WPLINE).** The production line where the scheduled receipt is produced.

**SCHEDULED ITEM (WFITEM).** The item number being produced.

**REV (WREVSN).** This field appears only if EPDM is activated. The revision identifier associated with this item.

**SCHEDULE DATE (WODUDT).** The date the schedule is due. If the 'post to oldest' function is active, the date displayed is the latest due date of the schedules grouped into the transaction.

**QUANTITY REMAINING (@OPEN) .** The open scrap quantity for this schedule. If the 'post to oldest' function is active, this will be the total of the open scrap quantities of all the schedules grouped into the transaction.

**QUANTITY CNTR (WCNQTY).** Required. Type in the number of full containers scrapped. If this item is reported only in pieces, this field is not input capable.

**QUANTITY PIECES (WPCQTY).** Required. Type in the number of pieces in a partial container scrapped.

**SCHEDULE NUMBER (WSSCH).** The schedule number is displayed if this is a single schedule. If the 'post to oldest' function is active and the transaction is for a group of schedules, this will be blank.

**S-NUMBER (WSNMBR).** The S-number selected on the previous display.

The following fields appear only on View 2:

**REASON (WREASN).** Type in a code that explains the reason for this transaction. This code is assigned by your company.

**REFERENCE (WREF).** Type in the user-defined code used to provide additional information.

**SHIFT (WSHIFT).** Type in **1, 2,** or **3** to indicate which production shift reported the transaction. The original value is from the previous display.

**CREW (WCREWN).** Type in the user-defined code to identify the production crew. The original value is from the previous display.

## AMQ34HR—Enter Transactions, Component Scrap (Review)

Use this display to reverse transactions, review previously reversed transactions, or correct error transactions from offline entry.

This display appears after you select a COMPONENT SCRAP (SC) transaction from display AMQ34J and transactions already processed exist in the batch.

DATE **/**/**	ENTER TRANSACTIONS COMPONENT SCRAP	REVIEW	AMQ34HR **
REV A	SCHEDULE *****	S-NUMBER *****	
WH    LINE	SCHED ITEM		SCHED DATE
***    *****	*****		**/**/**
	SEQ    COMPONENT		TRAN DATE
	***    *****		**/**/**
	--- QUANTITY ---		
LINE LOC	CNTRS    PIECES	BATCH/LOT	FIFO
*****	***    ***** . ***	*****	**/**/**
REASON	REFERENCE	SHIFT	CREW
*****	*****	*	***
			F02 NEXT TRANSACTION
			F09 REVIEW ALL
			F19 RETURN TO SELECT
			F20 DELETE RECORD
			+

### What to do

If the **REV** field is blank, you can type in **R** to reverse the transaction. If the **REV** field already shows an R, then all other fields on the display are output only. If the **REV** field shows an E, then you can type in corrections for the transaction.

- To review the next selected transaction, use **F02**.

**Note:** If other transaction types have been selected, those review displays will be shown. If no more transactions have been selected, go to display AMQ34J.

- To review the transactions you entered in the batch, use **F09**. Go to display AMQ34J.
- To return to the Enter Transactions (Select) display (AMQ34A), use **F19**.
- To delete an error transaction, use **F20**.

**Note:** If other transaction types have been selected, those review displays will be shown. If no more transactions have been selected, go to display AMQ34J.

## Function keys

F02 NEXT TRANSACTION presents the next selected transaction for review.

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another record.

F20 DELETE RECORD deletes the selected record from the batch after you select the function key twice.

## Fields

All fields on this display are optional if the **REV** field is E (Error). If the **REV** field is not E, they are for information only.

**REV (Reversal Code) (REVCD)**. Type in the reversal code for the transaction record:

**blank** Normal transaction. This code appears for valid transactions. Files were updated.

**E** Error. Transaction has failed an edit check. The files were not updated. An error transaction will become a normal transaction when corrected and posted.

**R** Reversed. If you type in R, the transaction is reversed and processed again. You cannot change a reversed transaction.

**SCHEDULE**. The schedule number that you entered into the offline file.

**S-NUMBER (SNMNR)**. The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**WH (Warehouse) (HOUSE)**. The warehouse from which components are issued and the finished items are received.

**LINE (PLINE)**. The code of the production line you want to review.

**SCHED ITEM (FITEM)**. The item to review for scrapped components.

**SCHED DATE (ODUDT)**. The date that the item's schedule is due to be completed.

**SEQ**. The user-defined sequence number used to uniquely identify the component.

**COMPONENT (CITEM)**. The material used in the production of the scheduled item.

**TRAN DATE (TDATE)**. The date that the transaction occurred.

**LINE LOC (DLOCN)**. The location on the production line where the component is normally delivered.

**QUANTITY CNTRS (CNQTY)**. The number of full containers scrapped at a location.

**QUANTITY PIECES (PCQTY).** The number of pieces in a partial container scrapped at a location.

**BATCH/LOT (LBHNO).** The batch/lot number assigned to an item lot. You can only edit batch/lot numbers if you selected batch/lot support during application tailoring.

**FIFO (First In First Out) (FDATE).** The date the item lot was originally received into inventory. FIFO dates appear if you select FIFO support during application tailoring.

**REASON (REASN).** A code that explains the reason for this transaction. This code is assigned by your company.

**REFERENCE (REFNO).** The user-defined code used to provide additional information.

**SHIFT (SHFTC).** A code (1, 2, or 3) for the production period established for labor and material reporting.

**CREW (CREWN).** The user-defined code to identify the production crew.

## AMQ34H1—Enter Transactions, Component Scrap (Select)

Use this display to select components to be scrapped.

This display appears after you select COMPONENT SCRAP (SC) on display AMQ34A.

```
DATE **/**/**          ENTER TRANSACTIONS          SELECT    AMQ34H1 **
                        COMPONENT SCRAP

WH aA3 LINE aaaA5 LINE LOC aaaaaA7 COMPONENT aaaaaaaaaaaaaA15 SHIFT n CREW nnn
SCHED NBR aaaaaA7 DATE nn/nn/nn ITEM aaaaaaaaaaaaaA15 S-NBR aaaaaaaaaaaaaA20

F09 REVIEW ALL
F19 RETURN TO SELECT
+
```

### What to do

- To enter a transaction, type in the information you need and press **Enter**. Go to display AMQ34H2.
- To review the transactions you entered in the batch, use **F09**. Go to display AMQ34J.

- To return to the Enter Transactions (Select) display (AMQ34A), use **F19**.

## Function keys

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another record.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WH (Warehouse) (HOUSE) [?]**. This field contains the value of the default planning warehouse. Type in the code of the warehouse from which components are issued and the finished items received.

**LINE (PLINE) [?]**. The code of the production line you want to review.

**LINE LOC (DLOCN)**. Type in the location on the production line where the component was scrapped.

**COMPONENT (CITEM) [?]**. Type in the component to be scrapped.

**SHIFT (SHFTC)**. Type in the shift during which the scrap was reported.

**CREW (CREWN)**. Type in the user-defined code to identify the production crew.

**SCHED NBR (ORDNO)**. Type in the schedule number for the specific schedule you want to see.

**DATE (ODUDT)**. The date that the item's schedule is due to be completed.

**ITEM (FITEM) [?]**. Type in a scheduled item to see a list of schedules released for this item.

**S-NUMBER (SNMBR) [?]**. Required if this item has features/options. Type in the features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.



## AMQ34H2—Enter Transactions, Component Scrap (Entry)

Use this display to report the scrapping of components from line locations. **F11 POSITION TO** shows you a window that allows you to choose a specific record.

This display appears after you enter valid data on the Select display (AMQ34H1).

```

DATE **/**/**                ENTER TRANSACTIONS          ENTRY      AMQ34H2 **
                             COMPONENT SCRAP

WH *** LINE ***** LINE LOC ***** COMPONENT ***** SHIFT * CREW ***

SCHED NBR ***** DATE **/**/** ITEM ***** S-
NBR *****
NUMBER OF RECORDS TO ROLL nnnn

LINE      USER --- QUANTITY ---   TRAN      FIFO
LOC      COMPONENT      SEQ CNTRS   PIECES     DATE      DATE
                             OPER  REASON  REFERENCE

***** ***** ***** nnn- nnnnnnn.nnn-   nn/nn/nn
***** ***** *****          ****  aaaaA6  aaaaaaaA10
***** ***** ***** nnn- nnnnnnn.nnn-   nn/nn/nn
***** ***** *****          ****  aaaaA6  aaaaaaaA10
***** ***** ***** nnn- nnnnnnn.nnn-   nn/nn/nn
***** ***** *****          ****  aaaaA6  aaaaaaaA10
***** ***** ***** nnn- nnnnnnn.nnn-   nn/nn/nn
***** ***** *****          ****  aaaaA6  aaaaaaaA10

                               F12 ADDITIONAL FIELDS
                               F18 REFRESH DISPLAY
                               F19 RETURN TO SELECT
USE ROLL UP/DOWN              F09 REVIEW ALL
F03 PREVIOUS DISPLAY          F11 POSITION TO

```

```

DATE **/**/**                ENTER TRANSACTIONS          ENTRY      AMQ34H2 **
                             COMPONENT SCRAP
                             =====
                             POSITION TO
WH *** LINE LOC ***** COMPONENT ***** WH aA3 LINE LOC aaaaaA7
                             COMPONENT aaaaaaaaaaaaA15
NUMBER OF RECORDS TO ROLL *****

```

### What to do

- To update the transaction file, press **Enter**. Go to display AMQ34H1.
- To review all the transactions you entered in the batch, use **F09**. Go to display AMQ34J.
- To view a specific transaction, use **F11** and type the required information in the **POSITION TO** window. Press **Enter** to skip to the specific record. The window disappears when you press **Enter** a second time.
- To see additional fields, use **F12**. To return to the original display format, use **F12** again.
- To cancel what you typed in on this display, use **F18**.
- To go to the Enter Transactions (Select) display (AMQ34A), use **F19**.

### Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of components.

F03 PREVIOUS DISPLAY shows you the previous display (AMQ34H1).

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F11 POSITION TO shows you a window that allows you to choose a specific record to review.

F12 ADDITIONAL FIELDS allows you to review the second line of fields on the display. Using F12 a second time returns you to the original format of one line of fields.

F18 REFRESH DISPLAY shows the display again without any changes made.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another record.

## Fields

**WH (Warehouse) (HOUSE).** The warehouse from which components are issued and the finished items are received.

**LINE (PLINE).** The code of the production line you want to review for components to scrap.

**LINE LOC (DLOCN).** The location on the production line where the component is normally delivered.

**COMPONENT (CITEM).** The material used in the production of the scheduled item.

**SHIFT (SHFTC).** Type in **1**, **2**, or **3** for the production period established for labor and material reporting.

**CREW (CREWN).** Type in the user-defined code to identify the production crew.

**SCHED NUMBER (ORDNO).** The schedule number associated with this item.

**SCHED DATE (ODUDT).** The date that the item's schedule is due to be completed.

**SCHED ITEM (FITEM).** The item that you want to review for components to scrap.

**S-NUMBER (SNMBR).** The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**NUMBER OF RECORDS TO ROLL (ROLFC).** Type in the number of records to be skipped as you page through the records.

**LINE LOC (DLOCN).** The location on the production line where the component is normally delivered.

**COMPONENT (CITEM).** The material used in the production of the scheduled item.

**SEQ.** The user-defined sequence number used to uniquely identify the component.

**QUANTITY CNTRS (CNQTY).** Required. Type in the number of full containers scrapped at a location.

**QUANTITY PIECES (PCQTY).** Required. Type in the number of pieces in a partial container scrapped at a location.

**TRAN DATE (TDATE).** Type in the date that the transaction occurred.

**FIFO (First In First Out) (FDATE).** The date the item lot was originally received into inventory. FIFO dates appear if you select FIFO support during application tailoring.

**BATCH/LOT (LBHNO).** The batch/lot number assigned to an item lot. You may only edit batch/lot numbers if you selected batch/lot support during application tailoring.

**OPER (Operation) (OPSEQ).** The operation sequence number that identifies the operation where the scrap occurred.

**REASON (REASN).** Type in a code that explains the reason for this transaction. This code is assigned by your company.

**REFERENCE (REFNO).** Type in the user-defined code used to provide additional information.

## AMQ34IR—Enter Transactions, Production Status (Review)

Use this display to reverse transactions and review previously reversed transactions.

This display appears after you select a PRODUCTION STATUS (PS) transaction on display AMQ34J.

DATE **/**/**	ENTER TRANSACTIONS PRODUCTION STATUS	REVIEW	AMQ34IR **
REV A	SCHEDULE *****		
WH    LINE	QUANTITY    LINE STATUS    TIME		
***    *****	*, ***, ****, *****		
			TRAN DATE **/**/**
REASON    REFERENCE    SHIFT    CREW		F02 NEXT TRANSACTION	
*****    *****    *    ***		F09 REVIEW ALL	
		F19 RETURN TO SELECT	
		F20 DELETE RECORD	+

### What to do

If the **REV** field is blank, you can type in **R** to reverse the transaction. If the **REV** field already shows an R, then all other fields on the display are output only. If the **REV** field shows an E, then you can type in corrections for the transaction.

- To review the next selected transaction, use **F02**.

**Note:** If other transaction types have been selected, those review displays will be shown. If no more transactions have been selected, go to display AMQ34J.

- To review the transactions you entered in the batch, use **F09**. Go to display AMQ34J.
- To return to the Enter Transactions (Select) display (AMQ34A), use **F19**.
- To delete an error transaction, use **F20**.

**Note:** If other transaction types have been selected, those review displays will be shown. If no more transactions have been selected, go to display AMQ34J.

## Function keys

F02 NEXT TRANSACTION presents the next selected transaction for review.

F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another record.

F20 DELETE RECORD deletes the selected transaction after you select the function key twice.

## Fields

All fields on this display are optional if the **REV** field is E (Error). If the **REV** field is not E, they are for information only.

**REV (Reversal Code) (REVCD).** Type in the reversal code for the transaction record:

**blank** Normal transaction. This code appears for valid transactions. Files were updated.

**E** Error. Transaction has failed an edit check. The files were not updated. An error transaction will become a normal transaction when corrected and posted.

**R** Reversed. If you type in R, the transaction is reversed and processed again. You cannot change a reversed transaction.

**SCHEDULE.** The schedule number that you entered into the offline file.

**WH (Warehouse) (HOUSE).** The warehouse from which components are issued and the finished items are received.

**LINE (PLINE).** The code of the production line you want to review.

**QUANTITY (TRQTY).** The quantity for this transaction.

**LINE STATUS (LINCD).** The status of the production line.

- 1** The line is started.
- 2** The line is stopped.

**TIME (TIMECD).** The time when the transaction occurred.



F09 REVIEW ALL causes the Enter Transactions, Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F18 REFRESH DISPLAY shows the display again without any changes made.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another record.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WH (Warehouse) (HOUSE) [?]**. This field contains the value of the default planning warehouse. Type in the code of the warehouse from which components are issued and the finished items received.

**LINE (PLINE) [?]**. Type in the production line you want to use for the starting or ending transaction.

**LINE STATUS (LINCD)**. Type in the status of the production line:

- 1 The line is started.
- 2 The line is stopped.

**REASON (REASN)**. Type in a code that explains the reason for this transaction. This code is assigned by your company.

**REFERENCE (REFNO)**. Type in the user-defined code used to provide additional information.

**SHIFT (SHFTC)**. Type in **1**, **2**, or **3** for the production period established for labor and material reporting.

**CREW (CREWN)**. Type in the user-defined code to identify the production crew.

**TRAN TIME (TIMCD)**. Type in the time that the transaction occurred.

**TRAN DATE (TDATE)**. Type in the date that the transaction occurred.

**QUANTITY (TRQTY)**. Type in the transaction quantity.

## AMQ34J—Enter Transactions, Review Summary (Review)

Use this display to review groups of previously processed transactions. From this display you can select a record to be updated. Use **F11 POSITION TO** to position the cursor at a specific record.

This display appears when you use **F09 REVIEW ALL** on display AMQ34A or any of the Transaction Entry or Review displays. This display also appears when you select an existing batch on display AMQ3ZA.

When the warehouse is selected for Location based replenishment, the *Line*, *Sched Item*, and *Seq* fields are blank.

```

DATE **/**/**                ENTER TRANSACTIONS          REVIEW    AMQ34J  **
                             REVIEW SUMMARY

NUMBER OF RECORDS TO ROLL nnnn

SEL REV  TR              LINE SCHED ITEM          COMPONENT          SEQ    DATE     TIME
A   *   **   ***    ***** *****          *****          ***** **/**/** **:**:**
A   *   **   ***    ***** *****          *****          ***** **/**/** **:**:**
A   *   **   ***    ***** *****          *****          ***** **/**/** **:**:**
A   *   **   ***    ***** *****          *****          ***** **/**/** **:**:**
A   *   **   ***    ***** *****          *****          ***** **/**/** **:**:**
A   *   **   ***    ***** *****          *****          ***** **/**/** **:**:**
A   *   **   ***    ***** *****          *****          ***** **/**/** **:**:**
A   *   **   ***    ***** *****          *****          ***** **/**/** **:**:**
A   *   **   ***    ***** *****          *****          ***** **/**/** **:**:**
A   *   **   ***    ***** *****          *****          ***** **/**/** **:**:**
A   *   **   ***    ***** *****          *****          ***** **/**/** **:**:**
A   *   **   ***    ***** *****          *****          ***** **/**/** **:**:**
A   *   **   ***    ***** *****          *****          ***** **/**/** **:**:**
A   *   **   ***    ***** *****          *****          ***** **/**/** **:**:**
A   *   **   ***    ***** *****          *****          ***** **/**/** **:**:**
A   *   **   ***    ***** *****          *****          ***** **/**/** **:**:**

USE ROLL UP/DOWN          F11 POSITION TO          F18 REFRESH DISPLAY
F08 SHOW EXCEPTIONS      F12 ALTERNATE VIEW      F19 RETURN TO SELECT

```

### What to do

- To select specific transactions, type **1** in the **SEL** field and press **Enter**.
- To review error transactions (type=E), use **F08**. To return to the original display format, use **F08** again.
- To view a specific transaction, use **F11** and type the required information in the **POSITION TO** window. Press **Enter** to skip to the specific record. The window disappears when you press **Enter** a second time.
- To view alternate information for these transactions, use **F12**. The display shows you schedule number, and container and pieces quantities. Use **F12** again to return to the original view.
- To cancel what you typed in on this display, use **F18**.
- To go to the Enter Transactions (Select) display (AMQ34A), use **F19**.

## Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of transactions.

F08 SHOW ALL/EXCEPTIONS shows only error and unapplied record types. Using **F08** a second time will return you to the information initially shown.

F11 POSITION TO shows you a window that allows you to choose a specific record to review.

F12 ALTERNATE VIEW shows you alternate information to help you identify the specific transaction you want to process.

F18 REFRESH DISPLAY shows the display again without any changes made.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another record.

## Fields

**NUMBER OF RECORDS TO ROLL (ROLFC)**. Type in the number of records to be skipped.

**SEL (Select) (SELEC)**. Required. Type in **1** next to each transaction you want to select for review.

**REV (Reversal Code) (REVCD)**. The reversal code for the transaction record:

**blank** Normal transaction. This code appears for valid transactions. Files were updated.

**E** Error. Transaction has failed an edit check. The files were not updated. An error transaction will become a normal transaction when corrected and posted.

**R** Reversed. If you type in **R**, the transaction is reversed and processed again. You cannot change a reversed transaction.

**U** Unapplied. Transaction failed because not enough stock was available at the line. The files were not updated. An unapplied transaction will become a normal transaction when corrected and posted.

**TR CD (Transaction Code) (TCODE)**. This field contains one of the following transaction codes:

- 1** (RLS) Replenishment by schedule
- 2** (RLL) Replenishment by location
- 3** (CL) Component transfer to line
- 4** (CN) Component return to stores
- 5** (RM) Schedule receipts
- 6** (RO) Operation reporting
- 7** (SM) Schedule scrap
- 8** (SC) Component scrap
- 9** (PS) Production status

**WH (Warehouse) (HOUSE)**. The warehouse from which components are issued and the finished items are received.



**LINE (PLINE).** The production line you selected on the previous display. This field is blank if the associated warehouse is selected for location based replenishment.

**SCHED ITEM (FITEM).** The item for which you want to review transactions. This field is blank if the associated warehouse is selected for location based replenishment.

**COMPONENT (CITEM).** The material used in the production of the scheduled item.

**SEQ (USRSQ).** The user-defined sequence number used to uniquely identify the component. This field is blank if the associated warehouse is selected for location based replenishment.

**POSTING DATE (UPDDT).** The date that the transaction was posted.

**POSTING TIME (UPDTM).** The time that the transaction was posted

The following fields appear when you use **F12** to get an alternate view. The fields help you further identify the specific transaction you want to process.

**SCHED NBR (ORDNO).** The schedule number associated with this transaction.

**QUANTITY CNTRS (CNQTY).** The number of full containers reported completed in this transaction.

**QUANTITY PIECES (PCQTY).** The number of pieces in a partial container reported completed in this transaction.

## AMQ34K—Enter Transactions, Batch Status

Use this display to review the status of the batch, and to suspend or close the batch.

This display appears when you use **F24 DISPLAY STATUS** on display AMQ34A.

DATE **/**/**	ENTER TRANSACTIONS BATCH STATUS	AMQ34K **												
BATCH NUMBER ***														
BATCH TOTALS	<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%;"></td> <td style="width: 33%; text-align: center;">----- QUANTITY -----</td> <td style="width: 33%;"></td> </tr> <tr> <td></td> <td style="text-align: center;">CNTRS                      PIECES</td> <td style="text-align: center;">TRANSACTIONS</td> </tr> <tr> <td></td> <td style="text-align: center;">*****                      ,***</td> <td style="text-align: center;">*****</td> </tr> <tr> <td></td> <td></td> <td style="text-align: center;">*****</td> </tr> </table>		----- QUANTITY -----			CNTRS                      PIECES	TRANSACTIONS		*****                      ,***	*****			*****	ERRORS
	----- QUANTITY -----													
	CNTRS                      PIECES	TRANSACTIONS												
	*****                      ,***	*****												
		*****												
			*****											
			+											
			F09 DATA QUEUE STATUS F23 SUSPEND BATCH F24 CLOSE BATCH											

## What to do

- To check the data queue status, use **F09**. Go to display AMQX31.
- To suspend a batch, use **F23**.
- To close a batch, use **F24**.

## Function keys

F09 DATA QUEUE shows display AMQX31 which allows you to check the status of the data queue.

F23 SUSPEND BATCH flags the current batch as being suspended. The Material Management menu (AMQM30) appears again.

F24 CLOSE BATCH flags the current batch as being closed. The Material Management menu (AMQM30) appears again so you can choose another option or end this activity.

## Fields

**BATCH NUMBER (BATCH)**. The sequential number assigned to the batch by the system.

**BATCH TOTALS**. The summary information for the batch being maintained.

**QUANTITY CNTRS (CNTRS)**. The total number of full containers entered in the batch.

**QUANTITY PIECES (TOPCS)**. The total number of pieces in a partial container entered in the batch.

**TRANSACTIONS (TOTRN)**. The total number of transactions entered into the batch.

**ERRORS (BERRS)**. The total number of error transactions in the batch.

## AMQ34LR—Enter Transactions, Planned Issue (Review)

Use this display to apply issues previously rejected by other transactions.

This display appears after you select a PLANNED ISSUE (IP) transaction on display AMQ34J.

DATE **/**/**	ENTER TRANSACTIONS PLANNED ISSUE	REVIEW	AMQ34LR **
REV A	SCHEDULE *****	S-NUMBER *****	
WH    LINE	SCHED ITEM		SCHED DATE
***    *****	*****		**/**/**
	SEQ    COMPONENT		TRAN DATE
	****    *****		**/**/**
	--- QUANTITY ---		
LINE LOC	CNTRS    PIECES	BATCH/LOT	FIFO
*****	**    ***** . **	*****	**/**/**
REASON	REFERENCE	F02 NEXT TRANSACTION	
*****	*****	F09 REVIEW ALL	
		F19 RETURN TO SELECT	
		F20 DELETE RECORD	
			+

### Function keys

F02 NEXT TRANSACTION presents the next selected transaction for review.

F09 REVIEW ALL causes the Review Summary display (AMQ34J) to appear so you can review a summary of the transactions in the batch.

F19 RETURN TO SELECT returns to the Select display (AMQ34A) so you can select another record.

F20 DELETE RECORD deletes the selected transaction after you select the function key twice.

## Fields

All fields on this display are optional if the **REV** field is E (Error). If the **REV** field is not E, they are for information only.

**REV (Reversal Code) (WREVCD)**. Type in the reversal code for the transaction record:

- blank** Normal transaction. This code appears for valid transactions. Files were updated.
- R** Reversed. If you type in **R**, the transaction is reversed and processed again. You cannot change a reversed transaction.
- E** Error. Transaction has failed an edit check. The files were not updated. An error transaction will become a normal transaction when corrected and posted.
- U** Unapplied. Transaction failed because not enough stock was available at the line. The files were not updated. An unapplied transaction will become a normal transaction when corrected and posted.

**SCHEDULE (WSSCH)**. The schedule number assigned to each scheduled item.

**S-NUMBER (WSNMBR)**. The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**WH (Warehouse) (WHOUSE)**. The warehouse you selected on the previous display.

**LINE (WPLINE)**. The production line you selected on the previous display.

**SCHED ITEM (WFITEM)**. The item for which you want to review transactions.

**SCHED DATE (WODUDT)**. The date that the item's schedule is due to be completed.

**SEQ (WSQNO)**. The user-defined component sequence number for this transaction.

**COMPONENT (WCITEM)**. The raw material part or subassembly associated with this transaction.

**TRAN DATE (WTDATE)**. The date that the transaction occurred.

**LINE LOC (WDLOCN)**. The location to which the component is to be delivered.

**QUANTITY CNTRS (WCNQTY)**. The number of full containers used at a location.

**QUANTITY PIECES (WPCQTY)**. The number of pieces in a partial container used at a location.

**BATCH/LOT (WLBHNO)**. The batch/lot number assigned to an item lot received into inventory. Batch/lot numbers appear if you selected batch/lot support during application tailoring.

**FIFO (First In First Out) (WFIFO)**. The date an item lot was received into inventory. FIFO dates appear if you select FIFO support during application tailoring.

**REASON (WREASN).** The code that explains the reason for the transaction. This code is assigned by your company.

**REFERENCE (WREFNO).** The user-defined code used to provide additional information.

## AMQX31—Enter Transactions, Data Queue Transaction Status (Inquiry)

Use this display to review the status of the transaction data queue.

This display appears when you select **F09 DATA QUEUE STATUS** on display AMQ34K.

```

DATE **/**/**                *****                INQUIRY    AMQX31  **
                                DATA QUEUE TRANSACTION STATUS
DATA QUEUE *****                STATUS *****                JOB NAME *****
                                *****                JOB NUMBER *****

TRAN                               ITEM                               SCHED  SCHED
DATE    TIME  WS  USER ID    TR  WH  LINE  S-NUMBER          DATE    NBR
**/**/** **:**:** ** ***** ** **  ***** ***** **/**/** *****
*****
**/**/** **:**:** ** ***** ** **  ***** ***** **/**/** *****
*****
**/**/** **:**:** ** ***** ** **  ***** ***** **/**/** *****
*****
**/**/** **:**:** ** ***** ** **  ***** ***** **/**/** *****
*****
**/**/** **:**:** ** ***** ** **  ***** ***** **/**/** *****
*****
                                *****
                                USE ROLL UP/DOWN                F12 ADDITIONAL FIELDS
                                                                F18 REFRESH DISPLAY
                                                                ENTER TO RETURN
                                                                +
    
```

### What to do

- To see additional fields, use **F12**. To return to the original display format, use **F12** again.
- To cancel what you typed in on this display, use **F18**.
- To return to the previous display, press **Enter**.

### Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of locations.

F12 ADDITIONAL FIELDS allows you to review any associated S-numbers for items. Using **F12** a second time returns you to the original format. This function key appears if you chose features/options support during PDM/EPDM tailoring.

F18 REFRESH DISPLAY shows the display again with the current status of the transaction data queue.

## Fields

**DATA QUEUE (UJDQN/UJDSC).** The name and description of the data queue.

**STATUS (UJCST).** The current status (ACTIVE, HELD, JOBQ, ABENDR, ABENDN, or ENDED) of the unattached job.

**JOB NAME (UJPGM).** The name assigned to the job.

**JOB NUMBER (UJNBR).** The number assigned to the job.

**TRAN DATE (UPDDT).** The date that the transaction was submitted to the data queue.

**TIME (UPDTM).** The time that the transaction was submitted to the data queue.

**WS (WKSID).** The ID of the submitting work station.

**USER ID (USERN).** The code assigned to the person who entered the transaction.

**TR (TCODE).** The code of the transaction.

<b>RM</b>	Schedule receipts
<b>RO</b>	Operation reporting
<b>SM</b>	Schedule scrap
<b>01</b>	Recalculate Cumulative Yield/Dates
<b>02</b>	Recalculate Quantities

**WH (Warehouse) (HOUSE).** The warehouse from which components are issued and the finished items are received.

**LINE (PLINE).** The production line selected from the previous display.

**ITEM (FITEM).** The number and description of the item selected from the previous display.

**S-NUMBER (SNMBR).** The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**SCHED DATE (ODUDT).** The date that the item's schedule is due to be completed.

**SCHED NBR (ORDNO).** The control number assigned by the system to each schedule in the data base.

---

## Option 6. Enter Transactions from Offline Files (AMQM30)

Use this option to load offline records to the REP Transaction Entry batch. You must select an action code to determine how to run the job.

**Note:** After loading the offline records, be sure to correct any errors that appear on the edit list and to close the batch using option 5 (Enter Transactions) on the Material Management menu (AMQM30).

**What information you need:** The Offline Repetitive Transaction file containing the REP transactions that were entered offline.

**What reports are printed:**

- Enter Transactions from Offline Files Edit List (AMQ3M1)
- Enter Transactions from Offline Files Edit List Totals (AMQ3M2)
- Enter Transactions from Offline Files—Update and Error List (AMQ3N1)
- Enter Transactions from Offline Files—Update and Error List Totals (AMQ3N2). If you typed **Y** in ERRORS ONLY LISTING? on the Copy Offline File (Options) Display (AXVOL1), only error records are printed. If you typed in **N**, all transactions are printed.

**What forms you need:** None.

The basic steps to enter transactions from Offline Files follow display.

## AMQ371—Enter Transactions from Offline Files (Select)

Use this display to select batch or interactive mode for the entry of offline transactions.

This display appears when you select option 6 on menu AMQM30.

Make sure the system operator has the Offline Repetitive Transaction file containing the REP transactions that were entered offline.

The Enter Transactions from Offline Files display (AMQ371) appears if the last job run did not end abnormally. The Enter Transactions from Offline Files, Abnormal Termination Restart display (AMQ3L1) appears if the last job run did end abnormally.

```
DATE **/**/**      ENTER TRANSACTIONS FROM OFFLINE FILES      SELECT      AMQ371  **

                                ACTION  n
                                1  RUN JOB NOW
                                2  RUN FROM JOBQ

                                F24 CANCEL JOB
```

### What to do

Type in the method to run the job and press **Enter**. Go to display AXV0L1.

### Function keys

F24 CANCEL JOB returns to the Material Management menu (AMQM30).

### Fields

**ACTION (SELWK)**. Required. Type in a code to indicate whether the processing of the offline file is interactive or batch:

- 1 Interactive
- 2 Batch



## AMQ3L1—Enter Transactions from Offline Files, Abnormal Termination Restart (Select)

Use this display to enter the function request for a job that was abnormally terminated.

This display appears when you select option 6 on menu AMQM30, if the job ended abnormally the last time it was run.

Make sure the system operator has the Offline Repetitive Transaction file containing the REP transactions that were entered offline.

```

DATE **/**/**      ENTER TRANSACTIONS FROM OFFLINE FILES      SELECT      AMQ3L1  **
                    ABNORMAL TERMINATION RESTART

DATE **/**/**      TIME **:**:**      FILE *****      RECD NBR IN ERROR *****
WS ID *****      JOB NBR *****      BATCH NBR *****      TOTAL RECORDS *****
USER *****

                    ACTION  n
                    1  FINISH RUNNING INTERRUPTED JOB
                    2  RUN ANOTHER JOB
                    3  DELETE THIS JOB

                                F24 CANCEL JOB

```

### What to do

Pressing **Enter** produces one of the following results:

- If you select option 1, the work files are cleared and processing will continue at the point of the interruption.
- If you select option 2, the work files are cleared and the Copy Offline File display (AXVOL1) appears.
- If you select option 3, the work files will be cleared, the recovery file reset, and the Material Management menu (AMQM30) appears.

### Function keys

F24 CANCEL JOB returns to the Material Management menu (AMQM30).

## Fields

**DATE (TDATE).** The date of the abnormal termination.

**TIME (BTIME).** The time of the abnormal termination.

**FILE (RCNAM).** The name of the file being processed when the abnormal termination occurred.

**RECD NBR IN ERROR (RFAIL).** The record number being processed when the abnormal termination occurred.

**WS ID (WKSID).** ID of the work station that entered the abnormally-terminated job.

**JOB NBR (JOBNR).** The job number of the terminated job.

**BATCH NBR (BCHNB).** The batch number assigned to the transactions being processed when the abnormal termination occurred.

**TOTAL RECORDS (RTOTL).** The total number of records being processed when the abnormal termination occurred.

**USER (USERN).** The name of the work station user when the abnormal termination occurred.

**ACTION (SELECT).** Required. Type in a code to indicate the action you want the system to take:

- 1 Finish running interrupted job
- 2 Run another job
- 3 Delete this job

## AXVOL1—Copy Offline File (Options)

Use this display to select the options for copying a file of transactions created from a system outside of XA. This display appears after you make a selection on display AMQ371.

```

DATE *****          COPY OFFLINE FILE          OPTIONS  AXVOL1  **

OFFLINE FILE NAME          aaaaaaaaaA10
OFFLINE FILE LOCATION <1/2>      n
    1 - DISKETTE
    2 - DISK

DISKETTE DEVICE OR DISK LIBRARY NAME  aaaaaaaaaA10
IF DISK - DELETE OFFLINE FILE? <Y/N>  A

                                         F24 CANCEL THE JOB

```

### What to do

If you are loading files from diskette, pressing **Enter** causes the system to show you a series of displays that ask you to load the diskette in the device, then remove the diskette from the device. Follow the instructions on the displays. When the process has been completed, the Material Management menu (AMQM30) appears again.

If you are loading files from disk, when you press **Enter**, the system loads the file from the disk. When the process has been completed, the Material Management menu (AMQM30) appears again.

**Note:** If severe errors are detected, a message appears stating that severe errors were found. You must respond to the message with either a Y or N. A Y response will process only those records without errors. An N response processes no records.

### Function keys

F24 CANCEL THE JOB cancels the job and returns you to the Material Management Menu (AMQM30).

## Fields

**ERRORS ONLY LISTING? <Y/N>**. Type in **Y** (Yes) or **N** (No):

- Y** Prints a listing of only the errors
- N** Prints a listing of all the records in the file.

The default is N.

**OFFLINE FILE NAME**. Type in the name of the offline file to copy. The default is RPTRN2.

**OFFLINE FILE LOCATION <1/2>**. Type in one of the following:

- 1** Offline file is on diskette
- 2** Offline file is on the disk

**DISKETTE DEVICE OR DISK LIBRARY NAME**. If the file is on diskette, type in the name of the diskette device you want to use. If the file is on disk, type in the disk library name for the file.

**IF DISK - DELETE OFFLINE FILE? <Y/N>**. If you are copying the file from disk, type in **Y** (Yes) or **N** (No):

- Y** Deletes the file after you copy it
- N** Keeps the file on disk.

## Option 7. Enter IM Transactions (AMQM30)

Use this option to enter (add) a new inventory transaction to a batch or review (look at, change, or delete) an inventory transaction already in the batch. You also must use these steps to close previously loaded offline inventory transaction batches.

**Note:** Other IM transaction types are visible on the display, but are not accessible through REP. For a detailed description of the IM displays, their fields and functions, refer to the *Inventory Management User's Guide*, or use your **HELP** key.

**What information you need:** None.

**What reports are printed:** None.

**What forms you need:** None.

The basic steps to enter (or add) IM transactions to batch or review follow display.

### AMI3Z1—Inventory Transaction, Data Entry Control

Use this display to select either a new batch or a batch whose status is active, closed, or suspended.

This display appears after you select option 1 on the IM Transaction Processing menu (AMIM30) or option 7 on the REP Material Management menu (AMQM30).

```

DATE **/**/**                INVENTORY TRANSACTION                AMI3Z1  **
                              DATA ENTRY CONTROL

ENTER BATCH NUMBER  nnn
BATCH  *--ORIGINAL--*   *---LAST---*   BATCHES CURRENTLY IN USE ***
NO.    WSID   OPID      WSID   OPID      STATUS   DATE   USED   ERRORS
***    *****   ***   *****   ***   *****   **/**   *****   *****
***    *****   ***   *****   ***   *****   **/**   *****   *****
***    *****   ***   *****   ***   *****   **/**   *****   *****
***    *****   ***   *****   ***   *****   **/**   *****   *****
***    *****   ***   *****   ***   *****   **/**   *****   *****
***    *****   ***   *****   ***   *****   **/**   *****   *****
***    *****   ***   *****   ***   *****   **/**   *****   *****
***    *****   ***   *****   ***   *****   **/**   *****   *****
***    *****   ***   *****   ***   *****   **/**   *****   *****
***    *****   ***   *****   ***   *****   **/**   *****   *****
***    *****   ***   *****   ***   *****   **/**   *****   *****
***    *****   ***   *****   ***   *****   **/**   *****   *****
***    *****   ***   *****   ***   *****   **/**   *****   *****
***    *****   ***   *****   ***   *****   **/**   *****   *****
***    *****   ***   *****   ***   *****   **/**   *****   *****

                              USE ROLL UP/DOWN
                              F04 NEW BATCH
                              F24 CANCEL THE JOB

```

#### What to do

- To start a new batch, use **F04**. Go to display AMI3D01.
- To use an existing batch on the display, type the number of the batch in the **ENTER BATCH NUMBER** field, press **Field Exit**, then press **Enter**.
- If the batch contains active records, go to display AMI3D01. If the batch does not contain active records, go to display AMI3D31R.

- To locate an existing batch not on this display, type the number of the batch in the **LOCATE BATCH** field, press **Field Exit**, then press **Enter**. The batch you selected appears at the top of the list of batches on the display.

## Function keys

F04 NEW BATCH starts a new batch and the Inventory Transaction – Transaction Selection (Select) display (AMI3D01) appears.

F24 CANCEL THE JOB ignores the data you entered on this display and causes the menu to appear again.

## Fields

**BATCHES CURRENTLY IN USE.** The number of batches in process regardless of status.

**ENTER BATCH NUMBER.** Required. Type in the number of a specific batch to review or change. After the batch number is typed in, you are attached to that batch. The next display is from the first record in that batch.

**LOCATE BATCH.** Optional. Use this field to search for a specific batch with which you want to work. To quickly see the data entry control information for a batch, type in the batch number in this field. This display appears again with the requested batch on the first line of the list of batches.

**BATCH NO.** The sequential number assigned by the application to identify the batch.

### ORIGINAL.

**WSID (Original work station identification).** The work station where transactions for the batch were originally entered. For offline batches, asterisks appear.

**OPID (Original operator identification).** The ID of the operator who entered the batch. The operator ID appears only if security is activated. For offline batches, asterisks appear.

### LAST.

**WSID (Last work station identification).** The work station where the batch was last selected. For offline batches, asterisks appear.

**OPID (Last operator identification).** The ID of the operator who last selected the batch. The operator ID appears only if security is activated. For offline batches, asterisks appear.

**STATUS.** The batch status is one of the following codes:

**ACTIVE** The batch is being used by another work station or is incomplete because of some abnormal condition. An active online batch can be selected only from the work station that last selected that batch. An active offline batch can be selected from any work station, if the batch is not being acted on by a program.

**SUSPND** The system operator has selected **F23** on the Inventory Transaction – Batch Status display (AMI3D29) to suspend the batch. More

transactions can be entered in the batch. A suspended batch can be selected from any work station.

- CLOSED** The system operator has selected **F24** on the Inventory Transaction – Batch Status display (AMI3D29) to close the batch. The application can now use the batch to print the Inventory Transaction Register (AMV3G) and, in a batch update mode, to update the master files.
- UPDATE** The application has selected the batch for updating the master files.
- FINISH** The batch has been applied to the master files, but the transactions remain in the batch until the files are saved.

**DATE.** The creation date or date of last activity for the batch.

**RECORDS USED.** The number of transaction records in the batch.

**RECORDS ERRORS.** The number of transaction records errors that the application has detected.

## AMI3D01—Inventory Transaction, Transaction Selection (Select)

Use this display to select the type of inventory transactions to be entered in the batch and to specify default options for the batch.

This display appears when you enter an empty batch number or a new batch on display AMI3Z1.

```

DATE **/**/**                INVENTORY TRANSACTION          SELECT  AMI3D01  **
                              TRANSACTION SELECTION

TRANSACTION DATE              nnnnnn
SHORTAGE CHECKING <Y/N>      A

SELECT ONE OF THE FOLLOWING:  A2
 1 (CA) Cost adjustment       14 (RM) Production receipt
 2 (CR) Avg cost replacement  15 (RP) P.O. receipt to stock
 3 (CS) Std cost replacement  16 (RS) Component return to stock
 4 (IA) Inventory adjustment  17 (RW) Interwarehouse receipt
 5 (IP) Planned mfg issue     18 (SA) Sales shipment
 6 (IS) Miscellaneous issue   19 (SC) Mfg component scrap
 7 (IU) Unplanned component  20 (SM) Mfg order scrap
 8 (IW) Interwarehouse issue  21 (SP) Purchase order scrap
 9 (PB) Pick complete by item 22 (SS) Scrap from stock
10 (PC) Pick complete by order 23 (TW) Interwarehouse transfer
11 (RC) Miscellaneous receipt 24 (UR) P.O. update routings
12 (RD) P.O. receipt to dock  25 (VA) Vendor accept
13 (RI) P.O. receipt to inspection 26 (VR) Return to Vendor

                                F09 REVIEW ALL
                                F24 DISPLAY STATUS

```

### What to do

- To enter an inventory transaction, type **Y** or **N** in the **SHORTAGE CHECKING** field and either the number or the two-letter code for the type of transaction in the **SELECT** field and press **Enter**. One of the following displays appears:

Selection	Display	Notes
1 or CA	AMI3D02E	
2 or CR	AMI3D03E	
3 or CS	AMI3D04E	
4 or IA	AMI3D05E	
5 or IP	AMI3D06E	If mfg. order tracking supported
6 or IS	AMI3D07E	
7 or IU	AMI3D08E	If mfg. order tracking supported
8 or IW	AMI3D10E	
9 or PB	AMI3D11E	If mfg. order tracking supported
10 or PC	AMI3D13E	If mfg. order tracking supported
11 or RC	AMI3D15E	
12 or RD	AMI3D16E	If P.O. tracking supported and Purchasing not interfacing
12 or RD	AMI3D34E	If P.O. tracking supported and Purchasing is interfacing
13 or RI	AMI3D17E	If P.O. tracking supported and Purchasing not interfacing
13 or RI	AMI3D35E	If P.O. tracking supported and Purchasing is interfacing.
14 or RM	AMI3D18E	If mfg. order tracking supported
15 or RP	AMI3D19E	If P.O. tracking supported, Purchasing not interfacing, and item does not require inspection on receipt
15 or RP	AMI3D36E	If P.O. tracking supported, Purchasing is interfacing, and item does not require inspection on receipt
16 or RS	AMI3D20E	If mfg. order tracking supported
17 or RW	AMI3D21E	
18 or SA	AMI3D22E	
19 or SC	AMI3D23E	If mfg. order tracking supported
20 or SM	AMI3D24E	If mfg. order tracking supported and PC&C not interfacing
21 or SP	AMI3D25E	If P.O. tracking supported
22 or SS	AMI3D26E	
23 or TW	AMI3D09E	If multiple warehouses supported
24 or UR	AMI3D33E	If Purchasing is interfacing
25 or VA	AMI3D37E	If Purchasing is interfacing
26 or VR	AMI3D38E	If Purchasing is interfacing

**Note:** IP, IU, PB, RM, RS, and SC transactions are valid only when manufacturing order tracking is supported. SM transactions are valid only when manufacturing order tracking is supported and PC&C is not interfacing. SP transactions are valid only when purchase order tracking is supported. TW transactions are valid only when multiple warehouses are supported.

- To review inventory transactions already in the batch, use **F09**. Display AMI3D31R appears.



## Function keys

F09 REVIEW ALL causes the Inventory Transaction – Summary Review (Review) display (AMI3D31R) to appear, so you can review a summary of the last 12 transactions in the batch.

F24 DISPLAY STATUS causes the Batch Status display (AMI3D29) to appear, so you can review batch status, or close, suspend, or delete the batch.

## Fields

**TRANSACTION DATE.** Type in the date to be used as the default transaction date for the transactions you are entering. If this field is blank, the system date is used as the default. You can change the default for an individual transaction by typing in a different date on the transaction display.

**SHORTAGE CHECKING <Y/N>.** Required. Type in **Y** (yes) to review manufacturing and customer order shortages when entering receipt transactions. Type in **N** (no) if you do not want to review shortages.

**SELECT ONE OF THE FOLLOWING.** Required. Type in either the option number (1 through 26) or the transaction code (CA through VR) for the transaction type. The valid options and codes appear on the display. Option numbers 24 through 26 (UR through VR) appear only if IM and Purchasing are interfacing.

**Note:** Depending on the security controls established by your company, you may not have access to all transaction types. Should you select a transaction type for which you are not authorized, the application will issue a message.

## AMI3D29—Inventory Transaction, Batch Status

Use this display to review the status of the batch being worked on and, to delete, suspend, or close the batch.

This display appears when you select **F24** on display AMI3D01.

```
DATE **/**/**          INVENTORY TRANSACTION          AMI3D29  **
                        BATCH STATUS

BATCH NUMBER ***

BATCH TOTALS    QUANTITY          AMOUNT    NO OF TRANS    NO OF ERRORS
                *****.***    *****.****    *****

F20 DELETE BATCH
F23 SUSPEND BATCH
F24 CLOSE BATCH
```

### What to do

To delete, suspend, or close the batch, use one of the function keys listed on the display. Press **Enter** to go to display AMI3D01.

### Function keys

F20 DELETE BATCH deletes the batch of data you entered. You are asked to select **F20** again to be sure that the first selection was not in error. After the second selection of **F20**, the batch is deleted. **F20** appears and it is only valid in batch update mode.

F23 SUSPEND BATCH marks the current transaction entry batch as suspended. If batch update (transaction register) is run, the suspended batch is not included.

F24 CLOSE BATCH marks the current transaction batch as closed. If batch update (transaction register) is run before reentry, you cannot update this batch. Master files are updated with these batch records.

If the batch includes immediate update transactions with a U (unapplied) reversal code, **F24** does not appear. You cannot close the batch until you have changed all reversal codes to A or E.

## Fields

**BATCH NUMBER.** The sequential number assigned by the application to identify the batch.

### **BATCH TOTALS.**

**QUANTITY.** An accumulation of the quantity values of all valid transactions submitted for entry into the batch.

**AMOUNT.** An accumulation of the amount values of all valid transactions submitted for entry into the batch.

**NO OF TRANS (Number of Transactions).** A count of all transactions entered into the batch.

**NO OF ERRORS.** The total number of transactions in the batch that have a reversal code of E or U.

## AMI3D31R—Inventory Transaction, Summary Review (Review)

Use this display to review a group of inventory transactions previously entered in the batch.

This display appears when you select **F04 REVIEW ALL** on the Inventory Transaction, Transaction Selection (Select) display (AMI3D01), the Inventory Transaction, Detail Review (Review) display (AMI3D32R), or any of the individual transaction entry or review displays.

This display also appears when you select an existing batch on the Data Entry Control display (AMI3Z1).

The top of the display contains a summary of 6 of the transactions in the current batch. The bottom of the display contains an entry field for selecting one of these transactions for detail review.

DATE **/**/**	INVENTORY TRANSACTION SUMMARY REVIEW				REVIEW	AMI3D31R **
REF RV TR NO. CD CD ORDER	ITEM NUMBER	WH	SEQ	BLK	QUANTITY	U/M CMP TRAN/REPL AMT
**** *	*****	*****	***	***	*****	***** ,*** ** *
**** *	*****	*****	***	***	*****	***** ,*** ** *
**** *	*****	*****	***	***	*****	***** ,*** ** *
**** *	*****	*****	***	***	*****	***** ,*** ** *
**** *	*****	*****	***	***	*****	***** ,*** ** *
**** *	*****	*****	***	***	*****	***** ,*** ** *
-----						
ENTER REFERENCE NO.   nnnn			USE ROLL UP/DOWN F05 CHANGE F10 RETURN TO SELECT			

### What to do

- To look at one of the transactions listed in more detail, type in its reference number and press **Enter**. Go to display AMI3D32R.
- To change or delete one of the transactions shown, type in its reference number and use **F05**. The display for the kind of transaction you chose appears.
- To enter additional inventory transactions or to look at the status of the batch, use **F10** to return to display AMI3D01.

### Function keys

**F05 CHANGE** causes the transaction review display for the transaction you selected to appear. This allows you to change, delete, or reverse the transaction. This function key is only valid if you type in a reference number.

Depending on the security controls established by your company, you may not have access to all transaction types. Should you select to change a transaction type for which you are not authorized, the application will issue a message.

F10 RETURN TO SELECT causes the Inventory Transaction – Transaction Selection (Select) display (AMI3D01) to appear again. You can enter additional transactions.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**REF NO. (Reference Number).** A system-assigned reference number for each of the transactions shown. Type in one of these numbers at the bottom of the display to see the detail for one of the transactions shown.

**RV CD (Reversal Code).** The status of the transaction within the batch:

**blank** Active. This code appears for valid transactions.

**E** Error. This transaction was accepted with errors when you selected **F17** during batch update, or when you changed U to E during immediate update.

**U** Unapplied. This code appears for transactions made in immediate update mode that were not accepted because of errors. Before the batch can be closed, transactions with code U must be changed to either E (accept with error), or A (reactivate). If you change U to E, no master files are updated.

**TR CD (Transaction Code).** For IM, the transaction types are:

<b>CA</b>	Cost adjustment
<b>CL</b>	Component transfer to line
<b>CN</b>	Component transfer to stores
<b>CR</b>	Average cost replace
<b>CS</b>	Standard cost replace
<b>CU</b>	Standard unit cost default replacement
<b>IA</b>	Inventory adjustment
<b>IP</b>	Planned manufacture issue
<b>IS</b>	Miscellaneous issue
<b>IU</b>	Unplanned component issue
<b>IW</b>	Interwarehouse issue
<b>MQ</b>	Manufacturing item QC complete
<b>PH</b>	Physical inventory update
<b>PQ</b>	Purchase item QC complete
<b>RC</b>	Miscellaneous receipt
<b>RM</b>	Production receipt
<b>RP</b>	P.O. receipt to stock
<b>RQ</b>	Shelf life expired - reject
<b>RS</b>	Component return to stock
<b>RW</b>	Interwarehouse receipt
<b>SA</b>	Sales shipment
<b>SC</b>	Manufacturing component scrap
<b>SM</b>	Manufacturing order scrap
<b>SP</b>	Purchase order scrap
<b>SQ</b>	QC status change
<b>SS</b>	Scrap from stock
<b>VR</b>	Purchase return to vendor

**ORDER.** The manufacturing, purchase, or customer order number associated with this transaction. If COM is installed and interfacing with IM, a customer order number includes the company number and order type of the associated customer order.

**ITEM NUMBER [?].** The item number associated with this transaction.

**WH (Warehouse Code).** The code of the warehouse where this item is stored.

**SEQ (User Sequence).** If the transaction is associated with a manufacturing order, this field can contain a user sequence number. If the transaction is associated with a purchase order, it is the sequence number of a miscellaneous or service item.

**BLK (Blanket Release Number).** If the transaction is associated with a blanket purchase order, this field can contain a blanket release number.

**QUANTITY.** The quantity of the item associated with this transaction.

**UM (Unit of Measure).** The unit of measure entered with the transaction.

**CMP (Completion Code).** A code indicating the status of a production receipt (RM) or a purchase receipt to stock (RP) transaction.

<b>C</b>	Receipt complete
<b>P or blank</b>	Partial receipt
<b>R</b>	Completed order has been reopened

**TRAN/REPL AMOUNT (Transaction or Cost Replace Amount).** The amount of the transaction.

**ENTER REFERENCE NO.** Type in the reference number of one of the transactions on the display.

## AMI3D32R—Inventory Transaction, Detail Review (Review)

Use this display to review an Inventory transaction previously entered in the batch.

This display appears when you enter a reference number on the Inventory Transaction, Summary Review (Review) display (AMI3D31R). This display also appears when you press **Enter**, or select **F02**, **F03**, or **F20** on a Transaction Review display.

```

DATE **/**/**                INVENTORY TRANSACTION          REVIEW    AMI3D32R **
                              DETAIL REVIEW

TR
CD ORDER                    ITEM NUMBER          WHSE    QUANTITY    U/M CMP SEQ.  BLK
** *****                *****                ***    *****_* ** *   ***  ****

      TRAN AMOUNT  REFERENCE  REASON  DATE    COST RPL AMT  LOCATION  BATCH/LOT
      *****_* ** *****                *        *****_* **   ***      ****

FIFO DATE                GRN                                GRN INV <Y/N>  VENDOR
*****                *****                                *              *****
-----

                                ** PAGING FORWARD

                                F02 PAGE FORWARD
                                F03 PAGE BACKWARD
                                F05 CHANGE
                                F09 REVIEW ALL
                                F10 RETURN TO SELECT
  
```

### What to do

- To review another inventory transaction, press **Enter**. This display appears again with either the next or the previous transaction in the batch, depending on whether you page forward or backward.
- To begin a search, type a question mark [?] in the **ITEM NUMBER** or **LOCATION** field and press **Enter**.

### Function keys

F02 PAGE FORWARD causes display AMI3D32R to appear again with the next transaction in the batch.

F03 PAGE BACKWARD causes display AMI3D32R to appear again with the previous transaction in the batch.

F05 CHANGE causes the transaction review display for this transaction to appear. This display allows you to change, delete, or reverse the transaction.

Depending on the security controls established by your company, you may not have access to all transaction types. Should you select a transaction type for which you are not authorized, the application will issue a message.

F09 REVIEW ALL causes the Inventory Transaction – Summary Review (Review) display (AMI3D31R) to appear so you can review a summary of the next or the previous group of transactions in the batch depending on whether you were paging forward or backward.

F10 RETURN TO SELECT causes the Inventory Transaction – Transaction Selection (Select) display (AMI3D01) to appear again. You can enter additional transactions.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

All of the fields on this display are informational only. To change any of these fields, press **F05 CHANGE**.

**TR CD (Transaction Code)**. For IM, the transaction types are:

<b>CA</b>	Cost adjustment
<b>CL</b>	Component transfer to line
<b>CN</b>	Component transfer to stores
<b>CR</b>	Average cost replace
<b>CS</b>	Standard cost replace
<b>CU</b>	Standard unit cost default replacement
<b>IA</b>	Inventory adjustment
<b>IP</b>	Planned manufacture issue
<b>IS</b>	Miscellaneous issue
<b>IU</b>	Unplanned component issue
<b>IW</b>	Interwarehouse issue
<b>MQ</b>	Manufacturing item QC complete
<b>PH</b>	Physical inventory update
<b>PQ</b>	Purchase item QC complete
<b>RC</b>	Miscellaneous receipt
<b>RM</b>	Production receipt
<b>RP</b>	P.O. receipt to stock
<b>RQ</b>	Shelf life expired - reject
<b>RS</b>	Component return to stock
<b>RW</b>	Interwarehouse receipt
<b>SA</b>	Sales shipment
<b>SC</b>	Manufacturing component scrap
<b>SM</b>	Manufacturing order scrap
<b>SP</b>	Purchase order scrap
<b>SQ</b>	QC status change
<b>SS</b>	Scrap from stock
<b>VR</b>	Purchase return to vendor

**ORDER**. The manufacturing or purchase order number associated with this transaction. If COM is installed and interfacing with IM, a customer order number includes the company number and order type of the associated customer order.

**ITEM NUMBER [?]**. The item number associated with this transaction.

**WHSE (Warehouse Code)**. The code of the warehouse where this item is stored. If you have only one warehouse, this field does not appear. If this is an interwarehouse transfer, both the issuing and receiving warehouse codes are shown.



**QUANTITY.** The quantity of the item associated with this transaction.

**U/M (Unit of Measure).** The unit of measure entered with the transaction.

**CMP (Completion Code).** A code indicating the status of a production receipt (RM) or a purchase receipt to stock (RP) transaction.

<b>C</b>	Receipt complete
<b>P or blank</b>	Partial receipt
<b>R</b>	Completed order has been reopened

**SEQ. (User Sequence or Line Item Sequence).** If the transaction is associated with a purchase order, this field can contain a line item sequence number. If the transaction is associated with a manufacturing order, this field can contain a user sequence number. If this field is blank, neither number is entered with the transaction.

**BLK (Blanket Release).** If the transaction is associated with a blanket purchase order, this field can contain a blanket release number.

**TRAN AMOUNT (Transaction Amount).** The amount of the transaction. This field is not required; however, if you enter an amount, a Cost Adjustment (CA) is made to the cost field in the Item Balance file.

**REFERENCE.** A user-defined value used for reference purposes only. It is printed on the Inventory Transaction Register report (AMV3G).

**REASON.** A code explaining the reason for this transaction.

**DATE.** The date of this transaction.

**COST RPL AMT.** The monetary amount associated with item cost transactions (transaction codes CA, CR, and CS).

**LOCATION [?].** The stock location of the item.

**BATCH/LOT.** Unique identification of a specific batch or lot of an item. When an item is defined as having batch/lot control, all transactions involving that item must carry the batch/lot number. This field can be used only if the Batch/Lot Control option was selected during application tailoring.

**FIFO DATE (First-in-first-out Date).** The date when the item was received in stock or issued from stock. This field appears only if you selected the FIFO date integrity option during application tailoring.

**GRN (Goods Received Note).** This field appears if you selected the GRN option during application tailoring or if IFM is installed and interfacing. The number of the goods received note that corresponds to a receipt. This field is user-defined and can represent a receiving ticket, a bill of lading, or an IFM invoice number. The GRN is used by the accounts payable department to check that invoiced items were actually received.

**GRN INV (Goods Received Notes Invoice).** Type in one of the following to describe the use of the GRN field:

**Y** GRN is an invoice number

**N** GRN is being used to match another document, such as a bill of lading

**blank** This is the default.

**VENDOR.** The vendor supplying this item.

The following fields only appear when you review an Unplanned Component Issue (IU) transaction:

**DESCRIPTION.** A description of the item issued.

**TOTAL QUANTITY.** The total quantity of the component required for the order.

**ADJ QTY PER.** Type in the adjusted quantity per of this component used in each parent item.

**STD QTY PER.** Type in the standard quantity per of this component used in each parent item.

If the Backflush code for the item on this order is 2 (standard quantity per), you can enter a standard quantity per that is different from the adjusted quantity per. When the component is backflushed, the standard quantity per will be used. If you backflush at standard, you must account for material used in excess of the standard quantity using scrap transactions. If the Backflush code is 1 (adjusted quantity per), the **STD QTY PER** field is not used.

**REQUIRED DATE.** Date when this component item must be available to the shop floor for the order. For Repetitive schedules, this date is automatically generated. For manufacturing orders, this date can be entered during order release or allocation maintenance. If no date was entered and the component has no lead time offset in the product structure, this is the scheduled start date. If no date was entered and the component has a lead time adjustment in the product structure, this date is the order due date less the component lead time adjustment from the product structure file.

**OPERATION USED.** The sequence number of the first operation in which this component is used in the parent item.

## Option 8. Print Transaction Register (AMQM30)

Use this option when you want to print a historical record of transactions entered against REP schedules, and to write the transactions to the REP Transaction History file.

You must determine which closed batches you want to print on the report.

**What information you need:** The individual batch number for which you want to print transactions.

**What reports are printed:**

- Transaction Register–Posted Transactions (AMQ361)
- Transaction Register–Transaction Totals (AMQ362)

**What forms you need:** None.

The basic steps to print a copy of the REP Transaction Register follow display.

### AMQ361—Print Transaction Register (Select)

Use this display to select the closed transaction batches that you want to include on the REP Transaction Register. You can select all batches, an individual batch, all batches closed at a specific work station, or all batches closed by a specific person. You can also select to print errors only, on the Transaction Register report, or print all transactions.

**Note:** This menu option includes only the transactions entered using options 5 and 6 on the Material Management Menu (AMQM30). To print transactions entered using option 7 on AMQM30, refer to the *Inventory Management User's Guide*.

This display appears when you select option 8 on the Material Management menu (AMQM30).

```
DATE **/**/**          PRINT TRANSACTION REGISTER          SELECT          AMQ361  **

SELECT CLOSED BATCHES  n
                       1  ALL
                       2  SINGLE BATCH          nnn
                       3  BY WORK STATION ID    aaaaaaaA10
                       4  BY OPERATOR ID       aA3
PRINT ERRORS ONLY      A

F24 CANCEL JOB
```

## What to do

- To select all closed batches to be printed, type **1** in the **SELECT CLOSED BATCHES** field and press **Enter**.
- To select a single closed batch to be printed, type **2** in the **SELECT CLOSED BATCHES** field and the number of the batch in the **SINGLE BATCH** field, and press **Enter**.
- To select closed batches by Work Station ID, type **3** in the **SELECT CLOSED BATCHES** field and an ID number in the **BY WORK STATION ID** field, and press **Enter**.
- To select closed batches by Operator ID, type **4** in the **SELECT CLOSED BATCHES** field and an ID number in the **BY OPERATOR ID** field, and press **Enter**.

## Function keys

F24 CANCEL JOB shows you the Material Management menu (AMQM30) without printing the report. You can then choose another option or end this activity.

## Fields

**SELECT CLOSED BATCHES.** Required. Type one of the following:

- 1** To print all closed transaction batches on the report.
- 2** To only print a specific batch on the report. Type in a batch number in the **SINGLE BATCH** field if you entered **2** in the **SELECT CLOSED BATCHES** field.
- 3** To print all batches closed by a specific work station. Type in a work station ID if you entered **3** in the **SELECT CLOSED BATCHES** field.
- 4** To print all batches closed by a specific operator. Type in an operator ID if you entered **4** in the **SELECT CLOSED BATCHES** field.

**PRINT ERRORS ONLY.** Type in **Y** (Yes) if you want to print only errors on the Transaction Register report. Type in **N** (No) if you want to print all transactions.

## Chapter 6. Schedule Management

When you select option 4 on the Repetitive Production Management Main Menu (AMQM00), the Schedule Management (AMQM40) appears. This menu has 10 options to allow you to enter, release, and maintain production schedules.

Option 1. Set Schedule Review/Release Horizon (AMQM40).....	6-3
Option 2. Maintain Customer Manufacturing Dates (AMQM40) .....	6-6
Option 3. Extract Schedule Requirements (AMQM40).....	6-10
Option 4. Enter and Maintain Schedules (AMQM40) .....	6-12
Option 5. Sequence Schedules (AMQM40) .....	6-36
Option 6. Release Schedules (AMQM40) .....	6-40
Option 7. Print Schedule Information (AMQM40) .....	6-45
Option 8. Purge Schedules (AMQM40) .....	6-51
Option 9. Review Schedule Performance (AMQM40) .....	6-59
Option 10. Recalculate Schedules (AMQM40).....	6-68

```

AMQM40                      Repetitive Production Management          *****
                               Schedule Management

Type option or command; press Enter.

  1. Set Schedule Review/Release Horizon
  2. Maintain Customer Manufacturing Dates
  3. Extract Schedule Requirements
  4. Enter and Maintain Schedules
  5. Sequence Schedules
  6. Release Schedules
  7. Print Schedule Information
  8. Purge Schedules
  9. Review Schedule Performance
 10. Recalculate Schedules

==> _____

F3=Exit      F4=Prompt      F9=Retrieve      F10=Actions
F11=Job status  F12=Return      F22=Messages

```

**Option 1. Set Schedule Review/Release Horizon.** Use this option to maintain dates that set horizons over which schedules are usually reviewed and released. The review date also establishes the end date over which smoothing occurs.

**Option 2. Maintain Customer Manufacturing Dates.** Use this option to update manufacturing due dates to line items and blanket release line items on a customer order. Reference information is provided by customer request dates if Customer Order Management (COM) is interfacing.

**Option 3. Extract Schedule Requirements.** Use this option to review the extract horizon date established in option 1 and extract the latest requirements for scheduling.

**Option 4. Enter and Maintain Schedules.** Use this option to review schedule requirements and to enter and maintain production schedules. Carry forward calculations are also performed using this option.

**Option 5. Sequence Schedules.** Use this option to change the order in which schedules are produced on a production line for a specified date.

**Option 6. Release Schedules.** Use this option to release production schedules and allocate component requirements.

**Option 7. Print Schedule Information.** Use this option to print schedule packets and the Production Reporting List.

**Option 8. Purge Schedules.** Use this option to delete schedules from the files and produce the Schedule Performance and Item/Line in Process reports.

**Option 9. Review Schedule Performance.** Use this option to review schedule performance information for current schedules and for the time period since the last schedule purge.

**Option 10. Recalculate Schedules.** Use this option to select lines for which schedules will be recalculated. You run this option when you have changed line capacity, schedule quantity, Calendar file, or the production facility.

---

## Option 1. Set Schedule Review/Release Horizon (AMQM40)

Use this option to maintain dates over which schedules are usually reviewed and released.

You can choose how you want to set the Review/Release Horizon dates. If MRP is installed and interfacing, the review and release horizon dates set in MRP may be used. Or you may choose to create review and release horizon dates whether or not MRP is installed and interfacing.

**What information you need:** The new review and release horizon dates, if you do not want the dates to be calculated by MRP.

**What reports are printed:** None.

**What forms you need:** None.

The basic steps to Set Schedule Review/Release Horizon follow each display.

### AMQ410—Set Schedule Review/Release Horizon (Select)

Use this display to select the warehouse for which you want to set schedule horizons.

This display appears only when you select option 1 on menu AMQM40 and you have multiple warehouses defined.

```
DATE **/**/**      SET SCHEDULE REVIEW/RELEASE HORIZON  SELECT  AMQ410  **  
  
      WAREHOUSE      aA3  
  
                                F24 END OF JOB  
                                +
```

#### What to do

- To accept the default warehouse, press **Enter**.
- To enter another warehouse, type in the new number and press **Enter**.

## Function keys

F24 END OF JOB shows you the REP Schedule Management menu (AMQM40) again so you can choose another schedule option or end this activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WAREHOUSE (HOUSE) [?]**. This field contains the value of the default planning warehouse. You may type in the code of another warehouse from which components are issued and the finished items received. Leave this field blank to update each warehouse in turn.

## AMQ411—Set Schedule Review/Release Horizon (Change)

Use this display to maintain review/release horizon options and the number of days or weeks in the horizon. The WEEKS IN REVIEW HORIZON and DAYS IN RELEASE HORIZON values in the **Current** fields are those you entered when **F13 ACCEPT CHANGE** was last selected.

If MRP is installed, you can choose option code 2, MRP REVIEW OR RELEASE HORIZON, to make REP's review and release dates compatible to MRP's review and release dates. If you choose option code 1, USER-ENTERED DAYS/WEEKS, REP will use the dates that you enter. The smoothing algorithm is based on the review horizon end date entered on this display.

This display appears when you select option 1 on menu AMQM40 if multiple warehouse support is not active. If multiple warehouse support is active this display follows display AMQ410.

DATE **/**/**	SET SCHEDULE REVIEW/RELEASE HORIZON CHANGE	AMQ411	**
	WAREHOUSE ***		
		NEW	CURRENT
REVIEW HORIZON OPTION		1	*
WEEKS IN REVIEW HORIZON		nn	**
RELEASE HORIZON OPTION		1	*
DAYS IN RELEASE HORIZON		nn	**
REVIEW START DATE		**/**/**	**/**/**
RELEASE END DATE		**/**/**	**/**/**
REVIEW END DATE		**/**/**	**/**/**
	OPTION CODES	1	USER-ENTERED DAYS/WEEKS
		2	MRP REVIEW OR RELEASE HORIZON
			F13 ACCEPT CHANGE
			F19 RETURN TO SELECT
			F24 CANCEL JOB
			+



## What to do

- To enter new review and release horizon dates, type **1** in the **OPTION CODE** field and press Enter. Go to display AMQ411.
- To allow MRP to calculate the review and release horizon dates, type **2** in the **OPTION CODE** field and press **Enter**. Go to display AMQ411.
- To accept the new calculated dates, use **F13**.

## Function keys

F13 ACCEPT CHANGE updates the Planning Information file and returns you to the Select display (AMQ410).

F19 RETURN TO SELECT returns to the Select display (AMQ410) so you can select another warehouse.

F24 CANCEL JOB shows you the REP Schedule Management menu (AMQM40) again so you can choose another schedule option or end this activity.

## Fields

**WAREHOUSE (HOUSE)**. The warehouse selected on display AMQ410 or the default planning warehouse.

**REVIEW HORIZON OPTION (NRVOP)**. Required. Type in the review horizon option:

- 1 Review horizon is user-defined.
- 2 Review horizon is generated by MRP.

**WEEKS IN REVIEW HORIZON (NRVWK)**. Required. Type in the number of weeks to be included in the new review horizon. The horizon determines the period of time over which requirements are extracted. It also affects the period of time over which requirements are smoothed. This option is only available if you choose option 1 to define the Review Horizon.

**RELEASE HORIZON OPTION (NLOPT)**. Required. Type in the release horizon option:

- 1 Release horizon is user-defined.
- 2 Release horizon is generated by MRP.

**DAYS IN RELEASE HORIZON (NRLDY)**. Required. Type in the number of days in the new release horizon. The horizon determines the number of days over which new schedules may be released. This field is only available if you choose option 1 to define the Release Horizon.

**REVIEW START DATE (NRVSD)**. The first work day of the current week. The date is determined when either you press **Enter** or use **F13 ACCEPT CHANGE**.

**RELEASE END DATE (RLEDT)**. The ending schedule release date based on the number of days entered, or on the date generated by MRP.

**REVIEW END DATE (NRVED)**. The last date of the review horizon, based on the number of weeks specified in the review horizon or on the date generated by MRP.

---

## Option 2. Maintain Customer Manufacturing Dates (AMQM40)

Use this option to assign manufacturing due dates to line items and blanket release line items on a customer order entered through the COM application.

Production schedules for a given day are matched against COM line item demand for that date. If demand exceeds production, you can choose to change a line item's manufacturing date to gain capacity and still satisfy a customer's ship date.

**What information you need:** The warehouse, manufacturing date, or the item number.

**What report is printed:** Maintain Customer Manufacturing Dates Audit (AMQ42).

**What forms you need:** None.

The basic steps to Maintain Customer Manufacturing Dates follow each display.

### AMQ421—Maintain Customer Manufacturing Dates (Select)

Use this display to select customer orders for review or maintenance of their manufacturing schedule date. You can select the orders by item or manufacturing date or both.

This display appears when you select option 2 on menu AMQM40.

```
DATE **/**/**      MAINTAIN CUSTOMER MANUFACTURING DATES  SELECT  AMQ421  **  
  
WAREHOUSE          aA3  
MANUFACTURING DATE nnnnnn  
ITEM NUMBER        aaaaaaaaaaaaA15  
LATE REQUIREMENTS ONLY <Y,N>  A  
  
F24 END OF JOB  
+
```

#### What to do

To select customer manufacturing dates for maintenance, enter the information you need, and press **Enter**. Go to display AMQ422.

## Function keys

F24 END OF JOB shows you the REP Schedule Management menu (AMQM40) again, so you can choose another schedule option or end this activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WH (Warehouse) (HOUSE) [?]**. Required. This field contains the value of the default planning warehouse. Type in the code of the warehouse from which components are issued and the finished items received.

**MANUFACTURING DATE (MANDT)**. Required. Type in a manufacturing date to select orders for review or maintenance.

**ITEM NUMBER (ITNBR) [?]**. Required. Type in an item number to select records by item to be processed.

**LATE REQUIREMENTS ONLY <Y,N> (YORN)**. Type in one of the following:

- Y** Yes. Select customer order line items that have request dates that are earlier than the manufacturing date plus the customer's ship lead time.
- N** No. Bypass this option.

## AMQ422—Maintain Customer Manufacturing Dates (Change)

Use this display to change the manufacturing schedule date for a customer line item or for a blanket release. All of the customer demand for a date is shown with respect to the total units scheduled. You can change the manufacturing schedule date for orders to bring demand in line with scheduled production.

If S-NUMBER is not supported, only the **BK ORD** and **PT SHIP** fields appear when you use **F12 ADDITIONAL FIELDS**.

This display appears after you enter data on AMQ421.

```

DATE **/**/**      MAINTAIN CUSTOMER MANUFACTURING DATES  CHANGE      AMQ422  **
WH ***  ITEM *****
DATE **/**/** DEMAND *, ***, ***.*** SCHEDULED *, ***, ***.*** VAR *, ***, ***.***
LATE REQUIREMENTS ONLY

      MFG  -----  CUSTOMER -----
U  DATE  REQ DATE  ORD DATE  ORDER NO  BK  ORD  PT  SHIP  DEMAND QTY  REL NO
*  nnnnnn **/**/** **/**/** ** ***** * , ***, ***.*** *****
      *****
*  nnnnnn **/**/** **/**/** ** ***** * , ***, ***.*** *****
      *****
*  nnnnnn **/**/** **/**/** ** ***** * , ***, ***.*** *****
      *****
*  nnnnnn **/**/** **/**/** ** ***** * , ***, ***.*** *****
      *****

                                F01 NEXT DATE      F12 ADDITIONAL FIELDS
                                F02 NEXT ITEM        F19 RETURN TO SELECT
                                USE ROLL UP/DOWN      F24 END OF JOB
                                                                +

```

**What to do**

- To see the next date for the selected item, use **F01**.
- To see the next item for the selected date, use **F02**.
- To see additional fields, use **F12**. To return to the original display format, use **F12** again.
- To return to the Maintain Customer Manufacturing Dates (Select) display (AMQ421), use **F19**.

**Function keys**

USE ROLL UP/DOWN scrolls up and down through the pages of line items and blanket release line items.

F01 NEXT DATE goes to the next ascending date if an item number was entered on AMQ421.

F02 NEXT ITEM goes to next ascending item if a manufacturing date was entered on AMQ421.

F12 ADDITIONAL FIELDS allows you to review the second line of fields on the display. Using **F12** a second time returns you to the original format of one line of fields.

F19 RETURN TO SELECT returns to the Select display (AMQ421) so you can select another record.

F24 END OF JOB prints the Maintain Customer Manufacturing Dates Audit report (AMQ42) and shows you the REP Schedule Management menu (AMQM40) again so you can choose another schedule option or end this activity.

## Fields

**WH (Warehouse) (HOUSE).** The warehouse from which components are issued and the finished items are received.

**ITEM (ITNBR).** The number of the item for which you want to modify manufacturing dates.

**AVL (Available) (AVAIL).** The net quantity not yet committed to a production schedule.

**DATE (MFGDT).** The manufacturing due date selected on the initial display or the oldest date for this item if no date was entered.

**DEMAND (EQNTY).** The total customer demand for this warehouse/item/date combination from the extract file.

**SCHEDULED (SCHED).** The total quantity for this date scheduled for this warehouse/item/date combination.

**VAR (VARI2).** The total variance quantity for this item/date combination. (Scheduled quantity minus demand quantity.)

**U (UPDAT).** The update code to identify which customer line items have had date changes.

**MFG DATE (MFIDT).** Type in the manufacturing due date for the customer line item or blanket release. A change to this date will update the customer line item.

**CUSTOMER REQ DATE (RQIDT).** The delivery date requested by the customer for each line item or blanket release.

**CUSTOMER ORD DATE.** The date of the customer's order.

**CUSTOMER ORDER NO (ORDNR).** Control number assigned to the order.

**DEMAND QTY (DMQTY).** The unsatisfied demand for this customer line item or blanket release. (Order quantity minus quantity shipped.)

**REL NO (RLNB).** Blanket release number from a customer order.

**BK ORD (Back Order) (BKORD).** The code that indicates if a customer will accept backordered shipments.

**N** Does not allow backorders  
**Y** Allows backorders

**PT SHIP (Partial Shipment) (BKPSC).** The code to determine if a customer will accept partial shipment of backordered items.

**N** Does not allow partial shipments of backorders  
**Y** Allows partial shipments of backorders

**S-NUMBER (SNMBR).** The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

## Option 3. Extract Schedule Requirements (AMQM40)

Use this option to review the extract horizon date and extract the latest requirements.

**What information you need:** The warehouse, if you want the extract performed for a specific warehouse.

**What reports are printed:**

- Extract Schedule Requirements Error List (AMQ471)
- Extract Schedule Requirements Totals Report (AMQ472)

**What forms you need:** None.

The basic steps to Extract Schedule Requirements follow each display.

### AMQ431—Extract Schedule Requirements (Select)

Use this display to review the source or sources of requirements. The display appears prior to the extract function to allow you to confirm the last date from which requirements will be extracted from the sources listed. These requirements are used in the schedules in Schedule Entry and Maintenance.

This display appears when you select option 3 on menu AMQM40.

```
DATE **/**/**          EXTRACT SCHEDULE REQUIREMENTS    SELECT    AMQ431  **

                               WAREHOUSE          aA3
                               EXTRACT HORIZON DATE  **/**/**
                               SOURCE OF REQUIREMENTS *****
                               *****

                               F16 RUN JOB NOW
                               F24 CANCEL JOB

                                                                 +
```

#### What to do

To run the extract in a batch mode, press **Enter**. To perform the extract interactively, use **F16**.

If you press **Enter** to accept the default warehouse, the job is submitted to the job queue.

If you change the warehouse and press **Enter**, the display appears again with the appropriate extract horizon date. If this is correct, press **Enter** again to submit the job

to the job queue; print the Extract Schedule Requirements Error report; and show the Schedule Management menu (AMQM40) again. If errors occur, this display (AMQ431) appears again with the errors highlighted.

### Function keys

F16 RUN JOB NOW runs the job now, not in the job queue. The error report is printed and the Schedule Management menu (AMQM40) appears again.

F24 CANCEL JOB shows you the REP Schedule Management menu (AMQM40) again, so you can choose another option or end this activity.

### Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WAREHOUSE (HOUSE) [?]**. This field contains the value of the default planning warehouse. Type in the code of another warehouse to extract requirements for that warehouse, or leave the field blank to extract requirements for all warehouses.

**EXTRACT HORIZON DATE (RVEDT)**. This field initially contains the review horizon end date of the default planning warehouse. If you enter another planning warehouse in the **WAREHOUSE** field, this field contains the date for the new warehouse. If you leave the **WAREHOUSE** field blank to select all warehouses, this field contains the latest date of all the planning warehouses.

**SOURCE OF REQUIREMENTS**. The field shows from where the production requirements for the item will be extracted: COM, MRP, or the Schedule Demand file.

---

## Option 4. Enter and Maintain Schedules (AMQM40)

Use this option to develop production schedules. You can enter and maintain unreleased schedules, create multiple schedule (lots) from an unreleased schedule, change the quantity on released schedules, and determine how well your production plan meets the extracted demand requirements.

To enter a schedule, you need only enter a date and quantity for a desired item and production line. To change the date or quantity of a released schedule you need to consider if a schedule has been primed or not.

- **Changing a primed schedule.** For a change to a schedule's date, merely re-key the schedule date. Then the application automatically adjusts all allocation, operation, and replenishment records for the new date. If a schedule's quantity is changed, then replenishment records may need to be adjusted to correctly show the schedule's component allocations and replenishment needs. If the schedule quantity is increased, then you most likely will need to create additional Replenishment (RL) transactions in Transaction Entry to account for the increase in planned material usage. A decrease in the schedule quantity will generally not require any replenishment changes since the worst that can happen is that some excess material may be sent to the line. If you have many replenishment records to add, an alternative may be to delete and purge the schedule and then reenter it using the proper schedule quantity.

**Note:** You cannot delete a primed schedule by changing its quantity to zero. You must use the Schedule Purge option instead.

- **Changing a schedule that is not primed.** If a schedule is not primed, you can change its date or quantity by re-keying the information. The application will automatically handle the change to its allocation and operation records. Since replenishment records are not created until a schedule is primed, there are no special considerations required for these records.

When you change scheduled quantities to a larger amount and the schedule has already been primed, Replenishment transactions must be entered to satisfy the additional component requirements. You can delete the entire schedule and create a new schedule for the correct amount, or add a new schedule for a different amount when you have many components for which Replenishment transactions must be generated.

An immediate demand extract can be run for a specific warehouse/item combination. You can also review material availability for a specific schedule and line load hours.

**What information you need:** The line, item, or planner for each schedule that you want to see.

**What report is printed:** Enter and Maintain Schedules—Carry Forward Audit (AMQ44).

**What forms you need:** None.

The basic steps to Enter and Maintain Schedules follow each display.



## AMQ440—Enter and Maintain Schedules (Select)

Use this display to select the warehouse for which you want to enter and maintain schedules.

This display appears only when you have multiple warehouses defined and you select option 4 on menu AMQM40 or option 8 on menu AMMM40.

```
DATE **/**/**          ENTER AND MAINTAIN SCHEDULES          SELECT          AMQ440 **  
  
WAREHOUSE          aA3  
  
F24 END OF JOB          +
```

### What to do

- To accept the default warehouse, press **Enter**.
- To enter another warehouse, type in the new number and press **Enter**.

### Function keys

F24 END OF JOB shows you the menu again, so you can choose another schedule option or end this activity.

### Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WAREHOUSE (HOUSE) [?]**. This field is required. This field contains the value of the default planning warehouse. You can type in the code of another warehouse from which components are issued and the finished items received.

## AMQ441—Enter and Maintain Schedules (Select)

Use this display to select production requirements, to select schedules to review and maintain, to begin the demand extract, to begin the lot sizing function, and to perform the carry forward function. Schedules are selected by item, line, or planner. You can use the Display Horizon From/To fields to control the dates presented on the ensuing displays.

This display appears when you select option 4 on menu AMQM40 or option 8 on menu AMMM40 if multiple warehouse support is not active. If multiple warehouse support is active, this display follows display AMQ440.

```

DATE **/**/**          ENTER AND MAINTAIN SCHEDULES  SELECT  AMQ441  **
WAREHOUSE             ***          LAST CARRY FORWARD PERFORMED **:**:** **/**/**
RELEASE HORIZON DATE **/**/**          WAREHOUSE ***
                                         LINE      *****
                                         ITEM      *****
                                         S-NUMBER  *****

      DISPLAY HORIZON          FROM      nnnnnn  TO      nnnnnn

      SEQUENCE                 n
      1 LINE                   aaaA5
      2 ITEM                   aaaaaaaaaaaaA15
      3 PLANNER                nnnnn

      SELECT                   n
      1 ALL SCHEDULES
      2 ALL EXCEPTIONS
      3 EXCEPTIONS INSIDE RELEASE HORIZON
      4 EXCEPTIONS OUTSIDE RELEASE HORIZON

      F02 NEXT ITEM/LINE/PLNR  F19 RETURN TO SELECT  F22 CARRY FORWARD
                               F21 LOT SIZE                F24 END OF JOB

```

### What to do

- To see selected schedules, press **Enter**. Go to display AMQ442.
- To see the next sequential item, line, or planner, use **F02**.
- To begin the lot sizing function, use **F21**.
- To perform the carry forward function, use **F22**.

### Function keys

F02 NEXT ITEM/LINE/PLNR goes to next item, line, or planner based on your Sequence criteria.

F19 RETURN TO SELECT returns to the Select display (AMQ440) so you can select another warehouse.

F21 LOT SIZE creates schedule lots from all individual unreleased schedules within the chosen warehouse and display horizon that meet the selection criteria.

F22 CARRY FORWARD calculates the carry forward quantities.

F24 END OF JOB shows you the menu again, so you can choose another schedule option or end this activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WAREHOUSE (HOUSE).** The warehouse selected on display AMQ440 or the default planning warehouse.

**LAST CARRY FORWARD PERFORMED.** The time and date that the last carry forward function was performed.

The next four fields give you more information about the last carry forward function. They could have been selected from this display or could have run automatically during schedule purge.

**WAREHOUSE (HOUSE).** The warehouse associated with the last carry forward function performed.

**LINE (WKCTR).** The line number associated with the last carry forward function performed.

**ITEM (ITNBR).** The item number associated with the last carry forward function.

**S-NUMBER.** The S-number associated with the last carry forward function performed.

**RELEASE HORIZON DATE (ODUDT).** The date used when selecting exceptions inside the release horizon or exceptions outside the release horizon.

**DISPLAY HORIZON FROM/TO.** Type in the first and last dates for which you want to review schedules.

**SEQUENCE.** Required. Type in one of the following:

- 1 Process all items with the production line specified as the primary line for that item. Only items with records in the Item Line file will be displayed.
- 2 Process all schedules for a specific item.
- 3 Process all schedules for a specific planner.

**LINE (WKCTR) [?].** Type in a line number to select schedule information for items with this line specified as the primary line.

**ITEM (ITNBR) [?].** Type in an item number to select schedule information for a specific item.

**PLANNER (PLANN).** Type in the code of the person responsible for planning and scheduling this finished item.

**SELECT.** Required. Type in one of the following:

- 1 Retrieves all schedules selected on the **Sequence** field.
- 2 Selects all exceptions which have a calculated proposed change value or line hours scheduled greater than line hours available or less than minimum percentage.
- 3 Selects those exceptions that are inside the release horizon.
- 4 Selects those exceptions that are outside the release horizon.

## AMQ442—Enter and Maintain Schedules, Summary by Item (Change)

Use this display to extract and review a summary of production information for an item that is scheduled on one or more production lines. The **MULT SCHED** field identifies which days have multiple schedules. You review and maintain detail information for a specific schedule by entering **1** in the **SEL** field next to the date you are interested in.

This display appears after data is entered and edited on display AMQ441.

```

Date **/**/**          ENTER AND MAINTAIN SCHEDULES          *****  AMQ442  **
                        SUMMARY BY ITEM

SEQUENCE BY ***** *****  PRIMARY LINE *****  PLANNER *****  LOT SIZING  *
WH *** ITEM *****
CARRY FWD *****.***  SMOOTHING CODE  A  SMOOTHING START DATE nnnnnn

      SCHED          REMAINING MULT      PROPOSED      SCHED -LINE HRS-
SEL  DATE          NET DEMAND      SCHED QTY SCHED      CHANGE      HOURS SCHED AVAIL
-   **/**/** * ,***,***.***- * ,***,***.***- * * ,***,***.***- ***,* ***.* ***.*-
      ORIGINAL
B   **/**/** * ,***,***.***- * ,***,***.***- * * ,***,***.***- ***,* ***.* ***.*-
      ORIGINAL
B   **/**/** * ,***,***.***- * ,***,***.***- * * ,***,***.***- ***,* ***.* ***.*-
      ORIGINAL
B   **/**/** * ,***,***.***- * ,***,***.***- * * ,***,***.***- ***,* ***.* ***.*-
      ORIGINAL

      USE ROLL UP/DOWN          F09 DATA QUEUE STATUS          F16 EXTRACT DEMAND NOW
      F02 NEXT ITEM            F12 ADDITIONAL FIELDS          F19 RETURN TO SELECT
      F05 SCHEDULE ADD          F13 USE PROPOSED CHG          F24 END OF JOB
      F06 SELECT ALL            F15 RECALC SCHEDULES
  
```

### What to do

- To see information for the next item, use **F02**.
- To add a schedule, use **F05**. Go to display AMQ44A.
- To select all items, use **F06**.
- To check the status of the data queue, use **F09**. Go to display AMQX31.
- To view both the remaining schedule quantity and original schedule quantity, use **F12**.
- To align schedules to meet net demand, select the schedule dates you want aligned and use **F13**.
- To recalculate the schedule start dates, use **F15**.

- To extract the latest net demand for a specific item from the item's applicable source of demand, use **F16**.
- To return to the Enter and Maintain Schedules (Select) display (AMQ441), use **F19**.
- To lot size a single schedule into multiple schedules (or lots) on the same date and line, use **F21**.
- To see a breakdown of individual schedules for an item, type **1** in the **SEL** field and press **Enter**. Information for model items is shown on display AMQ444. Information for non-model items is shown on display AMQ445.
- To end schedule maintenance, use **F24**.

## Function keys

F02 NEXT ITEM shows the display again with data for the next item that has demand or schedule activity.

F05 SCHEDULE ADD allows you to enter single item schedules for a day or across multiple days for a specific line, item, and date.

F06 SELECT ALL allows you to select all the schedule dates appearing on the display.

F09 DATA QUEUE STATUS shows you display AMQX31.

F12 ADDITIONAL FIELDS toggles to show you the remaining schedule quantity or the original schedule quantity.

F13 USE PROPOSED CHG performs schedule maintenance to update all schedules on the selected dates with proposed changes. The display appears again with the updated information.

F15 RECALC SCHEDULES allows you to recalculate the schedule and operation start dates for the schedules you selected.

F16 EXTRACT DEMAND NOW extracts the current production requirements for this item/warehouse and performs the smoothing function, if appropriate. Display AMQ442 appears again.

F19 RETURN TO SELECT returns to the Select display (AMQ441) so you can select another record.

F24 END OF JOB shows you the menu again, so you can choose another option or end this activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**SEQUENCE BY.** ITEM, LINE, or PLANNER appears depending on the type you selected on display AMQ441.

**PRIMARY LINE (WKCTR).** The production line where the item is usually manufactured.

**PLANNER (PLANN).** The code of the person responsible for planning and scheduling this finished item.

**WH (Warehouse) (HOUSE).** The warehouse selected on display AMQ440 or the default planning warehouse.

**ITEM (ITNBR).** The item number for which the summary data is shown.

**CARRY FWD (CFWD).** The calculated carry forward quantity. This field appears only if you are running a schedule that is part of a production campaign.

**SMOOTHING CODE (SMHCD).** The code specifies if and how smoothing is applied to an item in production.

**Blank** No smoothing.

- 1 REP Schedule Release Horizon plus one workday used to begin smoothing.
- 2 Smoothing begins with the schedule date where the first net demand occurs in the net demand column.

**SMOOTHING START DATE (SMHDT).** Type in a date to override the smoothing code. This date is used to begin smoothing if it is greater than the system date.

**SEL (Select).** Required. This field allows you to select specific schedules for review and maintenance, and to perform a material check. Type in **1** beside each schedule that you want to review and maintain.

**SCHED DATE (ODUDT).** The date the item's schedule is due to be completed.

**NET DEMAND (EQNTY).** The demand quantity for the item for this date since the last extract run. Net demand from COM is calculated by applying inventory against total demand. The field is highlighted if MRP exception codes exist. From MRP, net demand is the sum of planned orders plus scheduled receipts minus schedules proposed from deletion.

**Note:** Net demand has scrap added. Also, in MRP the schedule is netted by scrap quantity, and a planned schedule possibly might be created for scrap.

**REMAINING SCHED QTY (ORQTY).** The quantity of the item remaining to be produced on this date. When you use **F12** the display also shows you the original quantity scheduled.

**ORIGINAL SCHED QTY (ORQTY).** The quantity of the item originally scheduled for production on this date. When you use **F12** the display shows you the remaining quantity scheduled.

**MULT SCHED.** The code that indicates if this date has multiple schedules. The values are \* for Yes and blank for No.

**PROPOSED CHANGE (ORQTY).** The recommended quantity change to the schedule for this date. (Net demand for this date minus quantity scheduled.)

**SCHED HOURS.** The number of line hours allocated to this schedule. Schedule hours includes allowances for the carry forward quantity.

**LINE HOURS SCHED.** The total production hours scheduled on the lines this item is scheduled.

**LINE HOURS AVAIL.** The total hours available on the lines this item is scheduled on a specific date.

**ORIGINAL SCHED QTY (ORQTY).** The total quantity of the item scheduled to be produced on this date. When you use **F12**, the display only shows you the quantity remaining to be produced.

## AMQ44A—Enter and Maintain Schedules (Add)

Use this display to create a single item schedule for a day or across multiple days for a specific line, item, or date.

This display appears after data is entered and edited on display AMQ442.

```

DATE **/**/**          ENTER AND MAINTAIN SCHEDULES   ADD      AMQ44A  **
                          ENTRY

PRIMARY LINE  *****  PLANNER  *****
WH ***  ITEM *****
LOT *,**,***.***  MIN *,**,***.***  MAX *,**,***.***  QTY/ *****.***
CHANGEOVER HOURS  **.*  FLOW TIME **.*.***  ITEM RATE *****.***  P/C  *

SCHEDULE
DATE          NET DEMAND          REMAINING  MULT      PROPOSED  SCHED  -LINE  HOURS-
**/**/**    *,**,***.***-  *,**,***.***-  *  *,**,***.***-  **.*  **.*  **.*
SCHEDULE DATE          nn/nn/nn
PRODUCTION LINE        aaaa5          REVISION  aaaaA6
S-NUMBER               aaaaaaaaaaaaaaaaaa20
SCHEDULE QUANTITY      nnnnnnn.nnn
NUMBER OF DAYS         nn
IN QUANTITY            nnnnnnn.nnn
REFERENCE              aaaaaaaaa10
ALTERNATE ROUTING     aa
CARRY FORWARD OPT     a
RESCHEDULE CODE       n          CONSUME DATE          nn/nn/nn          ACCOUNTING CLASS *

F02 NEXT SCHEDULE DATE  F03 PREVIOUS DISPLAY  F14 SELECT PROCESS  F24 END OF JOB
    
```

### What to do

- To create a schedule for a specific line, item, and date, type in the required information.
- To end schedule add, use **F24**.

### Function keys

F02 NEXT SCHEDULE DATE shows the next schedule date if multiple days were selected on display AMQ442.

F03 PREVIOUS DISPLAY shows display AMQ442 again.

F14 SELECT PROCESS appears only if EPDM is activated and shows the Select Item Process display (AMVTIP01) so you can select an effective process for this item. If you do not select a particular process, the system will default to the primary process that is current for the revision on the order's start date.

If the warehouse of the order is associated with a site, order entry will automatically assign the primary process that is effective for the item revision based on the order's start date. You can only have one primary process effective at a time for an item revision; however, you may have alternate processes that are available. If you want to choose another process, use **F14** before you press **Enter** on this display. The Select Item Process display will show you the primary effective process and any alternate processes that are effective as of the order's start date. It is described at the end of this section.

F24 END JOB shows you the menu again, so you can choose another option or end this activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**PRIMARY LINE (WKCTR)**. The production line where the item is usually manufactured.

**PLANNER (PLANN)**. The code of the person responsible for planning and scheduling this finished item.

**WH (Warehouse) (HOUSE)**. The warehouse selected on display AMQ440 or the default planning warehouse.

**ITEM (ITNBR)**. The item number for which the summary data is shown.

**SCHED START OPTION**. Code used to determine where in the production cycle the first schedule of the day is positioned.

- 1 This day's production will begin with the Changeover Time for this schedule.
- 2 This day's production will begin with the Flow Time for this schedule. (Changeover will be scheduled on the previous day.)
- 3 This day's production will begin with the Cycle Time for the item. (Changeover and Flow Time will be scheduled on the previous day.) This is the default value.

**LOT**. The target quantity, in pieces, for schedules created through lot sizing.

**MIN (MINQY)**. The least allowable quantity, in pieces, for a schedule created by lot sizing.

**MAX (MAXQY)**. The greatest allowable quantity, in pieces, for a schedule created by lot sizing.

**QTY/ (Quantity Per) (CONDS)**. The description of a standard container and quantity of the finished item that can be placed in the container.



**CHANGEOVER HOURS (CHGOV).** Amount of time needed to set up the production line to begin producing the first item in the schedule.

**FLOW TIME (FLWTIM).** Elapsed time (in hours) required to produce one unit of a scheduled item on a continuously-operating production line.

**ITEM RATE (PCSHR).** Rate at which items are produced on the production line, stated in either pieces per hour or cycle time (time between pieces coming off the line).

**P/C (PCYYFL).** Code indicating the contents of the item rate field:

**C** Item rate is expressed as cycle time between pieces.

**P** Item rate is expressed as pieces per hour.

The next eight fields appear only if you selected a date on display AMQ442:

**SCHEDULE DATE (ODUDT).** The date the item's schedule is due to be completed.

**NET DEMAND (EQNTY).** The demand quantity for the item for this date since the last extract run. Net demand is calculated by applying inventory against total demand.

**Note:** Net demand has scrap added. Also, in MRP the schedule is netted by scrap quantity, and a planned schedule possibly could be created for scrap

**REMAINING SCHD QTY (ORQTY).** The quantity of the item remaining to be produced on this date. When you use **F12** the display also shows you the original schedule quantity.

**MULT SCHD.** The code that indicates if this date has multiple schedules. The values are \* for Yes and blank for No.

**PROPOSED CHANGE (ORQTY).** The recommended quantity change to the schedule for this date. (Net demand for this date minus schedule quantity.)

**SCHED HOURS.** The number of line hours allocated to this schedule. Schedule hours includes allowances for the carry forward quantity.

**LINE HOURS SCHED.** A summary of the line hours scheduled for this item across all lines where this item is scheduled for the day.

**LINE HOURS AVAIL.** The difference between line hours of capacity and the apportioned line hours scheduled for the day.

**SCHEDULE DATE (ODUDT).** Type in the date the item's schedule is due to be completed. If you did not select a date on the previous display, this field becomes enterable.

**PRODUCTION LINE [?].** Type in the production line to which you want to schedule the work. This field defaults to the primary line value in the ITEMPL file.

**REVISION (REVS1) [?].** This field appears only if EPDM is activated. If smoothing is not activated, accept the default of \*CUR to see the current revision based on the start date, or type a revision number to see a specific revision.

**S-NUMBER (SNMBR) [?]**. Type in the features and options code for the item. S-number appears if you chose feature/options support during EPDM/PDM tailoring.

**SCHEDULE QUANTITY (ORQTY)**. Type in the quantity of the item to be scheduled for each day.

**NUMBER OF DAYS**. Type in the number of days over which the schedule is spread. This is used with **DATE** to determine the first date of the schedule and overlays schedules if they already exist.

**IN QUANTITY (ORQTY)**. Type in the largest quantity that you want produced by the schedule. If you are limited by the supply of a critical component, enter the number of scheduled items that can be produced with the component's available stock.

**SCHEDULE QUANTITY** is calculated by multiplying **IN QUANTITY** by **CURRENT CUMULATIVE YIELD**. If both **SCHEDULE QUANTITY** and **IN QUANTITY** are entered, **IN QUANTITY** is ignored.

**REFERENCE (REFNO)**. Type in the user-defined code used to provide additional information.

**ALTERNATE ROUTING (ARCOD)**. Type in the code that selects alternate operations for the item. This code is sometimes called a Select Code.

**CARRY FORWARD OPT (Carry forward option)**. The code that identifies whether this schedule uses carry forward processing:

- 1 Schedule is not part of a production campaign.
- 2 Schedule is part of a production campaign.
- 3 This is the last schedule in a production campaign.

**RESCHEDULE CODE**. Type in the code used to indicate whether or not orders for the item (by item/warehouse) can be rescheduled automatically by the system.

- 0 Default to item reschedule code. This is the default.
- 1 Cannot be rescheduled automatically.
- 2 Can be scheduled out.
- 3 Can be scheduled in.
- 4 Can be scheduled both out and in.

**CONSUME DATE**. The date at which to begin consumption of planned orders in MRP.

**ACCOUNTING CLASS (ORAC)**. Class, defined by your company, to group or classify orders for accounting purposes.

## AMQ444—Enter and Maintain Schedules, Summary by S-Number (Change)

Use this display to show a summary of item demand and schedule quantity by S-number for a specific model item and date. You also can view detailed information about a schedule by selecting a particular schedule and pressing **Enter**.

This display appears when you select a schedule on display AMQ442 and the item is a model item number.

DATE **/**/**		ENTER AND MAINTAIN SCHEDULES		CHANGE	AMQ444 **
SUMMARY BY S-NUMBER					
SEQUENCE BY ITEM		PRIMARY LINE *****		PLANNER *****	
WH *** ITEM *****					
CARRY FWD *****		SMOOTHING CODE A		SMOOTHING START DATE **/**/**	
SCHED DATE **/**/**					
SEL	S-NUMBER	NET DEMAND	REMAINING SCHED QTY	PROPOSED CHANGE	
A	*****	*, ***, ***, ****-	*, ***, ***, ****-	*, ***, ***, ****-	
		ORIGINAL	*, ***, ***, ****-		
A	*****	*, ***, ***, ****-	*, ***, ***, ****-	*, ***, ***, ****-	
		ORIGINAL	*, ***, ***, ****-		
A	*****	*, ***, ***, ****-	*, ***, ***, ****-	*, ***, ***, ****-	
		ORIGINAL	*, ***, ***, ****-		
A	*****	*, ***, ***, ****-	*, ***, ***, ****-	*, ***, ***, ****-	
		ORIGINAL	*, ***, ***, ****-		
A	*****	*, ***, ***, ****-	*, ***, ***, ****-	*, ***, ***, ****-	
		ORIGINAL	*, ***, ***, ****-		
A	*****	*, ***, ***, ****-	*, ***, ***, ****-	*, ***, ***, ****-	
		ORIGINAL	*, ***, ***, ****-		
USE ROLL UP/DOWN		F12 ADDITIONAL FIELDS	F19 RETURN TO SELECT		
		F13 USE PROPOSED CHG	F24 END OF JOB		

### What to do

- To see schedule detail, type **1** in the **SEL** field and press **Enter**. Go to display AMQ445. If no more records were selected, go to display AMQ442.
- To update schedule quantity changes, use **F13**.
- To return to the Enter and Maintain Schedules (Select) display (AMQ441), use **F19**.

### Function keys

F12 ADDITIONAL FIELDS toggles between original schedule quantity and remaining schedule quantity.

F13 USE PROPOSED CHG updates the schedules with the recommended change quantities. The display appears again with the updated information.

F19 RETURN TO SELECT returns to the Select display (AMQ441) so you can select another record.

F24 END OF JOB shows you the menu again, so you can choose another option or end this activity.

## Fields

**SEQUENCE BY.** ITEM, LINE, or PLANNER appears depending on the type you selected.

**PRIMARY LINE (WKCTR).** The production line where the item is usually manufactured.

**PLANNER (PLANN).** The code of the person responsible for planning replenishment for manufactured and purchased material.

**WH (Warehouse) (HOUSE).** The warehouse selected on display AMQ440 or the default planning warehouse.

**ITEM (ITNBR).** The item number for which the summary data is shown.

**CARRY FWD (Carry Forward Quantity) (CFWRD).** The calculated carry forward quantity. (Schedule quantity minus quantity completed from previous day.)

**SMOOTHING CODE (SMHCD).** The code specifies if and how smoothing is applied to an item in production. The field can be overridden by the smoothing start date.

**blank** No smoothing  
**1** System date plus one workday used to begin smoothing  
**2** First net demand date used to begin smoothing

**SMOOTHING START DATE (SMHDT).** An override to the smoothing code. This date is used if it is greater than the system date.

**SCHED DATE (ODUDT).** The date the item's schedule is due to be completed.

**SEL (Select) (SELWK).** Type in **1** beside each S-number that you want to review.

**S-NUMBER (SNMBR).** The features and options code for the item. S-number appears if you chose feature/options support during EPDM/PDM tailoring.

**NET DEMAND (EQNTY).** The total demand quantity for this date for the item and S-number since the last extract run. Net demand from COM is calculated by applying inventory against total demand. This field is highlighted if MRP exception codes exist. From MRP, net demand is the sum of planned orders plus scheduled receipts minus schedules proposed for deletion.

**REMAINING SCHED QTY (ORQTY).** The quantity of the item remaining to be produced on this date. When you use **F12** the display also shows you the original quantity scheduled.

**ORIGINAL SCHED QTY (ORQTY).** The quantity of the item originally scheduled to be produced on this date. When you use **F12**, you can see the remaining quantity scheduled.

**PROPOSED CHANGE.** The recommended quantity change to the schedule for this date. (Net demand for this date minus quantity scheduled.)

## AMQ445—Enter and Maintain Schedules, Detail (Change)

Use this display to enter schedules and assign schedules over multiple production lines for a specific schedule date. It also allows you to sequence schedules, check component shortages and line utilization, and change the schedule quantity field.

This display appears after you enter a selection on display AMQ442 if the item is not a model item. For a model item it appears after a selection on display AMQ444.

```

DATE **/**/**          ENTER AND MAINTAIN SCHEDULES          CHANGE          AMQ445  **
                        DETAIL

SEQUENCE BY ***** PRIMARY LINE ***** PLANNER *****
WH *** ITEM ***** LEAD TIME ***.*
LOT *,***,**.* MIN *,***,**.* MAX *,***,**.* QTY/ ***** ***,**.*

SCHED DATE NET DEMAND REMAINING PROPOSED CHG S-NUMBER
**/**/** *,***,**.* *,***,**.* *,***,**.* *,***,**.* *****

View 1 of 3
SEL DATE LINE REV QUANTITY SCHED --- LINE HRS ---
AR SCHEDULE IN REFERENCE HOURS SCHED AVAIL V
-
nnnnnn aaaA5 aaaaA6 nnnnnnn.nnn nnnnnnn.nnn aaaaaaaA10 ***.* ***.* ***.* ***
.*
nnnnnn aaaA5 aaaaA6 nnnnnnn.nnn nnnnnnn.nnn aaaaaaaA10 ***.* ***.* ***.* ***
.*
nnnnnn aaaA5 aaaaA6 nnnnnnn.nnn nnnnnnn.nnn aaaaaaaA10 ***.* ***.* ***.* ***
.*
nnnnnn aaaA5 aaaaA6 nnnnnnn.nnn nnnnnnn.nnn aaaaaaaA10 ***.* ***.* ***.* ***
.*
nnnnnn aaaA5 aaaaA6 nnnnnnn.nnn nnnnnnn.nnn aaaaaaaA10 ***.* ***.* ***.* ***
.*

F05 SCHEDULE ADD          F09 MATERIAL CHECK          F18 REFRESH
  
```

```

View 2 of 3
SEL DATE LINE ORIGINAL SCHED ALT -- CARRY FWD -- RESCH
SCHED QTY REVISION NUMBER STS RTG SAC OPT QUANTITY CODE
-
nnnnnn aaaA5 nnnnnnn.nnn aaaaA6 nnnnnnn nn aa nnn A nnnnnnn.nnn A
-
nnnnnn aaaA5 nnnnnnn.nnn aaaaA6 nnnnnnn nn aa nnn A nnnnnnn.nnn A
-
nnnnnn aaaA5 nnnnnnn.nnn aaaaA6 nnnnnnn nn aa nnn A nnnnnnn.nnn A

ROLL UP/DOWN          F05 SCHEDULE ADD          F09 MATERIAL CHECK
ROLL UP/DOWN          F10 SOURCE OF DEMAND          F18 REFRESH
F03 PREV VIEW          F07 SEQUENCE SCHEDULES          F13 USE PROPOSED CHG          F19 RETURN
F14 SELECT PROCESS          F24 END JOB
+
  
```

```

View 3 of 3
SEL DATE LINE ORIGINAL SCHED MRP MRP DUE RESCH
SCHED QTY NUMBER STS EXCEPTION DATE CODE
-
nnnnnn aaaA5 nnnnnnn.nnn nnnnnnn nn nn nnnnnn nnnnnn A
-
nnnnnn aaaA5 nnnnnnn.nnn nnnnnnn nn nn nnnnnn nnnnnn A
-
nnnnnn aaaA5 nnnnnnn.nnn nnnnnnn nn nn nnnnnn nnnnnn A

ROLL UP/DOWN          F07 SEQUENCE SCHEDULES          F10 SOURCE OF DEMAND          F18 REFRESH
F03 PREV VIEW          F13 USE PROPOSED CHG          F19 RETURN
F05 SCHEDULE ADD          F09 MATERIAL CHECK          F24 END JOB
+
  
```

### What to do

- To sequence schedules, type **1** in the **SEL** field and use **F07**. Go to display AMQ441 under option 5, Sequence Schedules.

- To see the next view of information, use **F02**.
- To see the previous view of information, use **F03**.
- To create a single item schedule for a day or across multiple days, use **F05**.
- To perform a material check, type **1** in the **SEL** field and use **F09**. Go to display AMQ4L2.
- To see the source of demand, type **1** in the **SEL** field and use **F10**. Go to display AMM771.
- To update schedule quantity changes, use **F13**.

**Note:** When you press **Enter** after entering changes, message AM-9155 RECORDS UPDATED OR ADDED appears and the body of the display shows the effect of the changes you entered. Press **Enter** to continue with the next selected record. If no more selections are made, the previous Summary display (either AMQ442 or AMQ444) appears again.

If you enter a different date from the one in the header and press **Enter**, message AM-9155 appears and the body of the display shows only the records for the date in the header. The record for the different date is updated but not shown. To see this date, you must return to the Summary display (AMQ442) and select that date.

- To cancel what you typed in on this display, use **F18**.
- To return to the Enter and Maintain Schedules (Select) display (AMQ441), use **F19**.

## Function keys

F02 NEXT VIEW shows you the next page of schedules.

F03 PREV VIEW shows you the previous page of schedules.

F05 SCHEDULE ADD shows you display AMQ44A to allow you to create a schedule.

F07 SEQUENCE SCHEDULES shows you the Sequence Schedules display (AMQ452) to allow you to determine the order in which the schedules are built.

F09 MATERIAL CHECK shows you the Component Material Check display (AMQ4L2) to allow you to check the schedules for component shortages.

F10 SOURCE OF DEMAND shows you the Source of Demand display (AMM771) to allow you to check the sources of demand for this schedule.

F13 USE PROPOSED CHG updates the schedules with the recommended change quantities. This display (AMQ445) appears again with the updated information.

F18 REFRESH DISPLAY shows the display again without any changes made since the last time you used a function key or **Enter**.

F19 RETURN TO SELECT returns to the Select display (AMQ441) so you can select another record.

F24 END OF JOB shows you the menu again, so you can choose another schedule option or end this activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**SEQUENCE BY.** ITEM, LINE, or PLANNER appears depending on the type you selected.

**PRIMARY LINE (WKCTR).** The production line where the item is usually manufactured.

**PLANNER (PLANN).** The code of the person responsible for planning replenishment for manufactured and purchased material.

**WH (Warehouse) (HOUSE).** The warehouse selected on display AMQ440 or the default planning warehouse.

**ITEM (ITNBR).** The item number selected on display AMQ441.

**LEAD TIME (LTMAN).** The manufacturing lead time in days.

**LOT (SLTQIL).** The target quantity, in pieces, for schedules created through lot sizing.

**MIN (SMNQIL).** The least allowable quantity, in pieces, for a schedule created by lot sizing.

**MAX (SMXQIL).** The greatest allowable quantity, in pieces, for a schedule created by lot sizing.

**QTY/ (Quantity Per) (CONDS).** The description of a standard container and quantity of the finished item that can be placed in the container.

**SCHED DATE (ODUDT).** The date the item's schedule is due to be completed.

**NET DEMAND (EQNTY).** The total demand quantity for this date for the item and S-number since the last extract run. Net demand from COM is calculated by applying inventory against total demand. This field is highlighted if MRP exception codes exist. From MRP, net demand is the sum of planned orders plus scheduled receipts minus schedules proposed for deletion.

**REMAINING SCHED QTY (ORQTY).** The quantity of the item remaining to be produced on this date. When you use **F12**, the display also shows you the original schedule quantity.

**ORIGINAL SCHED QTY (ORQTY).** The total quantity of the item scheduled for production on this date.

**PROPOSED CHG.** The recommended quantity change to the schedule for this date. (Net demand for this date minus quantity scheduled.)

**S-NUMBER (SNMBR).** The features and options code for the item. S-number appears if you chose feature/options support during EPDM/PDM tailoring.

**SEL (Select).** Type in **1** and use **F07** or **F09** to select specific schedules for review.

**DATE.** Required. Type in the date the schedule is due to be completed.

**LINE (WKCTR) [?].** Required. Type in the production line on which you want to schedule the work.

**ORIGINAL SCHED QTY (ORQTY).** Type in the quantity of the item to schedule into production.

**REVISION (WSRVAD) .** This field appears only if EPDM is activated. Accept the default of \*ALL to see all revisions. Type \*CUR to see the current revision based on the current system. Type a revision number instead of a schedule number to see a specific revision.

**IN QUANTITY.** Type in the quantity to be entered into the process.

**REFERENCE (REFNO).** Type in the user-defined code used to provide additional information.

**SCHED HOURS.** The number of line hours allocated to this schedule. Changeover hours plus (flow time hours minus cycle time) plus (the sum of schedule quantity and carry forward quantity, multiplied by the cycle time) minus overlap hours.

**LINE HOURS SCHED.** The total line hours of all items scheduled on this line for a specific date.

**LINE HOURS CAP.** The daily capacity of hours available for this production line.

**LINE HOURS AVAIL.** The difference between the line's capacity and its apportioned line hours for the day.

**SCHED NUMBER (ORDNO).** The number of the associated schedule.

**STS (STATUS) (OSTAT).** The code that indicates the status of the schedule.

<b>00</b>	Planned order/schedule not released
<b>10</b>	Order/schedule released, not started
<b>40</b>	Activity reported (schedule primed)
<b>55</b>	Order/schedule complete

**ALT RTG (ARCOD).** Type in the code that selects an alternate operation for the item.

**SAC.** Class, defined by your company, to group or classify orders for accounting purposes.

**CARRY FORWARD OPT (Carry forward option).** The code that identifies whether this schedule uses carry forward processing:

<b>1</b>	Schedule is not part of a production campaign.
<b>2</b>	Schedule is part of a production campaign.
<b>3</b>	This is the last schedule in a production campaign.

**CARRY FWD QUANTITY (CFWRD).** The calculated carry forward quantity (Schedule quantity minus quantity completed from previous schedules).



**RESCH CODE (ORRC).** Type in the code used to indicate whether or not order/schedules for the item (by item/warehouse) can be rescheduled automatically by the system.

- 0 Default to item reschedule code. This is the default.
- 1 Cannot be rescheduled automatically.
- 2 Can be scheduled out.
- 3 Can be scheduled in.
- 4 Can be scheduled both out and in.

**MRP EXCEPTION.** The planning exception (or recommendation) for this order, if any, determined during the last planning run.

For a complete list of exceptions, see “Planning Exceptions” in the *Material Requirements Planning User’s Guide*.

**MRP DUE DATE.** The date the order/schedule is required. Before planner action (for released orders and firm planned orders), this is the date of the order/schedule as of the last planning run. For planned order/schedules, this is the date the order/schedule is required as determined by the last planning run. After planner action (in all cases), it is the date indicated by the planner.

## AMQ4L2—Component Material Check (Review)

Use this display to check the availability of components for a specific schedule. Availability is based on each component’s required date.

This display appears when you use **F09 MATERIAL CHECK** on display AMQ445.

```

DATE **/**/
**
          COMPONENT MATERIAL CHECK          REVIEW    AMQ4L2  **

SCHED NBR ***** SCHED DATE **/**/** LINE ***** S-NBR *****
WH ***  ITEM ***** REVISION *****

REM SCHED QTY  *,**,*.*.*-

          COMPONENTS          QTY REQ          ONHAND          AVAILABLE
          SEQ      REQ DATE      ALLOCATED      ON ORDER
*****
***** **/**/** ***** ** ***** **
***** **/**/** ***** ** ***** **
***** **/**/** ***** ** ***** **
***** **/**/** ***** ** ***** **
***** **/**/** ***** ** ***** **
***** **/**/** ***** ** ***** **
***** **/**/** ***** ** ***** **
***** **/**/** ***** ** ***** **
***** **/**/** ***** ** ***** **

HIGHLIGHTED AVAILABLE QUANTITIES SHOW SHORTAGE

                                USE ROLL UP/DOWN      F08 SHOW ALL COMPONENTS
                                F03 PREVIOUS DISPLAY    F12 ADDITIONAL FIELDS
                                F24 END OF JOB

+

```

### What to do

- To return to the **Enter** and Maintain Schedules Detail (Change) display (AMQ445), use **F03**. Go to display AMQ445.
- To see all of the components for a selected schedule, use **F08**. To see shortages for a selected schedule, use **F08** again.

- To see additional fields, use **F12**. To return to the original display format, use **F12** again.

## Function keys

F03 PREVIOUS DISPLAY shows you the previous display (AMQ445).

F08 SHOW SHORTAGES shows you the shortages from the selected schedules. Using F08 a second time changes the description to **SHOW COMPONENTS**, which shows all of the components for the selected schedules.

F12 ADDITIONAL FIELDS allows you to review the second line of fields on the display. Using **F12** a second time returns you to the original format of one line of fields.

F24 END OF JOB shows you the menu again, so you can choose another schedule option or end this activity.

## Fields

**SCHED NBR (ORDNO)**. The associated schedule number.

**SCHED DATE (ODUPT)**. The date the item's schedule is due to be completed.

**LINE (WKCTR)**. The production line where the item is usually manufactured.

**WH (Warehouse) (HOUSE)**. The warehouse selected on display AMQ440 or the default planning warehouse.

**ITEM (ITNBR)**. The item number selected on display AMQ441. The description of the item also appears.

**REVISION**. This field appears only if EPDM is activated. The revision number associated with this item.

**REM. SCHED QTY (ORQTY)**. The quantity of the item remaining to be produced on this date (scheduled quantities less their receipts).

**COMPONENTS (ITNBR)**. The material used in the production of the scheduled item and the operations shown.

**QTY REQ (ORQTY)**. The quantity of the component required to produce the schedule.

**ONHAND (ORQTY)**. The quantity currently in inventory for this component.

**AVAILABLE (ORQTY)**. The net quantity not yet committed to a production schedule. (Onhand plus on order minus allocated.)

**SEQ**. The user-defined sequence number used to uniquely identify the component.

**REQ DATE**. The date the component is required for production.

**ALLOCATED (ORQTY).** The total quantity of this component allocated through the required date.

**ON ORDER (ORQTY).** The total quantity of this component scheduled or on order through the required date.

## AMVTIP01—Select Item Process

Use this display to select an effective process for the item associated with the order you entered on display AMQ44A.

This display appears when EPDM is activated and you select **F14 SELECT PROCESS** on the Enter and Maintain Schedules - Add display (AMQ44A).

```

AMVTIP01                Select Item Process      DATE **/**/** *****
Site . : ***            *****
Item . : *****       *****
Rev . : *****        Effective...  **/**/**  **/**/**

Position to . . . . aaaaaaaaaaaaaaaaaaaaaaaaaaaaaaaaaA40

Type option: then press ENTER.
  1=Select

                                View 1 of 2
Opt  Pri  Eff From  Eff To  Description
n    *    **/**/** **/**/** *****
n    *    **/**/** **/**/** *****
n    *    **/**/** **/**/** *****
n    *    **/**/** **/**/** *****
n    *    **/**/** **/**/** *****
n    *    **/**/** **/**/** *****
n    *    **/**/** **/**/** *****
n    *    **/**/** **/**/** *****

F3=Exit   F7=Backward  F8=Forward   F12=Cancel
          F20=Right
  
```

```

                                View 2 of 2
Opt  Pri  Eff From  Eff To  Alt BOM ID  Routing ID  Version
n    *    **/**/** **/**/** *****  *****  *****
n    *    **/**/** **/**/** *****  *****  *****
n    *    **/**/** **/**/** *****  *****  *****
n    *    **/**/** **/**/** *****  *****  *****
n    *    **/**/** **/**/** *****  *****  *****
n    *    **/**/** **/**/** *****  *****  *****
n    *    **/**/** **/**/** *****  *****  *****

F3=Exit   F7=Backward  F8=Forward   F12=Cancel
F19=Left
  
```

### What to do

Type **1** in the **Opt** field beside the process you want to assign to the item and press **Enter**. Use the **Position to** field to move to a specific item process.



## Function keys

F12=Return causes the display from which you requested demand information to appear again.

F24=End of job ends processing and the menu where you started this task appears again.

## Fields

**Order.** The order number for the associated data.

**Item.** The item number for the associated data.

**Sequence.** The sequence number for the associated data.

**Warehouse.** The planning warehouse for the associated data.

**Release.** Sequential number assigned by the system to identify individual releases on a customer order line item.

**Source of demand.** This field displays the customer order or other top level requirement that generated this manufacturing order or purchase order item. For PC&C, the value +++ indicated that there are more sources of demand for this order than were tracked, due to selected planning run execution options. If the requirement is a customer order, the following fields appear:

**Order:** The customer order number.

**Line:** Line item sequence associated with shipment release detail information.

**Release:** Date customer manufacturing is due.

Possible values follow. MSSR refers to the Master Schedule Source Planning code.

**BLENDED** The larger of forecast and customer requirements (MSSR=C)

**CUSONLY** Combined customer orders (MSSR=C)

**Cxxxxxx** Customer order number ((MSSR=D or E). The customer order appears in the format of 01-CO-nnnnnnnn.

**FORCAST** Forecast quantity (MSSR=F)

**GENDMND** Generated component quantity based on parent planned orders (MSSR not D or E)

**MANUAL** Manually entered demand. Source of demand is optional at time of entry (MSSR=M)

**M FCST** Manual forecast

**M HELD** Manual held requirement

**M REQMT** Manual requirement

**MSAFETY** Safety quantity (MSSR=D or E)

**Mxxxxxx** Manufacturing order number

**NEG QOH** Negative quantity on hand

- P FCST** Propagated forecast
- P REQMT** Propagated requirement
- PRODPLN** Production planned quantity (MSSR=P)
- Sxxxxxx** Repetitive Manufacturing order, allocated quantity
- XS FCST** Forecast quantity in excess of customer requirements (MSSR=D)

**Demand item.** The top level source of demand for this component.

**Due date.** The due date of the top level source of demand.

**Quantity required.** The quantity of this item that is required.

## AMQX31—Data Queue Transaction Status (Inquiry)

Use this display to check the status of the data transaction queue.

This display appears when you select **F09 DATA QUEUE STATUS** on display AMQ442 or AMQ452.

```

DATE **/**/**          *****          INQUIRY  AMQX31  **
                        DATA QUEUE TRANSACTION STATUS

DATA QUEUE *****          STATUS *****          JOB NAME *****
*****          *****          JOB NUMBER *****

  TRAN          ITEM          SCHED          SCHED
DATE          TIME  WS  USER ID  TR  WH  LINE  S-NUMBER  DATE  NBR
**/**/** **:**:** ** ***** ** ** ***** ***** **/**/** *****
*****
**/**/** **:**:** ** ***** ** ** ***** ***** **/**/** *****
*****
**/**/** **:**:** ** ***** ** ** ***** ***** **/**/** *****
*****
**/**/** **:**:** ** ***** ** ** ***** ***** **/**/** *****
*****
**/**/** **:**:** ** ***** ** ** ***** ***** **/**/** *****
*****
*****
                        USE ROLL UP/DOWN          F12 ADDITIONAL FIELDS
                                                           F18 REFRESH DISPLAY
                                                           +

```

### What to do

- To see additional fields, use **F12**. To return to the original display format, use **F12** again.
- To exit this display, press **Enter**. Go to display AMQ442.

### Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of locations.

F12 ADDITIONAL FIELDS allows you to review any associated S-numbers for items. Using **F12** a second time returns you to the original format. This key appears if you chose features/options support during PDM/EPDM tailoring.

F18 REFRESH DISPLAY shows the display again with the current status of the transaction data queue.

## Fields

**DATA QUEUE (UJDQN/UJDSC).** The name and description of the data queue.

**STATUS (UJCST).** The current status (ACTIVE, HELD, or ENDED) of the unattached job.

**JOB NAME (UJPGM).** The name assigned to the job.

**JOB NUMBER (UJNBR).** The number assigned to the job.

**TRAN DATE (UPDDT).** The date the transaction was submitted to the data queue.

**TIME (UPDTM).** The time the transaction was submitted to the data queue.

**WS (WKSID).** The ID of the submitting work station.

**USER ID (USERN).** The code assigned to the person who entered the transaction.

**TR (TCODE).** The code of the transaction.

**RM** Schedule receipts

**RO** Operation reporting

**SM** Schedule scrap

**01** Recalculate Cumulative Yield/Dates. This code indicates maintenance to a schedule was performed using Release Schedule Maintenance on the AMQM50 menu

**02** Recalculate Quantities. This code indicates maintenance to a schedule was performed using either Sequence Schedule or Enter and Maintain Schedule on the AMQM40 menu.

**WH (Warehouse) (HOUSE).** The warehouse from which components are issued and the finished items are received.

**LINE (PLINE).** The production line selected from the previous display.

**ITEM (FITEM).** The number and description of the item selected from the previous display.

**S-NUMBER (SNMBR).** The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**SCHED DATE (ODUDT).** The date the item's schedule is due to be completed.

**SCHED NBR (ORDNO).** The control number assigned by the system to each schedule in the data base.

---

## Option 5. Sequence Schedules (AMQM40)

Use this option to change the order in which schedules are produced on a production line for a specified date. This option also allows you to run more than one schedule for a production line per day.

The basic steps to sequence schedules follow each display.

### AMQ451—Sequence Schedules (Select)

Use this display to select the order in which schedules are to be completed.

This display appears when you select option 5 on menu AMQM40.

DATE **/**/**	SEQUENCE SCHEDULES	SELECT	AMQ451 **
	WAREHOUSE aa3		
	LINE aaaA5		
	SCHEDULE DATE nnnnnn		
		F24 END OF JOB	+

#### What to do

To select schedules to sequence, type in the information you need and press **Enter**. Go to display AMQ452.

#### Function keys

F24 END OF JOB shows you the REP Schedule Management menu (AMQM40) again, so you can choose another schedule option or end this activity.

#### Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WAREHOUSE (FITWHW)**. Type in the warehouse you want to review.



**LINE (PLINE) [?]**. Type in the production line you want to review.

**SCHEDULE DATE (ODUDT)**. Type in the due date of the schedules you want to sequence.

## AMQ452—Sequence Schedules (Change)

Use this display to determine the order in which schedules are to be completed. You can change the schedule quantity, line load (schedule hours), and schedule length.

This display appears after you enter data on display AMQ451 or when you use **F07 SEQUENCE SCHEDULES** on display AMQ445.

```

DATE **/**/**                SEQUENCE SCHEDULES                CHANGE        AMQ452  **
LINE *****                *****
SCHEDULE DATE **/**/** LINE SCHED HOURS ***.* VARIANCE ***.* **.* **.* **.*
-----
WH ITEM          RUN CHG-    ORIGINAL    OVER-    SCHED
SCHED NBR REFERENCE SEQ  OVER  FLOW TIME  ITEM RATE  SCHED QTY  LAP  HOURS
*** ***** nnn nn.n nnn.nnnnn nnnnn.nnnnn nnnnnnn.nnn nnn.n nnnn.n
***** ***** nnn nn.n nnn.nnnnn nnnnn.nnnnn nnnnnnn.nnn nnn.n nnnn.n
***** ***** ***** ***** ** * *****
** LAST SCHEDULE PRIOR DAY ***
-----
*** ***** nnn nn.n nnn.nnnnn nnnnn.nnnnn nnnnnnn.nnn nnn.n nnnn.n
***** ***** ***** ***** ** * *****
*** ***** nnn nn.n nnn.nnnnn nnnnn.nnnnn nnnnnnn.nnn nnn.n nnnn.n
***** ***** ***** ***** ** * *****
*** ***** nnn nn.n nnn.nnnnn nnnnn.nnnnn nnnnnnn.nnn nnn.n nnnn.n
***** ***** ***** ***** ** * *****
***** ***** ***** ***** ** * *****

                F12 ADDITIONAL FIELDS
                F15 RECALC SCHEDULES
USE ROLL UP/DOWN                F09 DATA QUEUE STATUS                F24 END OF JOB
F03 PREVIOUS DISPLAY

```

### What to do

- To sequence the schedules, press **Enter**.
- To return to the Sequence Schedules (Select) display (AMQ451), use **F03**. Go to display AMQ451.
- To return to the Enter and Maintain Schedules (Select) display (AMQ445), use **F03** and go back to option 4 (Enter and Maintain Schedules), AMQ444.
- To see the status of the data queue, use **F09**. Go to display AMQX31.
- To see additional fields, use **F12**. To return to the original display format, use **F12** again.
- To recalculate the start dates for the selected schedules, use **F15**.

### Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of items.

F03 PREVIOUS DISPLAY returns to the select display (AMQ451) if sequence schedules was called from option 5 of the Schedule Management menu (AMQM40). If

sequence schedules was called from Enter and Maintain Schedules, this function key returns to display AMQ445.

F09 DATA QUEUE STATUS shows you display AMQX31.

F12 ADDITIONAL FIELDS allows you to review the second line of fields on the display. Using **F12** a second time returns you to the original format of one line of fields.

F15 RECALC SCHEDULES allows you to recalculate the schedule start dates and operation start dates for the schedules you selected.

F24 END OF JOB shows you the Schedule Management menu (AMQM40) again, if called from that menu, so you can choose another schedule option or end this activity. If called from Enter and Maintain Schedules, this function key shows you AMQ445.

## Fields

**LINE (PLINE).** The production line selected on the previous display.

**SCHEDULE DATE (ODUDT).** The date the item's schedule is due to be completed.

**LINE HOURS SCHED.** The total production hours of all items for this line for a specific date.

**AVAIL.** The difference between the line's capacity and its apportioned line hours for the day.

**SHIFT HOURS.** The number of hours each shift works on this line.

**WH (Warehouse) (HOUSE).** The warehouse from which components are issued and the finished items are received.

**ITEM (FITEM).** The number of the item to be produced on this schedule.

**RUN SEQ (RUNSQ).** Type in the order in which the schedules are to be run on the production line. (Items are listed by item within schedule group.)

**CHGOVER (CHGOV).** Type in the time (in hours) required to set up a production line in order to begin producing the first item of the schedule.

**FLOW TIME (FLWTM).** Type in the elapsed time (in hours) required to produce one unit of a scheduled item on a continuously-operating production line.

**ITEM RATE (PCHRS).** Type in either pieces per hour, or cycle time for the production line/end item combination, as indicated by P/C code field.

**ORIGINAL SCHED QTY.** Type in the quantity of this item scheduled for production on this date. If the quantity in this field does not meet your production goals and constraints, you can change the quantity.

**OVERLAP (OVLWK).** Type in the lesser of the two calculations: this schedule's changeover time plus flow time minus cycle time, or the previous schedule's flow time minus cycle time.

**SCHED HOURS.** The number of hours allocated to this schedule. Changeover hours plus (flow time hours minus cycle time) plus (the sum of schedule quantity and carry forward quantity multiplied by the cycle time) minus overlap hours.

**SCHED NBR (ORDNO).** The schedule number associated with this item.

**REFERENCE (ORDNO).** The user-defined reference number associated with this schedule.

**REVISION (ITRV).** This field appears only if EPDM is activated. The revision identifier associated with this item.

**GROUP (SCHGP).** A user-defined code used to sequence schedules. It can also identify items that have similar manufacturing characteristics. Schedules are sorted by run sequence and schedule group.

**ST (OSTAT).** The current status of this schedule.

<b>00</b>	Planned order/schedule not released
<b>10</b>	Order/schedule released, not started
<b>40</b>	Activity reported (schedule primed)
<b>55</b>	Order/schedule complete

**P/C (PCYFL).** A code indicating the contents of the Item Rate field.

<b>blank</b>	Value for any manufacturing order in MOMAST.
<b>C</b>	Item Rate is expressed as cycle time between pieces.
<b>P</b>	Item Rate is expressed as pieces per hour.

**S-NUMBER (SNMBR).** The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

---

## Option 6. Release Schedules (AMQM40)

Use this option to release schedules to production. This option creates the routing, component, Item Balance record, and additional description records necessary for running a schedule. You can select schedules to release, or schedules to release and prime. In addition, you can print the Item Shortage report and the Schedule Shortage report. The Released Schedules Audit report prints automatically.

**What information you need:** The warehouse, release horizon date, and the production line for the schedules you want to release to production.

**What reports are printed:**

- Release Schedules Audit (AMQ4N1)
- Release Schedules Audit-Totals (AMQ4N2)
- Release Schedules Prime Audit Report (AMQ4N3)
- Release Schedules Item Shortage Report (AMQ4Q)
- Release Schedules Schedule Shortage Report (AMQ4W).

**What forms you need:** None.

The basic steps to release schedules follow each display.

### AMQ460—Release Schedules (Select)

Use this display to select the warehouse for which you want to release schedules.

This display appears only when you select option 6 on menu AMQM40 and you have multiple warehouses defined.

```
DATE **/**/**          RELEASE SCHEDULES          SELECT    AMQ460  **
                                     WAREHOUSE          aA3
                                     F24 END OF JOB          +
```

#### What to do

- To accept the default warehouse, press **Enter**.
- To enter another warehouse, type in the new number and press **Enter**.

## Function keys

F24 END OF JOB shows you the REP Schedule Management menu (AMQM40) again, so you can choose another schedule option or end this activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WAREHOUSE (HOUSE) [?]**. This field contains the value of the default planning warehouse. You may type in the code of another warehouse from which components are issued and the finished items received, or you can leave it blank to select schedules from all warehouses.

## AMQ461—Release Schedules (Select)

Use this display to select schedules to be reviewed for releasing.

This display appears when you select option 6 on menu AMQM40 if you do not have more than one warehouse defined. If you have more than one warehouse defined, this display follows display AMQ460.

DATE **/**/**	RELEASE SCHEDULES	SELECT	AMQ461 **
WAREHOUSE	***		
RELEASE HORIZON DATE	nnnnnn		
LINE	aaaA5		
SHORTAGE REPORTS	n		
	1 BY ITEM		
	2 BY SCHEDULE		
	3 BOTH		
	4 NONE		
FIRST SCHEDULE DATE	99/99/99		
		F19 RETURN TO SELECT	
		F24 END OF JOB	
			+

## What to do

To select schedules to release, enter the information you need, and press **Enter**. You can also print shortage reports from this display. Go to display AMQ462.

## Function keys

F19 RETURN TO SELECT returns to the Select display (AMQ460) so you can select another warehouse.

F24 END OF JOB submits the job to release all selected schedules and shows you the REP Schedule Management menu (AMQM40) again so you can choose another schedule option or end this activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WAREHOUSE (HOUSE)**. The warehouse selected on display AMQ460 or the default planning warehouse. If you selected all warehouses on display AMQ460, ALL appears in this field.

**RELEASE HORIZON DATE (RLEDT)**. Required. Type in the upper date limit for schedule start dates that you want for review for release.

**LINE (PLINE) [?]**. Type in the production line you want to review for schedules to release.

**SHORTAGE REPORTS**. Type in one of the following:

- 1 Sorts the shortage reports by item
- 2 Sorts the shortage reports by schedule
- 3 Prints the shortage reports by both item and schedule
- 4 Prevents the shortage reports from being printed.

**FIRST SCHEDULE DATE**. Type in the first date for which you want to release schedules.

## AMQ462—Release Schedules (Select)

Use this display to select schedules to be reviewed for release, or schedules to release and prime, whose start date is prior to or equal to the release horizon date you entered on display AMQ461.

This display appears after you enter data on display AMQ461.

```

DATE **/**/**          RELEASE SCHEDULES          SELECT    AMQ462  **
WH ***  RELEASE HORIZON DATE **/**/**  LINE *****

SEL START DT SCHED DT LINE WH  ITEM          SCH NBR  S-NUMBER
A  **/**/** **/**/** ***** ** *****          ***** *****
REFERENCE
*****
REV *****
A  **/**/** **/**/** ***** ** *****          ***** *****
REFERENCE
*****
REV *****
A  **/**/** **/**/** ***** ** *****          ***** *****
REFERENCE
*****
REV *****
A  **/**/** **/**/** ***** ** *****          ***** *****
REFERENCE
*****
REV *****
*****
USE ROLL UP/DOWN          F13 RELEASE ALL
F11 REL AND PRIME ALL    F19 RETURN TO SELECT
F12 ADDITIONAL FIELDS    F24 END OF JOB

```

### What to do

- To see additional fields, use **F12**. To return to the original display format, use **F12** again.
- To select schedules, type **1** in the **SEL** field and press **Enter**. Go to display AMQ461.
- To release all schedules, use **F13**. Go to display AMQ461.
- To return to the Release Schedules (Select) display (AMQ461), use **F19**. Go to display AMQ461.

### Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of schedules.

F11 REL AND PRIME ALL sets the **SEL** flag to '2' for each of the schedules that are being made available for display. This flag indicates these schedules should be released and primed automatically.

F12 ADDITIONAL FIELDS allows you to review the second line of fields on the display. Using **F12** a second time returns you to the original format of one line of fields.

F13 RELEASE ALL sets the **SEL** flag to '1' for each of the schedules that are being made available for display. This flag indicates these schedules should be released, but not primed.

F19 RETURN TO SELECT returns to the Select display (AMQ461).

F24 END OF JOB submits the job to release all schedules flagged by **F13** or individually selected. The REP Schedule Management menu appears (AMQM40) again so you can choose another group of schedules or end this activity.

## Fields

**WH (Warehouse) (HOUSE).** The warehouse from which components are issued and the finished items are received. If you selected all warehouses on display AMQ460, ALL appears in this field.

**RELEASE HORIZON DATE (RLEDT).** The date that is the upper limit for the schedule start dates you want to review for releasing.

**LINE (PLINE).** The production line selected on the previous display.

**SEL (Select) (RELFL).** Type in **1** next to each schedule that you want to release. Type in **2** next to each schedule that you want to release and prime. To ignore a specific schedule, leave the **SEL** field blank.

**START DT (SSTDT).** The beginning date of the schedule when components are available at the line.

**SCHED DT (ODUDT).** The date the item's schedule is due to be completed.

**LINE (PLINE).** The production line where a schedule will be built.

**WH (Warehouse).** The warehouse from which components are issued and the finished items are received.

**ITEM (ITNBR).** The number of the item on schedules selected to be released.

**SCH NBR (ORDNO).** The schedule number associated with this item.

**S-NUMBER (SNMBR).** The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**REFERENCE (REFNO).** The user-defined code used to provide additional information.

**REV (ITRV).** This field appears only if EPDM is activated. The revision identifier associated with this item.



## Option 7. Print Schedule Information (AMQM40)

Use this option to print schedule packets and/or the Production Reporting List. You can use these reports as shop floor documents during the production of a schedule.

You must select the types of schedules you want to print.

**What information you need:** The schedules for which you want to print schedule packets.

**What reports are printed:**

- Schedule Packet (AMQ4H1)
- Schedule Packet Summary List (AMQ4H2)
- Production Reporting List (AMQ4J).

**What forms you need:** None.

The basic steps to print schedule information are listed each display.

### AMQ4G1—Print Schedule Information (Select)

Use this display to select the types of schedule information you want to print for the schedules that have been released.

This display appears when you select option 7 on menu AMQM40.

```
DATE **/**/**          PRINT SCHEDULE INFORMATION          SELECT          AMQ4G1  **

REPORTS TO PRINT      n
                      1  SCHEDULE PACKETS
                      2  PRODUCTION REPORTING LIST
                      3  BOTH

F24 CANCEL JOB          +
```

#### What to do

- To select schedule packets to be printed, type **1** in the **REPORTS TO PRINT** field and press **Enter**. Go to display AMQ4G2.
- To select the Production Reporting List to be printed, type **2** in the **REPORTS TO PRINT** field and press **Enter**. Go to display AMQ4G4.
- To select both reports to be printed, type **3** in the **REPORTS TO PRINT** field and press **Enter**. Go to display AMQ4G2.

## Function keys

F24 CANCEL JOB shows you the Schedule Management menu (AMQM40) again, so you can choose another schedule option or end this activity.

## Fields

**REPORTS TO PRINT (SELEC).** Required. Type in one of the following:

- 1 Prints schedule packets
- 2 Prints the Production Reporting List
- 3 Prints schedule packets and the Production Reporting List.

## AMQ4G2—Print Schedule Information, Schedule Packets (Select)

Use this display to print schedule packets for selected schedules. You can print packets for all previously unprinted schedules, for a single schedule, or for a range of schedules.

This display appears when you select option 1 (Schedule Packets) or 3 (Both) on display AMQ4G1.

For the **From** and **To** ranges on this display, the value you type in the **To** field must be greater than or equal to the value you type in the **From** field when both fields are used. The range begins with and includes the value you type in the **From** field; it ends with and includes the value you type in the **To** field.

If you type a value in the **From** field only, the system ends the range with the highest value for that field. If you type a value in the **To** field only, the system begins the range with the lowest value for that field. If you want to select records by a single value instead of a range, use that value in both the **From** and **To** fields.

DATE **/**/**	PRINT SCHEDULE INFORMATION SCHEDULE PACKETS	SELECT	AMQ4G2 **
WAREHOUSE	aA3		
SCHEDULES SELECTED	n	FROM	TO
1	ALL NOT PREVIOUSLY PRINTED	nnnnnn	nnnnnn
2	ALL WITHIN A RANGE OF START DATES	nnnnnn	nnnnnn
3	ALL WITHIN A RANGE OF SCHED DATES	nnnnnn	nnnnnn
4	SINGLE SCHEDULE		
	LINE	aaaA5	
	ITEM	aaaaaaaaaaaaA15	
	SCHED DATE	nnnnnn	
	S-NUMBER	aaaaaaaaaaaaaaaaA20	
	SCHED NBR	aaaaaA7	
		F19 RETURN TO SELECT	
		F24 CANCEL JOB	
			+

## What to do

- To select some or all schedule packets to be printed, enter the warehouse and type **1**, **2**, or **3** in the **SCHEDULES SELECTED** field. Type in a date range if you do not want to print all schedule packets. Press **Enter**. Go to display AMQ4G3.
- To select a schedule packet to be printed for a specific schedule, type **4** in the **SCHEDULES SELECTED** field. Go to display AMQ4G3.
- To return to the Print Schedule Information (Select) display (AMQ4G1), use **F19**.

## Function keys

F19 RETURN TO SELECT returns to the Select display (AMQ4G1) so you can change the report type.

F24 CANCEL JOB shows you the REP Schedule Management menu (AMQM40) again, so you can choose another schedule option or end this activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WAREHOUSE (HOUSE) [?]**. This field contains the value of the default planning warehouse. Type in the code of the warehouse in which the item is stocked.

**SCHEDULES SELECTED (PKTOPT)**. Required. Type in one of the following:

- 1** Prints all schedule packets not previously printed.
- 2** Prints schedule packets between a range of start dates. Type in the range in the **FROM** and **TO** fields beside this option.
- 3** Prints schedule packets between a range of schedule dates. Type in the range in the **FROM** and **TO** fields beside this option.
- 4** Prints a schedule packet for a single schedule. Type in **4** and enter line, item, schedule date and S-number, or schedule number, to select an individual schedule packet to be printed.

## AMQ4G3—Print Schedule Information, Schedule Packet Material Sequence (Select)

Use this display to print the packets with or without material detail (a listing of components) and in item, or line location sequence. If material is not selected, only the routing operation assigned to the schedule prints.

This display appears after selections are made on display AMQ4G2.

```
DATE **/**/**          PRINT SCHEDULE INFORMATION    SELECT    AMQ4G3  **
                        SCHEDULE PACKET MATERIAL SEQUENCE

WH ***  SCHEDULES SELECTED *****

                                MATERIAL DETAIL <Y,N>  A
                                MATERIAL SEQUENCE        n
                                                1  BY COMPONENT ITEM NUMBER
                                                2  BY LINE LOCATION

                                F03 PREVIOUS DISPLAY
                                F24 CANCEL JOB

                                                                +
```

### What to do

- To print schedule packets in component item number sequence, type **1** in the **MATERIAL SEQUENCE** field.
- To print schedule packets in line location sequence, type **2** in the **MATERIAL SEQUENCE** field. Press **Enter**.

**Note:** The schedule packets will be submitted to be printed. If you did not select both reports to be printed. If you selected both reports to be printed, go to display AMQ4G4.

### Function keys

F03 PREVIOUS DISPLAY shows you the previous display (AMQ4G2) to allow you to select which packets to print.

F24 CANCEL JOB shows you the REP Schedule Management menu (AMQM40) again, so you can choose another schedule option or end this activity.

### Fields

**WH (HOUSE).** The warehouse from which components are issued and the finished items are received.

**SCHEDULES SELECTED (PKTOPT).** The schedule information that you selected on display AMQ4G2 to be printed.

**MATERIAL DETAIL <Y,N> (LMGTL).** Required. Type in **Y** (Yes) or **N** (No):

- Y** Prints the material component information with the schedule packet.
- N** Prevents component information from printing with the schedule packet. The default is the last entry you made.

**MATERIAL SEQUENCE (SEQUEN).** Required. Type in one of the following:

- 1** If you selected to print material detail, prints the material list in component item number order.
- 2** Prints the material list in line location order.

## AMQ4G4—Print Schedule Information, Production Reporting List (Select)

Use this display to specify the information to be included on the Production Reporting List. You can also specify the printer output queue for the report. This report prints bar code of the turnaround number for schedules and operations within the schedules.

This display appears after you make selections on display AMQ4G3 or after you select a production reporting list on AMQ4G1.

For the **From** and **To** ranges on this display, the value you type in the **To** field must be greater than or equal to the value you type in the **From** field when both fields are used. The range begins with and includes the value you type in the **From** field; it ends with and includes the value you type in the **To** field.

If you type a value in the **From** field only, the system ends the range with the highest value for that field. If you type a value in the **To** field only, the system begins the range with the lowest value for that field. If you want to select records by a single value instead of a range, use that value in both the **From** and **To** fields.

DATE **/**/**	PRINT SCHEDULE INFORMATION PRODUCTION REPORTING LIST	SELECT	AMQ4G4 **
WAREHOUSE	aA3		
LINE	nnnnn		
SCHEDULE DATE	FROM TO 999999 999999		
PRINT TO OUTPUT QUEUE	aaaaaaaaA10		
OUTPUT QUEUE LIBRARY	aaaaaaaaA10		
		F19 RETURN TO SELECT F24 CANCEL JOB	+

## What to do

- To submit the report to be printed, type in the information you need, and press **Enter**.
- To return to the Print Schedule Information (Select) display (AMQ4G1), use **F19**.

## Function keys

F19 RETURN TO SELECT returns to the Select display (AMQ4G1) so you can change the report type.

F24 CANCEL JOB shows you the REP Schedule Management menu (AMQM40) again, so you can choose another schedule option or end this activity.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WAREHOUSE (HOUSE)**. This field contains the value of the default planning warehouse. Type in the code of the warehouse from which components are issued and the finished items received.

**LINE (PLINE) [?]**. Required. Type in the production line you want to include on the report.

**SCHEDULE DATE FROM (BEGDT/ENDDT)**. Type in the beginning and ending schedule date for selection.

**PRINT TO OUTPUT QUEUE (SPOUQ)**. Required. Type in the designated output queue for the Production Reporting List. The default is the value entered for the report using menu AMZM30, option 3, Work with Printer Overrides.

**OUTPUT QUEUE LIBRARY (SPLIB)**. Required. Type in the name of the library that contains the output queue. The default is the value entered for the report using menu AMZM30, option 3, Work with Printer Overrides.

## Option 8. Purge Schedules (AMQM40)

Use this option to remove schedules from the open schedule files, and optionally, to add the information to the manufacturing order schedule history files. Open allocations are removed at this time.

You must select the method to purge schedules and enter the schedule purge dates. You can purge schedules for a specific warehouse when you use the Purge by Schedule Date option. You can also purge any schedules that fall within the valid date range you specify.

The basic steps to purge schedules follow each display.

**Note:** A schedule cannot be purged if one of the following conditions exists:

- One of the schedule's components appears on a pick list. You must enter a Component Transfer to Line (CL) transaction to receive the component at the line location or enter a CL transaction with a zero quantity to cancel the replenishment.
- The schedule has transactions which are in error in PM&C. The transactions must be corrected through PM&C first.
- There are RM, RO, or SM transactions that have not been processed by the UJOB. The UJOB must be made active to allow the transactions to be processed.
- The schedule has unapplied IP transactions that must be resolved first. Check existing REP batches for unapplied transactions.

### AMQ4A1—Purge Schedules (Select)

Use this display to select the method to purge schedules. You can purge schedules by entering a schedule purge date, or by specifying individual schedules.

This display appears when you select option 8 on menu AMQM40.

DATE **/**/**	PURGE SCHEDULES	SELECT	AMQ4A1 **
PURGE BY	n		
	1 SCHEDULE PURGE DATE		
	2 INDIVIDUAL SCHEDULES		
		F24 CANCEL JOB	+

## What to do

- To purge schedules by the purge date, type **1** in the **PURGE BY** field and press **Enter**. Go to display AMQ4A2.
- To purge individual schedules, type **2** in the **PURGE BY** field and press **Enter**. Go to display AMQ4A3.

## Function keys

F24 CANCEL JOB clears the purge field in all records selected for purge and shows you the Schedule Management menu (AMQM40) again, so you can choose another schedule option or end this activity. All schedules selected for purge will be unselected.

## Fields

**PURGE BY (SELWK)**. Required. Type in the method to purge schedules:

- 1 Select schedules for purging using a Schedule Purge Date.
- 2 Select individual schedules for purging.

## AMQ4A2—Purge Schedules (Select)

Use this display to enter a purge date and warehouse. All schedules with a due date equal to or prior to this date for the warehouse indicated will be purged from the data base regardless of status.

The Carry Forward procedure is run automatically to update any schedules using that function.

This display appears when you enter **1** in the **PURGE BY** field on display AMQ4A1.

DATE **/**/**	PURGE SCHEDULES	SELECT	AMQ4A2	**
WAREHOUSE	aA3			
LAST SCHEDULE PURGE DATE	**/**/**			
NEW SCHEDULE PURGE DATE	999999			
ALL SCHEDULES DUE ON OR BEFORE THE DATE ENTERED WILL BE PURGED PRESS ENTER TO CONTINUE				
F18 REFRESH DISPLAY F19 RETURN TO SELECT F24 CANCEL JOB				
+				



## What to do

- To select a purge date, enter the information you need, and press **Enter**. Go to display AMQ4A3.
- To return to the Purge Schedules (Select) display (AMQ4A1), use **F19**. Go to display AMQ4A1.
- To cancel what you typed in on this display, use **F18**.

## Function keys

F18 REFRESH DISPLAY shows the display again without any changes made.

F19 RETURN TO SELECT returns to the Select display (AMQ4A1) so you can select another option.

F24 CANCEL JOB clears the purge fields in all records selected for purge and shows you the Schedule Management menu (AMQM40) again, so you can choose another schedule option or end this activity. All schedules selected for purge will be unselected.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WAREHOUSE (HOUSE) [?]**. This field contains the value of the default planning warehouse. Type in the identifier of the warehouse for which you want schedules purged. If you make this field blank, all warehouses will be included in your purge (you will receive a message warning you that the field is blank). You can type in a different warehouse, or you can type a ? to search for the warehouse.

To purge schedules by date for another warehouse, you must complete the processing cycle before entering a new warehouse identifier. In other words, press **Enter** on the Report Options display (AMQ4A5) and select option 8 again on the Schedule Management menu (AMQM40).

**LAST SCHEDULE PURGE DATE (PGDAT)**. The date you used for the last schedule purge.

**NEW SCHEDULE PURGE DATE (PDAT1)**. Required. Type in a new date. All schedules for the warehouse specified with a due date prior to and including the one you enter are deleted. Press **Enter** to confirm the date you want to use. To change the date, you can do so by selecting **F18 REFRESH DISPLAY**.

### AMQ4A3—Purge Schedules (Select)

Use this display to type in your selection criteria for the individual schedules you want to purge.

This display appears when you selected option 2 (Purge by Individual Schedules) on display AMQ4A1.

```

DATE **/**/**              PURGE SCHEDULES          SELECT    AMQ4A3  **
WH aA3  LINE aaaA5  ITEM aaaaaaaaaaaaaA15
SCHED DATE FROM nnnnnn TO nnnnnn S-NUMBER nnnnnnnnnnnnnnnnnnnnnn

F19 RETURN TO SELECT
F24 CANCEL JOB
+

```

#### What to do

- To select schedules to be purged, type in the information you need, and press **Enter**. Go to display AMQ4A4.
- To return to the Purge Schedules (Select) display (AMQ4A1), use **F19**.

#### Function keys

**F19 RETURN TO SELECT** returns to the Select display (AMQ4A1).

**F24 CANCEL JOB** clears the purge fields in all records selected for purge and shows you the Schedule Management menu (AMQM40) again, so you can choose another schedule option or end this activity. All schedules selected for purge will be unselected.

#### Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WH (Warehouse) (HOUSE) [?]**. Type in the ID of the warehouse from which components are issued and the finished items received.

**LINE (PLINE)**. Type in the production line for the schedules to be purged.

**ITEM (FITEM).** Type in the item number to be purged.

**SCHED DATE FROM/TO (ODUDT).** Type in the range of starting and ending due dates for the schedules you want to purge. If you type in only a FROM date, all schedules with that due date and later will be displayed. If you type in only a TO date, all schedules with that due date and earlier will be displayed.

**Note:** If you select a future schedule that has costs already associated with it, you will receive a message warning you of this. You can ignore the message and continue, or you can decide to remove your selection for this schedule.

**S-NUMBER (SNMBR).** Type in the features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

## AMQ4A4—Purge Schedules, Schedules Available for Purge (Select)

Use this display to select individual schedules to purge.

This display appears when you press **Enter** on display AMQ4A3.

DATE **/**/**	PURGE SCHEDULES SCHEDULES AVAILABLE FOR PURGE	SELECT	AMQ4A4 **
WH aA3 LINE aaaA5 ITEM aaaaaaaaaaaaA15 SCHED DATE FROM nnnnnn TO nnnnnn S-NUMBER nnnnnnnnnnnnnnnnnnnnnnn			
SEL WH	LINE	ITEM	SCH DATE ST SCH NBR CF S-NUMBER
A	aA3	*****	**/**/** ** ***** *
A	aA3	*****	**/**/** ** ***** *
A	aA3	*****	**/**/** ** ***** *
A	aA3	*****	**/**/** ** ***** *
A	aA3	*****	**/**/** ** ***** *
A	aA3	*****	**/**/** ** ***** *
A	aA3	*****	**/**/** ** ***** *
A	aA3	*****	**/**/** ** ***** *
A	aA3	*****	**/**/** ** ***** *
A	aA3	*****	**/**/** ** ***** *
A	aA3	*****	**/**/** ** ***** *
A	aA3	*****	**/**/** ** ***** *
A	aA3	*****	**/**/** ** ***** *
A	aA3	*****	**/**/** ** ***** *
A	aA3	*****	**/**/** ** ***** *
A	aA3	*****	**/**/** ** ***** *
A	aA3	*****	**/**/** ** ***** *
A	aA3	*****	**/**/** ** ***** *
			More . . .
USE ROLL UP/DOWN		F08 SHOW SCHED SELECTED	F18 REFRESH DISPLAY
F02 CONTINUE PROCESS		F13 SELECT ALL	F24 CANCEL JOB

### What to do

- To select a schedule to be purged, type in **1** in the **SEL** field and press **Enter**.
- To select purge options, use **F02**. Go to display AMQ4A5.
- To review all schedules selected to be purged, use **F08**. To review the schedules not selected to be purged, use **F08** again.
- To accept all schedules on the display to be purged, use **F13**.
- To cancel what you typed in on this display, use **F18**.

### Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of schedules.

F02 CONTINUE PROCESS shows you display AMQ4A5 to allow you to select report options and purge schedules.

F08 SHOW SCHED SELECTED shows all the schedules selected for purging. The text for **F08** is changed to SHOW SCHED NOT SEL, and the text for **F13** is changed to SELECT ALL.

Selecting **F08** again shows all schedules not selected for purging. The text for **F08** is changed to SHOW SCHED SELECTED, and the text for **F13** is changed to UNSELECT ALL.

F13 SELECT ALL selects all schedules shown for purging. When **F08** is used the first time, the text of **F13** changes to UNSELECT ALL. When **F13** is used the second time, the purge flags are removed from the selected schedules.

F18 REFRESH DISPLAY. Resets the **SEL** field of all schedules meeting the search criteria since the last time you pressed **Enter** or used **F13**.

F24 CANCEL JOB clears the purge fields in all records selected for purge and shows you the Schedule Management menu (AMQM40) again, so you can choose another schedule option or end this activity. All schedules selected for purge will be unselected.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WH (Warehouse) (HOUSE) [?]**. Type in the code of the warehouse from which components are issued and the finished items received.

**LINE (PLINE)**. Type in the production line you want to review for schedules to purge.

**ITEM (FITEM)**. Type in the item that you want to purge from the selected schedule.

**SCHED DATE FROM/TO (ODUPT)**. Type in the range of due dates for the schedules you want to purge. If you type in only a **FROM** date, all schedules with that due date and later will be displayed. If you type in only a **TO** date, all schedules with that due date and earlier will be displayed.

You must type in at least one date. A message will be displayed if both the **FROM** and **TO** fields are blank.

**S-NUMBER (SNMBR)**. Type in the features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**SEL (Select)**. Allows you to select a specific schedule for purging. Type in **1** next to each record you want to purge. If you select a schedule that is incomplete or a future schedule that has costs associated with it, a warning message appears on the display. You can ignore the warning by pressing **Enter** again to purge the schedule, or remove the **1** from the **SEL** field.

**WH (Warehouse) (HOUSE)**. The warehouse for the schedule to be purged.

**LINE (PLINE)**. The production line where the schedule to be purged is located.

**ITEM (ITNBR).** The number of the item to be purged.

**SCHED DATE (ODUDT).** The date the item to be purged is due to be completed.

**ST (Status) (OSTAT).** The current status of the schedule.

- 00** Planned order/schedule not released
- 10** Order/schedule released, not started
- 40** Activity reported (schedule primed)
- 55** Order/schedule complete

**SCH NBR (ORDNO).** The number of the schedule associated with this item.

**CF (Carry forward).** The code that identifies whether this schedule uses carry forward processing.

- 1** Schedule is not part of a production campaign
- 2** Schedule is part of a production campaign
- 3** This is the last schedule in a production campaign.

**S-NUMBER (SNMBR).** The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

## AMQ4A5—Purge Schedules, Options (Select)

Use this display to select options for reporting activity that has occurred for the schedules being purged as well as whether to save the purged records to the Manufacturing Order History file. The carry forward calculation is performed after these options have been selected.

This display appears after you make selections on AMQ4A2 or AMQ4A4.

DATE **/**/**	PURGE SCHEDULES OPTIONS	SELECT	AMQ4A5	**
	SAVE PURGED SCHEDULES <Y,N>	A		
	SCHEDULE PERFORMANCE REPORT <Y,N>	A		
	ITEM/LINE PROCESS REPORT <Y,N>	A		
			F03 PREVIOUS DISPLAY	
			F19 RETURN TO SELECT	
			F24 CANCEL JOB	
				+

## What to do

- To select the save purged schedules option, or the report print options, enter your choices and press **Enter**.
- To return to the previous display, use **F03**. Go to display AMQ4A2 or AMQ4A4.
- To return to the Purge Schedules (Select) display (AMQ4A1), use **F19**. Go to display AMQ4A1.

**Note:** If **F24** is used from any display, all schedules selected for purging are not purged.

## Function keys

**F03 PREVIOUS DISPLAY** returns you to the previous display (AMQ4A2 or AMQ4A4) to allow you to review additional schedules.

**F19 RETURN TO SELECT** returns to the Select display (AMQ4A1) so you can select another individual schedule or group of schedules to purge.

**F24 CANCEL JOB** clears the purge fields in all records selected for purge and shows you the Schedule Management menu (AMQM40) again, so you can choose another schedule option or end this activity. All schedules selected for purge will be unselected.

## Fields

**SAVE PURGED SCHEDULES <Y,N>**. Required. This field is shown only if you selected to keep history during tailoring. Type in **Y** (Yes) or **N** (No):

- Y** Saves the selected schedules to the Manufacturing Order History file.
- N** Deletes purged schedules.

**SCHEDULE PERFORMANCE REPORT <Y,N>**. Required. Type in a **Y** (Yes) or **N** (No):

- Y** Prints a summary of all activity relating to schedules that has occurred during the period by warehouse, item, and shifts for total units scheduled, completed, and scrapped.
- N** Prevents the report from being printed.

**ITEM/LINE PROCESS REPORT <Y,N>**. Required. Type in a **Y** (Yes) or **N** (No):

- Y** Prints a summary of all schedules by line or by item showing material and labor information since the last time schedules were purged.
- N** Prevents the report from being printed.

---

## Option 9. Review Schedule Performance (AMQM40)

Use this option to review schedule performance for current schedules, and for the time period since the last schedule purge. You can determine over/under completion status of schedules, including reported scrap. Information is shown by day or cumulatively by day.

You must specify the schedules to be included in the review, and you can also view information selectively by warehouse, item, line, or planner.

**What information you need:**

- The warehouse. Leave the field blank if you want to review schedule performance for all warehouses.
- The item, line, or planner for each schedule that you want to see.
- The percentage completion value to be compared to the actual schedule percentage.

**What reports are printed:** None.

**What forms you need:** None.

The basic steps to Review Schedule Performance follow each display.

## AMQ491—Review Schedule Performance (Select)

Use this display to select the schedules to be included in the performance inquiry. You can select schedule data for all items on a line, for an item produced on several lines, or for all items assigned to a planner.

You can also enter a percent value that is compared to the percent complete value in the schedule. If any percent complete value is less than the entered value, the schedule record is highlighted on the next display (AMQ492).

This display appears when you select option 9 from menu AMQM40.

```
DATE **/**/**          REVIEW SCHEDULE PERFORMANCE          SELECT          AMQ491  **

WAREHOUSE              aA3

REVIEW SCHEDULES      n
1  LINE                aaaA5
2  ITEM                aaaaaaaaaaaaA15
3  PLANNER             nnnnn

HIGHLIGHT % COMPLETE LESS THAN  nnn

F24 END OF JOB

+
```

### What to do

To select schedules for inquiry, type in **1** to select by line, **2** to select by item, or **3** to select by planner. Press **Enter**. Go to display AMQ492.

### Function keys

F24 END OF JOB The Schedule Management menu (AMQM40) appears again, so you can choose another option or end this activity.

### Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WAREHOUSE (FITWH)**. This field contains the value of the default planning warehouse. Type in a specific warehouse code to review schedules for that warehouse, or leave the field blank to review schedules for all warehouses.





## What to do

- To see daily detail information, type in **1** in the **SEL** field and press **Enter**. Go to display AMQ493.
- To see cumulative detail information for one or more summary display lines, type in **1** in the **SEL** field and use **F08**. Go to display AMQ494.
- To return to the Review Schedule Performance (Select) display (AMQ491), use **F19**. Go to display AMQ491.

## Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of schedules.

F19 RETURN TO SELECT returns to the Select display (AMQ491) so you can make another selection.

F24 END OF JOB shows you the Schedule Management menu (AMQM40) again, so you can choose another option or end this activity.

## Fields

All of the fields on this display are optional or for information only.

**WH (Warehouse) (HOUSE)**. The warehouse you selected on display AMQ491. If left blank, the field shows information for all warehouses.

**REVIEW BY (RPTBY)**. The Review Schedules option from AMQ491 (Line, Item, or Planner) followed by a description.

**% COMPLETE LESS THAN (CMPPC)**. The percentage from display AMQ491. Any percent complete values that are less than the value shown are highlighted.

**SEL (Select) (SELWK)**. Type in **1** next to each schedule for which you want to review daily schedule information.

**WH (Warehouse) (HOUSE)**. The warehouse in which the finished items are received.

**LINE (LINWK)**. The production line on which activity occurred.

**ITEM (ITNBR)**. The item number being produced.

**CURRENT SCHEDULE (SCHED)**. The schedule quantity for this item and line since the last schedule break.

**CURRENT COMPLETE (QTCP1)**. The completed quantity for this item and line since the last schedule break.

**CURRENT VARIANCE (QTVR1)**. The difference between quantity completed and quantity scheduled for this item and line since the last schedule break.

**CURRENT % CMP (PRCNT)**. The percentage of the quantity completed against the schedule.

**PERIOD SCHEDULE (SCHD).** The schedule quantity for this item and line for the period.

**PERIOD COMPLETE (QTCP1).** The completed quantity for this item and line for the period.

**PERIOD VARIANCE (QTVR2).** The difference between quantity completed and quantity scheduled for this item and line for the period.

**PERIOD % CMP (PRCNT).** The percentage of the quantity completed against the schedule for the total period.

## AMQ493—Review Schedule Performance Daily (Inquiry)

Use this display to review daily schedule information since the last purge.

This display appears when you type in **1** in the **SEL** fields on display AMQ492 or when you use **F08 SHOW DAILY** on display AMQ494.

```

DATE **/**/**          REVIEW SCHEDULE PERFORMANCE    INQUIRY    AMQ493  **
                        DAILY

WH ***  ITEM *****
LINE *****  PLANNER *****

C SCH DATE      SCHEDULE    COMPLETE    DAILY VAR    SCHED VAR    PERIOD VAR
SCH NBR  TYPE      PLANNED SCRAP  DAILY SCRAP  PERIOD SCRAP  YIELD
* **/**/** ***** .*** ***** .*** ***** .***- ***** .***- ***** .***- ***** .***-
*****      *          ***** .***- ***** .***- ***** .***- ***** .***- ***** .***-
* **/**/** ***** .*** ***** .*** ***** .***- ***** .*** ***** .*** ***** .***-
*****      *          ***** .***- ***** .***- ***** .***- ***** .***- ***** .***-
* **/**/** ***** .*** ***** .*** ***** .***- ***** .*** ***** .*** ***** .***-
*****      *          ***** .***- ***** .***- ***** .***- ***** .***- ***** .***-
*****
AVERAGE DAILY VARIANCE ***** .***-

                        USE ROLL UP/DOWN          F08 SHOW CUMULATIVE
                        F03 RETURN TO SUMMARY      F19 RETURN TO SELECT
                                                    F24 END OF JOB
                                                    +

```

### What to do

- To see the next selected record, press **Enter**. If no more records have been selected, go to display AMQ492.
- To see cumulative performance information, use **F08**. Go to display AMQ494.
- To return to the Review Schedule Performance Summary (Inquiry) display (AMQ492), use **F03**. Go to display AMQ492.
- To return to the Review Schedule Performance (Select) display (AMQ491), use **F19**.

## Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of schedules.

F03 RETURN TO SUMMARY returns to the previous display (AMQ492).

F08 SHOW CUMULATIVE proceeds to the next display (AMQ494) which shows cumulative quantities for the Quantity Schedule, Quantity Complete, Quantity Scrapped, and Variance fields for consecutive dates.

F19 RETURN TO SELECT returns to the Select display (AMQ491) so you can make another selection.

F24 END OF JOB shows you the Schedule Management menu (AMQM40) again, so you can choose another option or end this activity.

## Fields

**WH (Warehouse) (HOUSE).** The warehouse from which components are issued and the finished items are received.

**ITEM (ITNBR).** The item number and description selected on the previous display.

**LINE (LINWK).** The production line selected on the previous display.

**PLANNER (PLANN).** The code of the person responsible for planning and scheduling this finished item.

**C (Complete) (IFLAG).** If a schedule has had a receipt transaction reported to make the schedule complete, a C appears in this field.

**SCH DATE (DATEWK).** The date the item is scheduled to be completed.

**SCHEDULE (SCHED).** The schedule quantity for this item and line for this schedule date.

**COMPLETE (QTCP1).** The completed quantity for this item and line for this schedule date.

**DAILY VAR (Daily Variance) (QTVR1).** The difference between the units reported completed and the units scheduled for this date.

**SCHED VAR (Schedule Variance) (QTVR2).** The sum of daily variances for a summary schedule.

**PERIOD VAR (Period Variance) (QTVR3).** The period-to-date sum of the schedule variances for this item since the last schedule purge by date.

**SCH NBR (ORDNO).** The schedule number associated with this item.

**CF OPT (Carry forward option) (SUMCD).** The code which indicates the carry forward option that applies to this schedule:

1 Schedule is not part of a production campaign

- 2 Schedule is part of a production campaign
- 3 Schedule is the last schedule in a production campaign.

**PLANNED SCRAP (PSCR).** The amount of expected item scrap, based on the units scheduled. The calculation is (scheduled quantity times expanded quantity per end item unit) percent yield minus scheduled quantity times expanded quantity per end item unit.

**DAILY SCRAP (QTSP3).** The actual reported scrap for the finished item.

**PERIOD SCRAP (QTSP1).** The cumulative actual scrap quantity reported for this item and line since the last purge of schedules by date.

**YIELD (AYLD4).** The percentage of completed units of the item that have passed inspection. Quantity complete divided by (quantity complete plus quantity scrapped) times 100 equals percent yield.

**AVERAGE DAILY VARIANCE (AVAR1).** The sum of the unsigned daily variances divided by the number of days a schedule appears. This field provides a measurement of how well schedules are met.

## AMQ494—Review Schedule Performance, Cumulative (Inquiry)

Use this display to review the cumulative quantities for the Quantity Schedule and Quantity Complete fields for consecutive dates.

This display appears when you use **F08 SHOW CUMULATIVE** on display AMQ492 or AMQ493.

DATE **/**/**	REVIEW SCHEDULE PERFORMANCE CUMULATIVE	INQUIRY AMQ494 **
WH *** ITEM *****	*****	
LINE *****	PLANNER *****	
C SCH DATE	SCHEDULE COMPLETE	SCHED VAR PERIOD VAR
	PLANNED SCRAP DAILY SCRAP	PERIOD SCRAP YIELD
* **/**/**	***** ,***- ***** ,***-	***** ,***- ***** ,***-
* **/**/**	***** ,***- ***** ,***-	***** ,***- ***** ,***-
* **/**/**	***** ,***- ***** ,***-	***** ,***- ***** ,***-
* **/**/**	***** ,***- ***** ,***-	***** ,***- ***** ,***-
	AVERAGE DAILY VARIANCE ***** ,***	
	USE ROLL UP/DOWN	F08 SHOW DAILY
	F03 RETURN TO SUMMARY	F19 RETURN TO SELECT
		F24 END OF JOB

### What to do

- To see the next selected record, press **Enter**. If no more records have been selected, go to display AMQ492.
- To see daily performance information, use **F08**. Go to display AMQ493.

- To return to the Review Schedule Performance Summary (Inquiry) display (AMQ492), use **F03**. Go to display AMQ492.
- To return to the Review Schedule Performance (Select) display (AMQ491), use **F19**.

## Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of schedules.

F03 RETURN TO SUMMARY returns to display AMQ492.

F08 SHOW DAILY returns to previous display (AMQ493).

F19 RETURN TO SELECT returns to the Select display (AMQ491) so you can make another selection.

F24 END OF JOB returns to the Schedule Management menu (AMQM40) so you can choose another option.

## Fields

**WH (Warehouse) (HOUSE)**. The warehouse from which components are issued and the finished items are received.

**ITEM (ITNBR)**. The item number selected on the previous display.

**LINE (LINWK)**. The production line selected on the previous display.

**PLANNER (PLANN)**. The code of the person responsible for planning and scheduling this finished item.

**C (Complete) (IFLAG)**. If a schedule has had a receipt transaction reported to make the schedule complete, a C appears in this field.

**SCH DATE (Schedule Date) (DATEWK)**. The date the schedule is to be completed.

**SCHEDULE (QTSC1)**. The cumulative schedule quantity for this item and line for this schedule date.

**COMPLETE (QTCP1)**. The cumulative completed quantity for this item and line for this schedule date.

**SCHED VAR (Schedule Variance) (QTVR2)**. The accumulated sum of daily variances.

**PERIOD VAR (Period Variance) (QTVR3)**. The cumulative period-to-date sum of the schedule variances for this item.

**PLANNED SCRAP (PSCR)**. The amount of expected item scrap, based on the units scheduled. The calculation is (scheduled quantity times expanded quantity per end item unit) percent yield minus scheduled quantity times expanded quantity per end item unit.

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**DAILY SCRAP (QTSP3).** The actual reported scrap for the finished item.

**PERIOD SCRAP (QTSP1).** The cumulative actual scrap quantity reported for this item and line since the last purge of schedules.

**YIELD (AYLD4).** The percentage of completed units of the item that have passed inspection. Quantity complete divided by (quantity complete plus quantity scrapped) times 100 equals percent yield.

**AVERAGE DAILY VARIANCE (AVAR1).** The sum of the unsigned daily variances divided by the number of days a schedule appears. This field provides a measurement of how well schedules are met.

---

## Option 10. Recalculate Schedules (AMQM40)

Use this option to recalculate schedules for an individual line or all lines. You must determine whether to recalculate schedules for an individual line or for all lines. It may be desirable to recalculate schedules if a change was made to the Calendar file, the variable capacity of a line, or to the production facility.

**What information you need:** The individual line for the schedules you want to recalculate.

**What report is printed:** Recalculate Schedules Audit (AMQ4S1).

**What forms you need:** None.

The basic steps to recalculate schedules follow each display.

### AMQ4R1—Recalculate Schedules (Select)

Use this display to select an individual production line, or all production lines, to have the schedules recalculated.

This display appears when you select option 10 from menu AMQM40.

```
DATE **/**/**          RECALCULATE SCHEDULES          SELECT          AMQ4R1  **  
  
          SITE  aA3  
  
RECALCULATE FOR  n  
1  LINE          aaaA5  
2  ALL LINES  
3  ALL SITES, ALL LINES  
  
F24 CANCEL JOB
```

#### What to do

- To select an individual line to have schedules recalculated, type in **1** and the line. Press **Enter**.
- To select all lines to have schedules recalculated, type in **2**. Press **Enter**.



## Function keys

F24 CANCEL JOB. The Schedule Management menu (AMQM40) appears again, so you can choose another option or end this activity.

## Fields

**SITE.** This field appears only if EPDM is activated. Type in the site identifier you want to use.

**RECALCULATE FOR.** Required. Type in one of the following:

- 1 Selects schedules on an individual line to be recalculated.
- 2 Selects schedules on all lines to be recalculated.
- 3 Selects schedules on all sites, all lines to be recalculated, if EPDM is activated. If you select this option, the **SITE** field must be blank.

## Chapter 7. File Maintenance

When you select option 5 on the Repetitive Production Management Main Menu (AMQM00), the File Maintenance menu (AMQM50) appears. This menu has 11 options to allow you to maintain the files that contain Repetitive Production Management information. All Repetitive Production Management file maintenance occurs using immediate update.

Option 1. Item Balance (AMQM50) .....	7-3
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Option 11. Variable Capacity (AMQM50) .....	7-123

Because it is impractical to lock out certain functions, you should schedule file maintenance for times when the file being maintained is not being updated by another function. Concurrent master file maintenance lets multiple users maintain the same master file at the same time.

**Note:** All file maintenance displays can lock out other jobs, both in the job queue and at other work stations. If you are using a file maintenance display, you should either respond immediately to the display or cancel the job.

```

AMQM50                      Repetitive Production Management          *****
                             File Maintenance

Type option or command; press Enter.

    1. Item Balance
    2. Released Schedules
    3. Work With Item/Line
    4. Production Facility
    5. Batch/Lot Quality Control Status
    6. Batch/Lot Numbers
    7. Location Detail
    8. Code Files >>
    9. Work With Location/Component
   10. Control File
   11. Variable Capacity

==> _____

F3=Exit      F4=Prompt   F9=Retrieve  F10=Actions
F11=Job status F12=Return  F22=Messages
    
```

**Option 1. Item Balance.** Use this option to maintain Inventory Management and Repetitive Product Management information in the Item Balance file.

**Option 2. Released Schedules.** Use this option to maintain material, labor, and allocation information for released schedules.

**Option 3. Item/Line.** Use this option to maintain production information concerning a specific item on a production line.

**Option 4. Production Facility.** Use this option to maintain production information and daily capacities for a specific production line, work station, or work center.

**Note:** When EPDM is activated, file maintenance to this file must be done from EPDM. If you want to maintain variable capacity information, use option 11 instead.

**Option 5. Batch/Lot Quality Control Status.** Use this option to maintain batch/lot date information.

**Option 6. Batch/Lot Numbers.** Use this option to maintain batch/lot numbers for items at specific locations.

**Option 7. Location Detail.** Use this option to maintain information for production facilities. This option allows selection by production line or stock location.

**Option 8. Code Files.** Use this option to add, change, or delete the code values your company uses for certain data fields. This option takes you to the Code File Maintenance menu. The fields for which you define code values appear as options on the Code File Maintenance menu.

**Option 9. Work with Location Component.** Use this option to access the Work With Location/Component Definitions panels so you can define or review what mode of replenishment is used at a location and specify or review other replenishment controls.

**Option 10. Control File.** Use this option to select tailoring options that allow you to control how the REP application handles certain functions.

**Option 11. Variable Capacity.** Use this option to maintain variable capacity information when EPDM is activated. Normally this task is performed using option 4, but if EPDM is activated that option is not available, so this option gives you access to the facility variable capacity records.

## Option 1. Item Balance (AMQM50)

Use this option to add a new Item Balance record to the Item Balance (ITEMBL) file or to change, delete, suspend, or reactivate ITEMBL information already in the file.

**What information you need:** Form IM-16.

**What reports are printed:** Item Balance File Maintenance Edit List (AMI7A).

**What forms you need:** None.

The basic steps to maintain the Item Balance file follow each display.

### AMI7A1—Item Balance File Maintenance (Select)

Use this display to select the type of Item Balance and/or Item Plan file maintenance you want to perform.

This display appears when you:

- Select option 2 on the File Maintenance menu (AMIM70)
- Select **F19** on displays AMI7A2, AMI7A3, AMI7A4, or AMI7A5
- Press **Enter** on AMI7A2, AMI7A3, AMI7A6, or AMI7A7
- Press **Enter** on AMI7A8 when REP is not installed.

```
DATE **/**/**          ITEM BALANCE FILE MAINTENANCE          SELECT          AMI7A1  **
ITEM NUMBER aaaaaaaaaaA15  WAREHOUSE aA3

                                A-ADD
                                C-CHANGE
                                D-DELETE
                                S-SUSPEND
                                R-REACTIVATE

                                ACTION A

                                F07 PLANNING INFO
                                F24 DISPLAY STATUS
```

#### What to do

To perform file maintenance on the Item Balance file, type in the item number, warehouse (if requested), and one of the action codes listed on the display. Press **Enter**.

- If you typed A or C in the **ACTION** field and the password used for this session does not authorize changes to quantities, display AMI7A2 appears. Otherwise, display AMI7A5 appears.

- If you typed D, S, or R in the **ACTION** field, display AMI7A3 appears.

## Function keys

F07 PLANNING INFO causes the Item Balance File Maintenance — Planning Information display (AMI7A8) to appear.

F24 DISPLAY STATUS causes the Item Balance File Maintenance (Status) display (AMI7A6) to appear.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**ITEM NUMBER (ITNBR) [?]**. Required. Type in the number of the item to be maintained.

**Note:** If ISL/MISL is installed, a production family item can exist in only one warehouse. An error message is issued if you try to create a record for a production family item that already exists in another warehouse.

**WAREHOUSE (HOUSE)**. Required if multiple warehouses are defined in the Warehouse Master file. Type in the code of the warehouse associated with the item. If you have only one warehouse, the warehouse defined in the Warehouse Master file appears in this field and cannot be changed.

**ACTION**. Required. Type in one of the following codes to identify the kind of maintenance to be performed:

- A** Add (new item/warehouse)
- C** Change (any maintainable field)
- D** Delete (any item/warehouse without balances)
- R** Reactivate (any suspended item/warehouse).
- S** Suspend (any item/warehouse; existing orders are processed but no new orders are accepted)

The action code needs to be typed in only once during this Item Balance file maintenance session. Type it in only if the type of maintenance is to be changed.

## AMI7A2—Item Balance File Maintenance (Add or Change)

Use this display to add or change detail information about the item in the Item Balance file.

This display appears when you type A or C in the **ACTION** field on display AMI7A1 or use **F05** on display AMI7A7 or AMI7A8 only if your password for this work session does not authorize you to change quantities and standard cost.

```

DATE **/**/**          ITEM BALANCE FILE MAINTENANCE          ADD          AMI7A2  **
ITEM NUMBER *****      WAREHOUSE ***
DESCRIPTION *****
ITEM CLASS aaA4      VENDOR          aaaaA6      PLANNER          nnnnn
STOCK LOC  aaaaaA7  FLR STOCK          A          STD COST  ***** .*****
--- LEAD TIME ---  BACKFLUSH          A          --- PERIOD-TO-DATE ---
CODE          A      STOCK CONFIGURATION A      USAGE COST nnnnnnnnnnnnnn.nn
MFG          nnn.n  ORDER POINT      nnnnnnnn.nnn  SALES COST nnnnnnnnnnnnnn.nn
VAR MFG      nnn.n  SAFETY STOCK      nnnnnnnn.nnn  SALES AMT  nnnnnnnnnnnnnn.nn
ADJ MFG      nnn.n  FIXED ORDER QTY  nnnnnnnn.nnn
AVG MFG      nn.n   PURCHASE U/M          A2          --- YEAR-TO-DATE ---

CMLT MFG     nnn.n  U/M CONV          nnnnn.nnnnn  USAGE COST nnnnnnnnnnnnnn.nn
REV PUR      nnn.n  ITEM ACCOUNTING CLASS aA3  SALES COST nnnnnnnnnnnnnn.nn
VEN PUR      nnn.n  SALES AMT         nnnnnnnnnnnnnn.nn
SAF PUR      nnn.n
PUR          nnn.n  --- CYCLE COUNT ---      AVG SALES  nnnnnnnnnnnnnn.nn
ADJ PUR      nn     CODE              n          DATE LAST SALE  nnnnnn
AVG PUR      nnn.n  DATE NEXT COUNT  nnnnnn    DATE LAST USE   nnnnnn

CMLT MTL     nnn.n  TRANS COMPARE     nnnnnnn    DATE LAST MAINTAINED nnnnnn

                                F18 REFRESH
                                F19 RETURN TO SELECT

```

### What to do

To add or change the Item Balance record, type in the requested information and press **Enter**. Go to display AMI7A1.

### Function keys

F18 REFRESH causes the display to appear as it did when you first selected it.

F19 RETURN TO SELECT causes the Select display AMI7A1 to appear again.

### Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**ITEM NUMBER (ITNBR)**. The number of the item to maintain.

**WAREHOUSE (HOUSE)**. The code that identifies the warehouse where the item is located.

**DESCRIPTION (ITDSC)**. The description of the item to maintain.

**ACTIVITY CODE (ACREC).** The present status of the record shown:

**A** Active  
**D** Deleted  
**S** Suspended

The remaining fields on this display are described in groups as shown on the display for purposes of continuity, rather than in the normal order dictated by cursor movement.

**ITEM CLASS (ITCLS).** Type in the user-defined code identifying the class or group to which this item belongs. For example, ST might indicate this item is classified with that group of items made of steel. If you are adding a record to the Item Balance file, the item class from the Item Master record appears. Accept the default or type a new value. If you blank out this field, no item class is assigned.

Uses of item class include the following:

- Sales Analysis can be performed using item class.
- Item Master file maintenance allows percentage change of purchase content (cost) for all items having a specific item class.
- PDM cost simulation can be run based on percentage change of purchase content (cost) for all items having a specific item class.
- Several IM reports allow limits to be set using item class and can also be sequenced using item class.

**VENDOR (VNDNR) [?].** Type in the number of the primary vendor supplying this item. If you are adding a record to the Item Balance file, the vendor number from the Item Master record appears. Accept the default, or type in a new value. If you blank out this field, no vendor number is assigned. If Purchasing is installed and interfacing, refer to the *Purchasing User's Guide* for more information about this field.

**PLANNER (PLANN).** The user-assigned code that identifies the person responsible for planning the replenishment strategy for this item.

**STOCK LOC (Warehouse Stock Location) (WHSLOC) [?].** Type in the code that identifies the location of this item in the warehouse. When this display first appears, it defaults to the value from the Item Master record. Be aware that if you subsequently change this field to a blank, it will not default to the value from the Item Master record.

Picking lists can be sequenced by this field to aid in picking items for sales and manufacturing orders. For controlled warehouses, this serves as a default supply location.

**FLR STOCK (Floor Stock Code) (FLSTK).** A code that indicates if the floor stock is controlled. Select one of the following codes:

**blank** Not floor stock  
**C** Controlled floor stock  
**U** Uncontrolled floor stock

Uncontrolled floor stock items are normally inexpensive items such as washers, rivets, or wire that are issued to an assembly area in bulk quantities to be used as needed. The bulk issue (Miscellaneous Issue) transaction is not reported against any specific manufacturing order. When a manufacturing order is released that requires uncontrolled floor stock items, the application applies all issues and associated material costs for those items to the order at that time. Separate issue transactions used to record the usage of these items are not necessary.

Controlled floor stock items are normally more expensive components stored in assembly areas in bulk quantities to be used as needed. The application applies usage of these components to manufacturing orders in calculated quantities as Production Receipt (RM) or Manufacturing Order Scrap (SM) transactions are processed for the end item on the manufacturing order. When a Production Receipt transaction is entered for a manufacturing order that has controlled floor stock components, Planned Manufacturing Issues for those components are generated. The application calculates the quantity by multiplying the receipt quantity times the quantity per assembly of the controlled floor stock item. This technique is referred to as backflushing.

**BACKFLUSH (BFFL).** The code that identifies whether component backflushing for controlled floor stock items is done using the component quantity per adjusted for yield or the standard component quantity per.

- 0 Use the value of the backflush code for the warehouse.
- 1 Use adjusted quantity per to backflush (default).
- 2 Use standard quantity per to backflush.

**STD COST (STDUC).** If this field is not 0, it shows the standard cost (standard unit cost) used in inventory costing. This standard cost overrides the unit cost default (UCDEF) from the Item Master record.

You cannot change the **STANDARD COST** field from this display. You must use a Standard Cost replace (CS) transaction to change the standard cost for an item.

**LEAD TIME.** Required when you add information.

**CODE (LTCOD):** Required. A code used to indicate which lead time to use when MRP plans replenishment orders. Use M if this item has components and you want requirements generated for them by MRP. Select one of the following codes:

- M Manufacturing lead time
- P Purchasing lead time.

The lead times for a standard lot of an item expressed in working days, are as follows:

**MFG (Standard Manufacturing) (LTMAN):** The total lead time to manufacture one standard lot size of the item based on availability of components and the use of a single level bill of material. Standard manufacturing lead time includes fixed time factors (such as setup, move, and queue times) and quantity-dependent factors (such as run times to produce standard lots).

**VAR MFG (Variable Manufacturing) (LTVAM):** The portion of total manufacturing lead time dependent on the quantity produced. It is the run time for all operations that do not have a fixed length of time per lot. This value is used when computing quantity-based lead times in MRP. If a value is not typed in this field, MRP assumes that the quantity-based lead time calculations do not apply and that, regardless of the planned order quantity, the lead time will be the sum of the standard manufacturing lead time and the manufacturing lead time adjustment.

**ADJ MFG (Adjustment Manufacturing) (LTADM):** A portion of the total lead time required for quantity-independent administrative activities such as review time or requisition processing time prior to order release. This value is added to the standard manufacturing lead time to arrive at the total manufacturing lead time.



**AVG MFG (Average Manufacturing) (LTMAV):** The weighted average number of days between the order release and the order completed receipt to stock. This field is updated by the application but can be changed using file maintenance.

**CMLT MFG (Cumulative Manufacturing) (CMFLT):** The total number of days to produce an item, assuming all purchased items at every level of the bill of material are in stock. This field is manually maintained.

**REV PUR (Review Purchasing) (LTREV):** The number of days between creation of the requisition and release of the order to the vendor.

**VEN PUR (Vendor Purchasing) (LTVEN):** The vendor-quoted number of days between the vendor's receipt of your order and delivery to your dock.

**SAF PUR (Safety Purchasing) (LTSAF):** The number of days allocated for unexpected delays.

**Note:** **REV PUR**, **VEN PUR**, and **SAF PUR** appear only if Purchasing is installed and interfacing.

**PUR (Standard Purchased) (LTPUR):** The number of days between creation of a requisition and receipt of the item at the dock. It is the sum of **REV PUR**, **VEN PUR**, and **SAF PUR**.

**ADJ PUR (Adjustment Purchased) (LTADP):** The number of days between receipt of the item at the dock and receipt to stock.

**AVG PUR (Average Purchased) (LTPAV):** The weighted average number of days between purchase order release and receipt of the item to stock. The average purchase lead time is calculated by the application but can be changed using file maintenance.

**CMLT MTL (Cumulative Material Lead Time) (CMTLT):** The amount of time necessary to produce a standard lot size of the item when starting with no materials on hand. It is the sum of the longest lead time for a purchased component, on the lowest level of the product structure, and the longest manufacturing or purchase lead time in the next higher assembly. Cumulative material lead time is the maximum amount of time required to purchase the materials and manufacture an item.

The application does not calculate this field; it must be manually maintained. The longest manufacturing or purchase lead time from each successive level of the assembly is added to the current sum (or is replaced by the longest lead time from this level, if it is longer than the current sum), until the cumulative material lead time is calculated for the specified item.

**STOCK CONFIGURATION (STCFS).** This field appears if this is a configured item and the warehouse is controlled. A 1 in this field indicates the configuration will be identified in the **Batch/Lot** field when the item is received. A 0 in this field indicates the configuration will not be identified in the **Batch/Lot** field. Type in 1 to be able to identify how many of which configuration you have in stock.

**ORDER POINT (ORDPT).** Leave this field blank for the system to calculate the order point. If Forecasting (FCST) is installed and interfacing, you can also allow it to calculate this quantity. Otherwise, type in the quantity of the item, below which an

exception condition occurs, to flag the need to reorder this item. Quantity entered must be in terms of the stocking unit of measure.

**SAFETY STOCK (SAFTY).** Type in the quantity of the item to be carried in excess of expected demand to meet unexpected increases in demand or late delivery. Quantity entered must be in terms of the stocking unit of measure. If Forecasting (FCST) is installed and interfacing, you can also allow it to calculate this quantity.

**FIXED ORDER QTY (FXORQ).** Required if this item has an order policy code of C, D, or H. When the order policy code in the Item Balance file (Planning Information) is B, you can leave this field blank if you want the system to dynamically calculate order quantity. Otherwise, when the order policy code is B or D, type in the quantity of the item that is to be reordered when the quantity available falls below the order point.

When the order policy code is C, type in a quantity representing the level that the quantity available should be brought up to whenever the item is reordered.

When the order policy code is H, type in the minimum reorder quantity for which an order can be released (defined by your company).

Quantity entered must be in terms of the stocking unit of measure.

**PURCHASE U/M (Purchase Unit of Measure) (PURUM).** Type in the purchase unit of measure for the item if it is different from the stocking unit of measure. For example, wire can be purchased by the coil but issued by the meter. This field is used with the unit of measure conversion factor when printing the Reorder Report and the Purchase Order Status Report and can be used in purchase receipt transactions.

**U/M CONV (Unit of Measure Conversion) (UMCNV).** Type in the factor used in converting one purchase unit of measure of the item to stocking units of the item when the two are different. For example, if wire is issued by the meter and purchased by the coil with each coil containing 250 meters, then a conversion factor of 250.00 would be entered. If bolts are issued individually but purchased by the box with each box containing 75 bolts, then enter 75.00 for the unit of measure conversion factor. The default value is 1.00 if the purchasing unit of measure is left blank. Otherwise, it is a required field.

**ITEM ACCOUNTING CLASS (ITAC).** Class, defined by your company, to group or classify items for accounting purposes.

#### **CYCLE COUNT.**

**CODE (Cycle Count Code) (CCODE):** A code used to indicate if the item is to be cycle counted, and, if so, how often. Select one of the following codes:

- |          |   |
|----------|---|
| <b>0</b> | No cycle count performed on this item                   |
| <b>1</b> | Cycle count performed monthly                           |
| <b>2</b> | Cycle count performed quarterly                         |
| <b>3</b> | Cycle count performed semi-annually                     |
| <b>4</b> | Cycle count performed on the Date of Next Count (NXCDT) |

**DATE NEXT COUNT (NXCDT):** The date used with cycle count code 4 to select items for cycle counting.

The default is 999999. The due date of replenishment orders is automatically placed into this field if it contains 999999, so that the item can be selected for cycle counting just prior to a receipt (when the quantity on hand is at its lowest point).

If the first replenishment order is a blanket purchase order and you want to do the cycle count while the on hand balance is low, type the due date of the first release in this field.

**TRANS COMPARE (Transaction Count Compare) (CCOMP):** If this item is to be cycle counted, type in the number of transactions after which the item should be flagged for cycle counting. Type **1** in this field for items in your cycle count control group.

If this field is not 0, it can be used with the cycle count code. For example, if the cycle count code is 2 (quarterly) and you type 40 in this field, the item is selected for cycle count at least every three months. However, the item may be selected earlier if 40 transactions are processed for this item before three months have passed.

When you request a Cycle Count List using display AMI5A4 or AMI5A5 (option 2 on menu AMIM50), items with a count of transactions that fall within a user-assigned percentage of this transaction count compare value can be cycle counted.

**DATE LAST SALE (DOFLS).** Type in the date of last sale for this item. This field is updated by the application when sales transactions are processed.

**DATE LAST USE (DOFLU).** Type in the last date on which an item was transferred from stock for any reason. This field is updated by every issue, warehouse, and adjustment transaction.

**DATE LAST MAINTAINED (MDATE).** The date this record was last maintained. It cannot be changed. It appears only when the action code is C on display AMI7A1.

**PERIOD-TO-DATE.** Depending on whether a 13-period or 12-month accounting year was selected during application tailoring, this field is shown as PERIOD or MONTH, respectively.

**USAGE COST (CSTMO):** The period or month-to-date usage cost for this item. This includes the cost of items sold, removed from stock but not sold, and issued and adjusted from stock.

**SALES COST (CAMMO):** The period or month-to-date sales cost for the item.

**SALES AMT (AMSMO):** The period or month-to-date amount of sales for the item.

**Note:** The preceding three fields are updated by the system when appropriate transactions are processed.

**YEAR-TO-DATE.**

**USAGE COST (CSTYR):** The year-to-date usage cost for this item. This includes both the cost of items sold and the cost of items removed from stock but not sold.

**Note:** Usage cost fields are computed at the time the transactions are processed using the cost (average, standard, or last) selected in the IM install/tailor questionnaire.

**SALES COST (CAMYR):** The year-to-date sales cost for the item.

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**SALES AMT (AMSYR):** The year-to-date amount of sales for the item.

**Note:** The preceding three fields are updated by the system when appropriate transactions are processed.

**AVG SALES (AVSAL).** Type in the average value of the quantity sold per month. This field is recalculated when you run period-end closing stock status with file update. If no value is entered, the average is set equal to the first non-zero period-to-date sales.

## AMI7A3—Item Balance File Maintenance (Delete, Suspend, or Reactivate)

Use this display to delete, suspend, or reactivate the selected Item Balance record.

If REP is installed and interfacing, you cannot delete or suspend the Item Balance record if any planned or released schedules exist for this item/warehouse combination in the Manufacturing Order Master file.

This display appears when you enter D, S, or R in **ACTION** on display AMI7A1.

```

DATE **/**/
**      ITEM BALANCE FILE MAINTENANCE      DELETE      AMI7A3  **

ITEM NUMBER *****      WAREHOUSE ***
DESCRIPTION *****

ITEM CLASS ****      VENDOR      *****      PLANNER      *****

STOCK LOC *****      FLR STOCK      *      STD COST *****.*****
--- LEAD TIME ---      BACKFLUSH      *      --- PERIOD-TO-DATE ---
CODE *      STOCK CONFIGURATION *      USAGE COST *****.***
MFG ***.*      ORDER POINT *****.***      SALES COST *****.***
VAR MFG ***.*      SAFETY STOCK *****.***      SALES AMT *****.***
ADJ MFG ***.*      FIXED ORDER QTY *****.***
AVG MFG **.*      PURCHASE U/M      **      --- YEAR-TO-DATE ---

CMLT MFG ***.*      U/M CONV *****.*****      USAGE COST *****.***
REV PUR ***.*      ITEM ACCOUNTING CLASS ***      SALES COST *****.***
VEN PUR ***.*      SALES AMT *****.***
SAF PUR ***.*
PUR ***.*      --- CYCLE COUNT ---      AVG SALES *****.***
ADJ PUR **      CODE *      DATE LAST SALE *****

AVG PUR ***.*      DATE NEXT COUNT *****      DATE LAST USE *****

CMLT MTL ***.*      TRANS COMPARE *****      DATE LAST MAINTAINED *****

F19 RETURN TO SELECT

```

### What to do

To confirm that you want to delete, suspend, or reactivate the Item Balance record shown on the display, press **Enter**. Go to display AMI7A1.

### Function keys

F19 RETURN TO SELECT causes display AMI7A1 to appear again.

## Fields

The fields on this display are informational only and cannot be changed. See 'AMI7A2—Item Balance File Maintenance (Add or Change)' for field definitions.

## AMI7A4—Item Balance File Maintenance (Add or Change)

Use this display to manually update Item Balance file quantities (for example, on hand, period or month, or year-to-date values) that are updated automatically by the application when processing other transactions.

This display appears when you press **Enter** or select **F08** on the Item Balance File Maintenance (Add or Change) display (AMI7A5).

```

DATE **/**/**          ITEM BALANCE FILE MAINTENANCE          CHANGE          AMI7A4  **
ITEM NUMBER *****  WAREHOUSE ***          ACTIVITY CODE *
DESCRIPTION *****

      --- QUANTITIES ---          --- PERIOD-TO-DATE ---          --- YEAR-TO-DATE ---
ON HAND          nnnnnnn.nnn          SOLD          nnnnnnnnn.nnn          SOLD          nnnnnnnnnnn.nnn
ON ORDER PROD    nnnnnnn.nnn          ISSUES        nnnnnnnnnnn.nnn          ISSUES        nnnnnnnnnnn.nnn
ON ORDER PUR     nnnnnnn.nnn          RECEIPTS     nnnnnnnnnnn.nnn          USAGE        nnnnnnnnnnn.nnn
ALLOCATED        nnnnnnn.nnn          ADJUSTS      nnnnnnnnnnn.nnn
PICK LIST REQ    nnnnnnn.nnn          USAGE        nnnnnnnnnnn.nnn
BEGIN INV        nnnnnnn.nnn

                                DATE LAST ACTIVITY ISSUED          nnnnnn
                                DATE LAST AFFECTING QTY ON HAND          nnnnnn

                                AVERAGE PERIOD END BALANCE          nnnnnnnnnnnnnnn.nn
                                ESTIMATED ANNUAL USAGE                  nnnnnnnnnnn.nnn

                                F05 RETURN TO DETAIL
                                F18 REFRESH
                                F19 RETURN TO SELECT
    
```

## What to do

To manually update the quantities, type in the requested information and press **Enter**. Go to display AMI7A8.

Quantities are updated automatically by the application when processing transactions. You cannot change on hand quantity if you chose to use transaction history during application tailoring.

## Function keys

F05 RETURN TO DETAIL causes display AMI7A5 to appear again.

F18 REFRESH causes the display to appear as it did when you first selected it.

F19 RETURN TO SELECT causes display AMI7A1 to appear again, and any data just typed in to be ignored. In addition, any data typed in on display AMI7A5 is not used to update the Item Balance file.

## Fields

**ITEM NUMBER (ITNBR).** The number of the item to maintain.

**WAREHOUSE (HOUSE).** A code used to identify the warehouse in which the above item is located.

**ACTIVITY CODE (ACREC).** The present status of the record shown:

<b>A</b>	Active
<b>D</b>	Deleted
<b>S</b>	Suspended

**DESCRIPTION (ITDSC).** The description of the item to maintain.

The remaining fields on this display are described in their order of appearance on the display, instead of by their order of cursor movement.

## QUANTITIES.

**ON HAND (MOHTQ).** Type in the quantity of the item presently in stock. This field cannot be changed if the transaction history option was selected during application tailoring. If transaction history is supported, you must use an inventory transaction to change the on hand quantity for this item.

If you enter a quantity on hand when adding a new item and you are using controlled warehouses, you must also add this quantity on hand to the Location Quantity File (SLQNTY) using Location Detail File Maintenance in order to keep your files in synchronization.

**ON ORDER PROD (On Order Production) (MPRPQ).** Type in the total quantity of the item that is currently on order but not yet received to stock.

**ON ORDER PUR (On Order Purchase) (MPUPQ).** Type in the total quantity of the item currently on order through purchasing and still open on purchase orders for this warehouse.

**ALLOCATED (MALQT).** Type in the total quantity of this item allocated (reserved) for manufacturing requirements.

**PICK LIST REQ (Pick List Requirements) (PLREQ).** Type in the total quantity of this item reserved for customer order requirements. This field is updated automatically if COM is installed and interfacing with IM.

**BEGIN INV (Beginning Inventory) (BEGIN).** Type in the quantity of the item that was on hand at the beginning of the period or month.

**PERIOD-TO-DATE.** Depending on whether a 13-period or 12-month accounting year was selected during application tailoring, this field is shown as PERIOD or MONTH, respectively.

**SOLD (QTSMO).** Type in the quantity of the item sold this period or month-to-date.

**ISSUES (ISSMO).** Type in the quantity of the item issued this period or month-to-date. This field is reduced by components returned to stock.

**RECEIPTS (RECMO).** Type in the quantity of the item received this period or month-to-date.

**ADJUSTS (ADJMO).** Type in the sum of the adjustments (changes) made to the quantity of the item this period or month-to-date.

**USAGE (USEMO).** Type in the quantity of the item used this period or month-to-date. This includes both items sold and items removed from stock but not sold.

**YEAR-TO-DATE.**

**SOLD (QTSYR).** Type in the quantity of the item sold far this year.

**ISSUES (ISSYR):** Type in the quantity of the item issued this year. This field is reduced by components returned to stock.

**USAGE (USEYR).** Type in the quantity of the item used this year. This includes both items sold and items removed from stock but not sold.

**DATE LAST ACTIVITY ISSUED (LACDT).** Type in the last date that this item was issued. This field is usually updated by every issue transaction.

**DATE LAST AFFECTING QTY ON HAND (LDQOH).** Type in the last date the quantity on hand for this item was changed. This field is updated by every transaction that changes the quantity on-hand.

**AVERAGE PERIOD END BALANCE (AVMEB).** Type in the average quantity on hand of the item at period-end closing. The quantity shown is either a period or month-end balance, depending on whether a 13-period or 12-month accounting year was selected during application tailoring. If no value is entered, the average is set equal to the first non-zero on hand period-end balance.

**ESTIMATED ANNUAL USAGE (EAANU).** Type in the average quantity of the item used during one entire year. This average is recalculated during each period-end file update run. If no value is entered, the average is set equal to the annualized value of the first non-zero period-to-date usage.

## **AMI7A5—Item Balance File Maintenance (Add or Change)**

Use this display to add or change detail information about the item in the Item Balance file.

This display appears when you enter A or C in **ACTION** on display AMI7A1 or press **F05** on display AMI7A8 only if your password for this work session authorizes changes to quantities and standard cost.

```

DATE **/**/
**      ITEM BALANCE FILE MAINTENANCE      CHANGE      AMI7A5 **

ITEM NUMBER *****      WAREHOUSE ***
DESCRIPTION *****      ACTIVITY CODE A

ITEM CLASS aaA4      VENDOR      aaaaA6      PLANNER      nnnnnn

STOCK LOC aaaaaA7      FLR STOCK      A      STD COST ***** .*****
--- LEAD TIME ---      BACKFLUSH      A      --- PERIOD-TO-DATE ---
CODE A      STOCK CONFIGURATION A      USAGE COST nnnnnnnnnnnnnn.nn
MFG nnn.n      ORDER POINT nnnnnnn.nnn      SALES COST nnnnnnnnnnnnnn.nn
VAR MFG nnn.n      SAFETY STOCK nnnnnnn.nnn      SALES AMT nnnnnnnnnnnnnn.nn
ADJ MFG nnn.n      FIXED ORDER QTY nnnnnnn.nnn
AVG MFG nn.n      PURCHASE U/M      A2      --- YEAR-TO-DATE ---

CMLT MFG nnn.n      U/M CONV nnnnn.nnnnn      USAGE COST nnnnnnnnnnnnnn.nn
REV PUR nnn.n      ITEM ACCOUNTING CLASS aA3      SALES COST nnnnnnnnnnnnnn.nn
VEN PUR nnn.n      SALES AMT nnnnnnnnnnnnnn.nn
SAF PUR nnn.n
PUR nnn.n      --- CYCLE COUNT ---      AVG SALES nnnnnnnnnnnnnn.nn
ADJ PUR nn      CODE n      DATE LAST SALE nnnnnn

AVG PUR nnn.n      DATE NEXT COUNT nnnnnn      DATE LAST USE nnnnnn

CMLT MTL nnn.n      TRANS COMPARE nnnnnnn      DATE LAST MAINTAINED *****
F08 REVIEW QUANTITIES
F18 REFRESH
F19 RETURN TO SELECT

```

**What to do**

To add or change detail information, type in the requested information for this Item Balance record and press **Enter**. Go to display AMI7A4.

**Note:** Pressing **Enter** on this display does not update the Item Balance file. You must press **Enter** on display AMI7A4 to update the file.

You cannot change the **STANDARD COST** field on this display if the transaction history option was selected during application tailoring. You must use a Standard Cost Replace (CS) transaction to change the standard cost for an item.

**Function keys**

F08 REVIEW QUANTITIES causes display AMI7A4 to appear so you can review or manually update quantities that were updated automatically by the application when processing transactions.

F18 REFRESH causes the display to appear as it did when you first selected it.

F19 RETURN TO SELECT causes display AMI7A1 to appear again.

**Fields**

Refer to 'AMI7A2—Item Balance File Maintenance (Add or Change)' for an explanation of the fields on this display.



## AMI7A6—Item Balance File Maintenance (Status)

Use this display to review the number of records maintained in the Item Balance file and to end the job.

This display appears when you select **F24** on the Select display AMI7A1.

```
DATE **/**/**      ITEM BALANCE FILE MAINTENANCE      STATUS      AMI7A6  **

SESSION STATUS

RECORDS ADDED      *** , *** , ***
RECORDS CHANGED   *** , *** , ***
RECORDS DELETED    *** , *** , ***
RECORDS SUSPENDED *** , *** , ***
RECORDS REACTIVATED *** , *** , ***

F24 END OF JOB
```

### What to do

- To return to the Select display AMI7A1, press **Enter**.
- To end the session, use **F24**. The Item Balance File Maintenance Edit List is scheduled for printing. The File Maintenance menu appears again.

### Function keys

F24 END OF JOB causes the File Maintenance menu to appear again.

### Fields

All fields on this display are informational only.

**SESSION STATUS.** The number of records maintained in the Item Balance file during this session.

**RECORDS ADDED.** The number of records added during this session.

**RECORDS CHANGED.** The number of records changed during this session.

**RECORDS DELETED.** The number of records deleted during this session.

**RECORDS SUSPENDED.** The number of records suspended during this session.

**RECORDS REACTIVATED.** The number of records reactivated during this session.

## AMI7A7—Item Balance File Maintenance – Repetitive Manufacturing (Add or Change)

Use this display to add or change detail information in the Item Balance file used for repetitive manufacturing processes.

This display appears when you press **Enter** on display AMI7A4 and REP is installed, you are using a controlled warehouse, and the item is neither a purchase nor miscellaneous item.

```

DATE **/**/**          ITEM BALANCE FILE MAINTENANCE      *****      AMI7A7  **
                        REPETITIVE MANUFACTURING

WH ***  ITEM *****

SCHEDULE CONTROL <Y,N>  A          EXTRACT SOURCE CODE < ,1,2,3>  A
                                CARRY FORWARD CODE <Y,N>      A
                                SMOOTHING CODE < ,1,2>          A
                                SMOOTHING START DATE            **/**/**
                                LOT SIZING <Y/N>               A

PRIMARY PRODUCTION LINE  aaaA5     SCHEDULE GROUP              aaaA5
WAREHOUSE LOCATION       aaaaaA7   QUANTITY PER CONTAINER      nnnnnnn.nnn
                                CONTAINER DESCRIPTION          aaA4

                                F05 RETURN TO DETAIL
                                F18 REFRESH
                                F19 RETURN TO SELECT
    
```

### What to do

To add or change detail information for repetitive manufacturing items in the Item Balance file, type in the information, and press **Enter**. The Select display AMI7A1 appears.

### Function keys

F05 RETURN TO DETAIL shows you display AMI7A2 so you can add or change other detail information.

If you are authorized to change the quantities in the Item Balance file, the text for **F05** reads REVIEW QUANTITIES. In that case, pressing **F05** shows you display AMI7A4 so you can review or manually update quantities that were updated automatically by the application when processing transactions.

F18 REFRESH causes the display to appear as it did when you first selected it.

F19 RETURN TO SELECT causes Select display AMI7A1 to appear again.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WH (Warehouse) (HOUSE)**. A code that identifies the warehouse in which the item is located.

**ITEM (ITNBR)**. The number of the item to maintain.

**Description (ITDSC)**. The description of the item to maintain.

**SCHEDULE CONTROL <Y,N> (SCHCD)**. The item schedule control code. The code indicates if an item can have schedules or not.

**N** The item is not schedule-controlled. This is the default.  
**Y** The item is schedule-controlled.

**EXTRACT SOURCE CODE <1,2,3> (EXTCD)**. A code used to indicate to REP the source of demand for the item. If you change this field, you may want to change the smoothing code.

**blank** No override. This is the default.  
**1** MRP, if it is installed and interfacing with REP.  
**2** COM, if it is installed and interfacing with REP.  
**3** Schedule Demand (interface) file.

**CARRY FORWARD CODE <Y,N> (CFWCD)**. A code used to indicate whether the difference between quantity produced and schedule quantity should be brought forward into the next day's schedule as schedule quantity.

**N** Do not use carry forward function. This is the default.  
**Y** Use carry forward function.

**SMOOTHING CODE <,1,2> (SMHCD)**. A code used to indicate whether the MRP demand smoothing algorithm is used to spread production evenly for the net demand and how it should be applied. This code can be overridden by the smoothing start date. If you update the smoothing code, the requirements planning modification flag (RPFLD) is set to 1. It only appears if the **SCHEDULE CONTROL** field contains Y.

**blank** No smoothing. This is the default.  
**1** Use the system date, plus one work day.  
**2** Use the first net demand date.

**SMOOTHING START DATE (SMHDT)**. A date used along with the smoothing code to indicate when demand smoothing begins for an item and warehouse combination. The date that appears in this field was typed in on the Enter and Maintain Schedules – Summary by Item display (AMQ442) in REP.

If the smoothing start date is equal to or greater than the system date, smoothing begins on the smoothing start date and overrides the value in the **SMOOTHING CODE** field. If the smoothing start date is zeros or earlier than the system date, the smoothing code determines the date smoothing starts.

**LOT SIZING <Y,N>(LOTZ).** A code used to indicate whether an item can have multiple schedules per day (lots) automatically created within REP.

- N** Do not lot size for this item. This is the default.
- Y** Lot size for this item.

**PRIMARY PRODUCTION LINE (PRLIN) [?].** The most frequently used production line. This field is required if the **SCHEDULE CONTROL** field contains Y. Entries allowed are limited to active work center records flagged as production lines.

**SCHEDULE GROUP (SCHGP).** This is a user-defined code to group items together.

**WAREHOUSE LOCATION (WHSLC) [?].** The location, recorded in the Location Detail file, in which a finished item is placed when production is complete. For components used in REP, it serves as the default supply location.

**QUANTITY PER CONTAINER (CONQT).** The number of items that fit in a full container used to transfer items to and from the production line. This field is edited during the lot sizing process. This field is required if the **SCHEDULE CONTROL** field value is Y. The default is 1.

**CONTAINER DESCRIPTION (CONDS).** A user-defined code or abbreviation that describes the container in which items are moved to and from the production line.

## AMI7A8—Item Balance File Maintenance — Planning Information (Add or Change)

Use this display to add or change planning information in the Item Balance and Item Plan files.

This display appears when you press **Enter** on the Item Balance File Maintenance (Add or Change) display (AMI7A4), or press **F07** on display AMI7A1.

```

DATE **/**/**          ITEM BALANCE FILE MAINTENANCE          CHANGE          AMI7A8  **
                        PLANNING INFORMATION
ITEM NUMBER *****  WAREHOUSE ***          ACTIVITY CODE          *
DESCRIPTION *****  DATE LAST MAINTAINED **/**/**
MASTER SCHEDULE ITEM CODE  A          PRODUCT FAMILY PLANNER  nnnnn
MINIMUM QTY                nnnnnnn.nnn  MPS PLANNING SOURCE CODE  A
MAXIMUM QTY                nnnnnnn.nnn  DAYS SUPPLY                nnn
MULTIPLE QTY              nnnnnnn.nnn  FORECASTING CODE         n
MASTER LEVEL ITEM CODE    A          MASTER LEVEL FCST CODE   n
ORDER POLICY CODE         A          NO OF PERIODS            nn
MASTER LEVEL PRINT CODE   A          DAYS/PERIOD              nn
MAX # LINES/ITEM          A          FORECAST QTY             nnnnnn
PERIOD INTERVAL CODE      n          FIRM TIME FENCE          nnn
COMBINE REQUIREMENTS CODE n          AUTH TIME FENCE          nnn
INCLUDE INVENTORY BALANCE n          AUTO RELEASE CODE        n
SHRINKAGE                 .nnn      CONTRACT REQUIRED CODE    n
PRBRK CONV FACTOR         nnnnnnn.nnnn  ITEM RESCHEDULE CODE     n
PLAN CUSTOMER ORDER CODE  n          RESCHEDULE FROZEN ZONE   nnnn
PLAN EXPECTED ORDER CODE  A          MIN DAYS TO RESCHEDULE   nnnn
PLANNING PROFILE ID       aaaaA6      DEMAND TIME FENCE        nnn
RESOURCE NUMBER           aaaA5      RESOURCE PROFILE BLD CODE  A
                                F05 RETURN TO DETAIL
                                F18 REFRESH
                                F19 RETURN TO SELECT

```

## What to do

To update planning information, type in the requested information and press **Enter**. The Item Balance and/or the Item Plan file is updated with the data you typed in, and the Select display AMI7A1 appears again.

If REP is interfacing with IM, the Repetitive Manufacturing display AMI7A7 appears.

## Function keys

F05 RETURN TO DETAIL causes display AMI7A5 to appear.

F18 REFRESH erases any information you typed in and shows you the display as it first appeared.

F19 RETURN TO SELECT ignores the information you just entered and causes display AMI7A1 to appear again.

## Fields

All of the fields on this display are used for planning warehouses only, except **INCLUDE INVENTORY BALANCE**, which is used for both planning and demand warehouses.

**ITEM NUMBER (ITNB)**. The number of the item you want to maintain.

**WAREHOUSE (WHID)**. A code used to identify the warehouse in which the above item is located.

**ACTIVITY CODE (ACREC)**. The present status of the record shown:

<b>A</b>	Active
<b>D</b>	Deleted
<b>S</b>	Suspended

**DESCRIPTION (ITDSC)**. The description of the item you want to maintain.

The remaining fields on this display are described in their order of appearance on the display, instead of by their order of cursor movement.

**DATE LAST MAINTAINED (MDATE)**. The date this record was last maintained.

**MASTER SCHEDULE ITEM CODE (MSCOD)**. Type in the code used by MPSP (if installed and interfacing) to indicate if this item is a master scheduled item. If you type in M, MPSP plans orders for the item and ignores any requirements generated or entered for it in MRP. MRP uses the orders created by MPSP during the MRP planning run, based on a run-time option in MRP. The available codes are:

<b>blank</b>	Not a master scheduled item
<b>M</b>	Master scheduled item
<b>P</b>	Production family

If the code is blank, and the MLI code is M or S, FCST (if installed and interfacing) uses the forecasting code to determine whether the item is forecast, and what, if anything, is passed to MRP. If the code is M, and FCST is installed and interfacing,

the forecasting code determines whether the item is forecast and whether the forecast is passed to MPSP.

If the code is M, all item type codes are valid, except for F (Feature) or 0 (Phantom). If the code is P, the only valid master level item code is blank and the only valid item type code is 0 (Phantom). Refer to display AMVT02 for a definition of the item type codes.

**Note:** To change a code of M or P to blank, you first must delete the family or family member from the MPSP Production Family Relationship file.

**PRODUCT FAMILY PLANNER (PFPLN).** The user-defined identifier for the person responsible for planning the replenishment strategy for these production families.

**MINIMUM QTY (MINQ).** Type in the minimum order quantity of the item. Any planned order generated by MRP and MPSP that is for a quantity less than the minimum indicated is increased to this minimum number. The default is 0. This field is used only by MRP and MPSP (if installed and interfacing).

**MPS PLANNING SOURCE CODE (MSSR).** Type in the code used by MPSP (if installed and interfacing) to indicate the kind of demand used for generating the master production schedule for this item. The available codes are:

<b>blank</b>	Not used in MPS planning
<b>B</b>	Blended demand (the greater of forecasted demand or customer orders)
<b>C</b>	Customer orders only
<b>D</b>	Blended demand, do not combine customer orders
<b>E</b>	Customer orders only, not combined
<b>F</b>	Forecasts only
<b>M</b>	Manually entered firm planned orders
<b>P</b>	Item production plan

If the master scheduled item code is M, this field cannot be blank.

Codes D and E correspond to B and C except the demand records are kept separately by customer order. Codes B and C combine customer orders for the same item into a single demand quantity. Codes D and E facilitate the tracking of source of demand information by customer order.

**MAXIMUM QTY (MAXQ).** Type in the maximum planned order quantity. If the planned order quantity generated by MRP or MPSP exceeds this maximum, an exception is created to notify the planner, who may want to adjust the order quantity. This field is used only by MRP and MPSP (if installed and interfacing).

**DAYS SUPPLY (NODS).** If the item is planned in MRP, type in the number of days of supply that one order provides.

If MPSP is installed and interfacing, and the item is a master scheduled item with a MPS planning source code of P (production plan), type in the code to set the intervals for ordering this item. This field is used only by MRP and MPSP (if installed and interfacing) if the order policy code is G for this item. The available codes are:

<b>1</b>	Once a week
<b>2</b>	Two times per production planning period
<b>3</b>	One time per production planning period
<b>4</b>	One time per work day.

**MULTIPLE QTY (MULQ).** Type in the factor used by MRP and MPSP (if installed and interfacing) to increase a planned order to a multiple of this quantity. For example, if the planned order was originally for a quantity of 16 and the multiple quantity factor

was 20, the planned order would be increased to 20. If the original quantity was 35, the planned order would be increased to 40. This field is used only by MRP and MPSP (if installed and interfacing).

**FORECASTING CODE (FCSC).** Type in the code used to control forecasting for this item in this warehouse. The available codes are:

- 0** Do not forecast this item.
- 1** Forecast but do not pass to MRP/MPSP.
- 2** Forecast this item. If the master schedule item code (MSIC) is M, pass the forecast to MPSP. If MSIC is blank and the MLI code is M or S, pass the forecast to MRP.
- 3** Forecast this item. If the MSIC is M, pass the forecast to MPSP. If MSIC is blank and the MLI code is M or S, pass both the forecast and the requirement to MRP.

**MASTER LEVEL ITEM CODE (MLIC).** Type in the code used by MRP (if installed and interfacing) to indicate if this item is a master level item and, if so, which requirements to use when planning orders. The available codes are:

- blank** Not a master level item (MLI).
- M** Multiple source MLI. Both planner-entered (manual, held, and propagated) and generated requirements cause planned orders to be created for this item.
- S** Single source MLI. Only planner-entered requirements cause planned orders to be created.

**MASTER LEVEL FCST CODE (Master Level Forecast Code) (MLFC).** Type in the code used by MRP (if installed and interfacing) to indicate if the master level item is to have a forecast propagated in MRP, using the three fields listed below. The available codes are:

- 0** Do not propagate forecast for this item.
- 1** Propagate forecast for this item.
- 2** Propagate requirements equal to forecast for this item.

If FCST is installed and interfacing, you must type in 0. If MRP is installed and interfacing, and the MRP application tailoring option does not allow the forecast to equal requirements, items coded 2 are treated as if they were coded 1. If code 1 or 2 is typed in, the following fields (also defined on the Item Balance File Maintenance displays) must contain nonzero values for propagation to occur:

- **NO OF PERIODS** (Number of Forecast Periods) (FRPD)
- **DAYS/PERIOD** (Days per Forecast Period) (PDDY)
- **FORECAST QTY** (Forecast Quantity) (FRQTY)

**NO OF PERIODS (Number of Forecast Periods) (FRPD).** Type in the number of periods over which this item is to be forecasted in MRP. This field is used only if MRP is installed and interfacing, and applies only to forecasts generated in MRP. If FCST is installed and interfacing, leave this field blank.

**ORDER POLICY CODE (ORDP).** Type in the code used to identify the order policy to be used to plan replenishment orders for this item. The available codes are:

- A** Discrete order quantity
- B** Order point, order quantity
- C** Order point, order up to level
- D** Fixed quantity

- F** Part period balancing – standard cost
- G** Time periods of supply (default)
- H** Discrete above a minimum quantity
- I** Part period balancing – current cost
- Z** User option

If MRP or MPSP are installed and interfacing with IM, items with an order policy code of B or C are not planned. IM treats all items as having a code of B, except those with a code of C. If you leave this field blank, the default of G is assumed. It is recommended that you use the default value of G except for those items for which you have a specific reason to use another code.

Refer to the *Material Requirements Planning User's Guide* for a detailed explanation of order policy codes.

**DAYS/PERIOD (Days per Forecast Period) (PDDY).** Type in the number of days to be contained in each MRP forecast period. This field is used only if MRP is installed and interfacing, and applies only to forecasts generated in MRP. If FCST is installed and interfacing, leave this field blank.

**MASTER LEVEL PRINT CODE (MLPC).** Type in the code used by MRP (if installed and interfacing) to indicate if this item is printed on MRP MLI reports during master level planning runs. The available codes are:

- blank** Always printed.
- L** Printed only if this item's level was planned.
- S** Service usage. Is not printed on MRP MLI reports.

**FORECAST QTY (FRQTY).** Type in the forecast quantity per time period. This field is used by MRP (if installed and interfacing) to propagate forecast quantities when the Master Level Forecast Code is 1 or 2. It identifies the quantity of this item used in the forecast and ranges from 0 through 9,999,999. If FCST is installed and interfacing, this field should be zero. The default is zero.

**MAX # LINES/ITEM (MXLN).** Type in the code used to indicate the maximum number of lines to be printed for this item on the MRP Requirements Planning Report and the MPSP Master Schedule Planning Report. The available codes are:

- blank** 1 page per item
- A** All detail

**FIRM TIME FENCE (FTIM).** Type in the number of days during which orders can be placed and purchase can be committed. The number of days entered is added to the MRP current date to establish this fence. The established time fence is used with the auto release function. This field is used for standard purchase orders and for requisitions.

**PERIOD INTERVAL CODE (PDIN).** Type in the code used by MRP (if installed and interfacing) to indicate how requirements detail is presented on the Requirements Planning report. The available codes are:

- 0** Print full detail.
- 1** Summarize according to the first set of print intervals.
- 2** Summarize according to the second set of print intervals.
- 3** Summarize according to the third set of print intervals.

This code corresponds to the print intervals defined on MRP Period Interval display, AMM120.



**AUTH TIME FENCE (ATIM).** Type in the number of days during which orders can be intended and payment for vendor raw materials can be committed. The number of days entered is added to the MRP current date to establish this fence. The established time fence is used with the auto release function. This field is used for standard purchase orders and for requisitions.

**COMBINE REQUIREMENTS CODE (CMRQ).** Type in the code used by MRP (if installed and interfacing) to indicate if requirements for this item are to be combined during the MRP Requirements Planning run.

**Note:** You are not able to use the pegged-to-requirements function for any items that have combined requirements.

The four combine interval sizes and the five price break literals are defined on MRP Period Interval display, AMM120. Codes 5 through 9 (price break literals) combine requirements according to the fourth period interval.

The price break literals refer to the price break unit of measure constants printed on the MRP Purchase Planning report. The available codes are:

- 0 Do not combine requirements
- 1 Combine interval 1
- 2 Combine interval 2
- 3 Combine interval 3
- 4 Combine interval 4
- 5 Price break literal 5
- 6 Price break literal 6
- 7 Price break literal 7
- 8 Price break literal 8
- 9 Price break literal 9.

**AUTO RELEASE CODE (ATRL).** A code used to define the conditions under which purchase orders or requisitions for this item can be automatically released. This field is used by MRP auto release for planned items and by IM Reorder report for order point items. Type one of the following codes:

- 0 Do not automatically release requisitions or purchase orders.
- 1 Automatically release requisitions without generating a purchase order.
- 2 Automatically release held single purchase orders if the planned order is within the FIRM horizon. The hold from print code must be manually removed in Purchasing before the purchase order is available for printing.
- 3 Automatically release single purchase orders if the planned order is within the FIRM horizon. The purchase orders are available for automatic selection during the purchase order print process. No manual intervention is required.
- 4 Automatically release held blanket purchase orders if the planned order is within the FIRM or AUTHORIZED horizon. The hold from print code must be manually removed in Purchasing before the purchase order is available for printing. Releases can be added to a normal or a fixed blanket order.
- 5 Automatically release blanket purchase orders if the planned order is within the FIRM or AUTHORIZED horizon. The purchase orders are available for automatic selection during the purchase order print process. Releases can be added to a normal or a fixed blanket order.
- 6 Automatically release held fixed blanket purchase orders if the planned order is within the FIRM or AUTHORIZED horizon. The hold from print code must be manually removed in Purchasing before the purchase order is available for printing. A fixed blanket order must already exist with this option.

- 7 Automatically release fixed blanket purchase orders if the planned order is within the FIRM or AUTHORIZED horizon. The purchase orders are available for automatic selection during the purchase order print process. A fixed blanket order must already exist with this option.

**INCLUDE INVENTORY BALANCE (ININ).** Type in one of the following:

- 1 Yes. Include inventory balance of this item/warehouse in MRP planning runs. This is the default.
- 0 No. Do not include inventory balance of this item/warehouse in MRP planning runs.

**CONTRACT REQUIRED CODE.** Type in one of the following:

- 0 Use the value for this warehouse defined on MRP's Planning Run Execution Options panel (AMM151). This is the default. If MRP is not interfacing, a 0 value is treated the same as 1 (which is the default for the field in MRP).
- 1 A contract is required for this item; must be valid and unexpired.
- 2 A contract is not required for this item; however, expired contracts can stop release of the item and a hard error is issued. However, if a valid contract is found, it will be used.
- 3 A contract is not required for this item. The system issues a warning if there are expired contracts, but will create the purchase order or release. If a valid contract is found, it will be used.
- 4 A contract is not required for this contract and the system ignores any contracts.

**SHRINKAGE (SHFC).** Type in the value used by MRP and MPSP (if installed and interfacing) as a multiplier to adjust gross requirements not covered by on-hand quantity to reflect expected material losses.

MRP and MPSP consider both shrinkage and adjusted quantity per (which includes operation yield). Therefore, if you are using operation yield, you probably want a shrinkage factor of zero. Only in cases where there is additional loss of the parent item after production is complete, such as testing or breakage in packaging, do you want to use a shrinkage factor and operation yield.

**ITEM RESCHEDULE CODE (ITRC).** Code used to indicate whether or not orders for the item (by item/warehouse) can be rescheduled automatically by the system.

- 0 Default to warehouse reschedule code
- 1 Cannot be rescheduled automatically
- 2 Can be scheduled out
- 3 Can be scheduled in
- 4 Can be scheduled both out and in

**PRBRK CONV FACTOR (Price Break Conversion Factor) (PBCF).** Type in the factor used by MRP (if installed and interfacing) to convert planning units to purchase units. The factor is described by the price break literal assigned to this item (see "COMBINE REQUIREMENTS CODE (CMRQ)" on page 7-24).

**RESCHEDULE FROZEN ZONE (RSFZ).** Number of days within which production schedules will not be rescheduled, by item/warehouse.

**PLAN CUSTOMER ORDER CODE (CTPO).** Type in one of the following codes:

- 1 Create planned orders equal to all customer orders that fall after the MRP current date.
- 2 Create planned orders for all orders that fall after the release date.
- 3 Create planned orders for all orders that fall after the review date.
- 4 Do not create any planned orders.
- 5 Create planned orders equal to all customer orders that fall after MRP start date.

**MIN DAYS TO RESCHEDULE (MIND).** Specifies the minimum number of days that an order can move in order for it to be rescheduled automatically by the system. The default is 0.

**PLAN EXPECTED ORDER CODE (ETPO).** Type in one of the following codes:

**Blank** Use the value in the Warehouse Master file.

- 0 Do not use expected customer orders in planning.
- A Use only type A (Make) expected customer orders in planning.
- B Use type A (Make) and type B (Buy) expected customer orders in planning.
- C Use type A (Make), type B (Buy), and type C (Firm) expected customer orders in planning.
- D Use type A (Make), type B (Buy), type C (Firm), and type D (Plan) expected customer orders in planning.

**PLANNING PROFILE ID (PSPR) [?].** The user-defined purchase planning profile identifier that was created in MRP for the vendor or item/warehouse.

**DEMAND TIME FENCE(DMDFN).** Type in the number of days that are used by MPSP (if installed and interfacing) as a frozen planning zone in the MPSP master production schedule for this item. During this period, blended demand does not include forecasts until the periods after the fence date, and only customer orders are considered as demand. Any changes to the production schedule during the frozen period should be avoided because they can seriously affect production schedules. This number of days can equal the final assembly lead time (FALT) for this item. The system uses this number to calculate the demand time fence date in the master production schedule for this item.

**RESOURCE NUMBER (RSCNO).** Type in the user-defined number used by MPSP (if installed and interfacing) to identify this item as a critical resource.

**Note:** You must enter the resource number in the MPSP Resource Master file before you can enter it into the Item Plan file.

**RESOURCE PROFILE BLD CODE (RSCBF).** Type in the code used by MPSP (if installed and interfacing) to indicate which items or production families can have resource profiles generated. The available codes are:

- Y Build profile
- N Do not build profile.

## Option 2. Released Schedules (AMQM50)

Use this option to add a component, operation, or discrete allocation to the Released Schedule file, or change or delete a component, operation, or discrete allocation already in the file. You also can substitute components and change summary schedule records. You are not allowed to change the schedule quantity for the item.

If you are increasing the quantity per of a component on a released and primed schedule, the replenishment records will not be changed to reflect the new quantity per automatically. You must either enter replenishment transactions, or delete and re-add the component.

**What information you need:** None.

**What reports are printed:**

- Released Schedule Maintenance Edit List (AMQ5B1)
- Released Schedule Maintenance Edit List — Totals (AMQ5B2).

**What forms you need:** None.

The basic steps to maintain released schedules follow each display.

### AMQ5B1—Released Schedules (Select)

Use this display to select a released schedule for maintenance.

This display appears when you select option 2 on the File Maintenance menu (AMQM50) or when you press **Enter** on display AMQ5B12 or **F19 RETURN TO SELECT** on display AMQ5B2 and AMQ5BZ.

```
DATE **/**/**                RELEASED SCHEDULES                SELECT  AMQ5B1  **

WH aA3  ITEM aaaaaaaaaaaaA15 ***** REVISION aaaaA6
LINE aaaA5 *****
SCHED DATE nnnnnn  SCHEDULE NUMBER nnnnnnn  S-NUMBER aaaaaaaaaaaaaaaaaA20

                                     F24 DISPLAY STATUS
                                     +
```

## What to do

- To select a schedule to maintain, type in the warehouse (the default is the default planning warehouse). Press **Enter**. Next, type in the item to be produced on the schedule. Press **Enter**. Go to display AMQ5B2.
- To see a list of revisions, accept the default of \*ALL. Go to display AMQ5B2.
- To see a list of schedules, leave the schedule number field blank. Display AMQ5BZ appears so you can select the schedule number you want to maintain.
- To end the session or review the status of the file, use **F24**. Go to display AMQ5B12.

## Function keys

F24 DISPLAY STATUS shows you display AMQ5B12 which shows the number of records maintained.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WH (Warehouse) (FITWH) [?]**. Required. This field contains the value of the default planning warehouse. Type in the code of the warehouse from which components are issued and the finished items received.

**ITEM (ITNBR) [?]**. Required. Type in the number of the item you want to add or maintain.

**REVISION (SREVN)** . This field appears only if EPDM is activated. Accept the default of \*ALL to see all revisions. Type \*CUR to see the current revision based on the current system. Type a revision identifier instead of a schedule number to see a specific revision.

**LINE (WKCTR) [?]**. Required. Type in the production line you want to review.

**SCHED DATE (ODUDT)**. Required. Type in the scheduled due date.

**SCHEDULE NUMBER (ORDNO)**. Required. Type in the control number assigned by the system to each schedule in the data base. This number can be entered instead of warehouse, item, line, or schedule date.

**S-NUMBER (SNMBR) [?]**. Type in the features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.



## Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of operations or components.

F01 SUMMARY SCHEDULE shows display AMQ5B3 which allows you to review summary information for the schedule.

F05 ADD COMPONENT shows display AMQ5B4 which allows you to enter a new component for the schedule.

F06 ADD OPERATION shows display AMQ5B9 which allows you to enter a new operation for the schedule.

F09 DATA QUEUE STATUS shows display AMQX31 which allows you to check the status of the data queue.

F11 POSITION TO shows you a window that allows you to choose a specific operation or component to review.

F19 RETURN TO SELECT returns to the Select display (AMQ5B1) so you can select another record.

F22 COMPONENT SUBST shows display AMQ5B6 which allows you to substitute components on the schedule.

F24 DISPLAY STATUS goes to display AMQ5B12 which shows the number of records maintained.

## Fields

**WH (Warehouse) (FITWH).** The warehouse selected on display AMQ5B51.

**ITEM (ITNBR) .** The item number selected on display AMQ5B51.

**REVISION (SREVN).** This field appears only if EPDM is activated. The revision identifier associated with this item.

**LINE (WKCTR).** The production line selected on display AMQ5B51.

**SCHED DATE (ODUDT).** The date the item's schedule is due to be completed.

**SCHEDULE NUMBER (ORDNO).** The control number assigned by the system to each schedule in the data base.

**S-NUMBER (SNMBR).** The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**SEL (Select) (SELWK).** Type in 1 next to each operation or component for the selected schedule.

**ACTIVE (ACFLG).** The code designates a component as being active (Y) or inactive (N).

**OPER (OPERATION) (OPSEQ).** The operation sequence number that identifies the operation detail record.

**COMPONENT (CITEM).** The material used in the production of the scheduled item and the operations shown.

**SEQ (USRSQ).** The user-defined sequence number used to uniquely identify the component.

## AMQ5B3—Released Schedules, Summary Schedule (Change)

Use this display to make changes to the summary record of the released schedule.

This display appears when you select **F01 SUMMARY SCHEDULE SELECT** on display AMQ5B2.

```

DATE **/**/**                RELEASED SCHEDULES          CHANGE    AMQ5B3  **
                              SUMMARY SCHEDULE

WH ***  ITEM *****          *****          REVISION *****
LINE ***** *****
SCHED DATE **/**/**  SCHEDULE NUMBER *****  S-NUMBER *****
SCHED RESCHED CODE   *

SCHEDULED QUANTITY *****.***  SCHEDULE GROUP *****  RUN SEQUENCE ***
ALTERNATE ROUTING CODE          **  ITEM RATE *****.***  P/C *  STATUS          **

SETUP COST      nnnnnnnnnnn.nn-  UNIT COST          nnnnnnnnnnn.nnnnnnnnn-
LABOR COST      nnnnnnnnnnn.nn-  OVERHEAD COST      nnnnnnnnnnn.nn-
ISSUE COST      nnnnnnnnnnn.nn-  SCRAP COST         nnnnnnnnnnn.nn-
RECEIPT COST    nnnnnnnnnnn.nn-  PERIOD RECEIPT COST nnnnnnnnnnnnn.nn-

PLANNER          aaaA5                SITE                ***
DEPARTMENT       aaA4                BOM ID              *****
CUSTOMER JOB     aaaaaaaaaA12         ROUTING ID          *****
REFERENCE NUMBER aaaaaaaA10          VERSION             *****
ENGINEERING DRAWING aaaaaaaaaaaaaA15

                                F03 PREVIOUS DISPLAY
                                F10 SOURCE OF DEMAND
    
```

### What to do

- To change a schedule summary record, type in the information you need. Press **Enter**.
- To cancel what you have done on this display, use **F19**. Go to display AMQ5B1.

### Function keys

**F03 PREVIOUS DISPLAY** shows you the previous display (AMQ5B2).

**F10 SOURCE OF DEMAND** shows you display AMM771 so you can see the source of demand for this schedule.



## Fields

**WH (Warehouse) (FITWH)** The warehouse selected on display AMQ5B1.

**ITEM (ITNBR)**. The item number selected on display AMQ5B1.

**REVISION (SREVN)**. The revision identifier associated with this item. This field appears only if EPDM is activated.

**LINE (WKCTR)**. The production line selected on display AMQ5B1.

**SCHED DATE (ODUDT)**. The date the item's schedule is due to be completed.

**SCHEDULE NUMBER (ORDNO)**. The control number assigned by the system to each schedule in the data base.

**S-NUMBER (SNMBR)**. The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**SCHED RESCHED CODE (Schedule reschedule code) (ORRC)**. The code that defines whether or not this schedule can be rescheduled automatically.

- 0 Default to Item Reschedule code in the ITMPLN file
- 1 Cannot be rescheduled automatically
- 2 Can be rescheduled in
- 3 Can be rescheduled out
- 4 Can be rescheduled out and in

**SCHEDULED QUANTITY (ORQTY)**. The quantity of the item released to production on this schedule.

**SCHEDULE GROUP (ILSEQ)**. A user-defined code used to sequence schedules. It can also identify items that have similar manufacturing characteristics.

**RUN SEQUENCE (RUNSQ)**. A code that determines the sequence in which schedules are run on a production line.

**ALTERNATE ROUTING CODE (fALTCD)**. The Alternate Routing Code determines which additional operations are added to the routing. A default of blank (no select) indicates that only base operations were selected (no additional operations were added).

**ITEM RATE (PCSHR)**. The rate at which items are produced on the production line. Stated in either pieces per hour or cycle time.

**P/C**. Code indicating the contents of the **ITEM RATE** field.

- C Item Rate is expressed as cycle time between pieces.
- P Item Rate is expressed as pieces per hour.

**STATUS (OSTAT)**. The reporting status of an open order or schedule.

- 00 Planned order/schedule not released
- 10 Order/schedule released, not started
- 40 Activity reported (labor and/or material) or order/schedule started
- 55 Order/schedule complete, material and labor

**SETUP COST (SETCO).** Type in the costs associated with preparing a production line for the production of a new item.

**UNIT COST (CSTPC).** Type in the cost per component which the manufacturer is charged to produce a single unit.

**LABOR COST (LABCO).** Type in the cost of labor associated with the production schedule.

**OVERHEAD COST (OVHCO).** Type in costs not reported directly to a schedule.

**ISSUE COST (ISSCO).** Type in the transaction cost of the material issues to a schedule.

**SCRAP COST (SCPCO).** Type in the cost of labor, materials, and overhead incurred in the production of scrapped items.

**RECEIPT COST (RECCO).** Type in the costs associated with completed units that were received on this schedule.

**RECEIPT COST THIS PERIOD (RECTP).** Type in the period-to-date costs associated with completed units that were received on this schedule.

**PLANNER (PLANN).** Type in the code of the person responsible for planning and scheduling this finished item.

**DEPARTMENT (DPTNO).** Type in the department associated with the specific operation.

**CUSTOMER JOB (JOBNO).** Type in the customer order number.

**REFERENCE NUMBER (REFNO).** Type in the user-defined code used to provide additional information.

**ENGINEERING DRAWING (ENGNO).** Type in the unique engineering drawing number assigned to an end product or item.

If EPDM is activated, the following fields appear to provide additional information:

**SITE.** The identifier of the specific site in the EPDM application used as the source of engineering records for this item.

**BOM ID.** The bill of material identifier associated with this item.

**ROUTING ID.** The routing identifier associated with this item.

**VERSION.** The identifier that specifies the version of the routing assigned to this item.

## AMQ5B4—Released Schedules, Component (Add)

Use this display to add new components to a released schedule. When you have added a component to the schedule, the item demand is recalculated. If the schedule has been primed, then replenishment records are generated.

This display appears when you select **F05 ADD COMPONENT** on AMQ5B2 or **F03 PREVIOUS DISPLAY** on display AMQ5B7 or AMQ5B8.

```

DATE **/**/**                RELEASED SCHEDULES          ADD      AMQ5B4  **
                               COMPONENT

WH *** ITEM *****
LINE *****
SCHED DATE **/**/**  SCHEDULE NUMBER *****  S-NUMBER *****

COMPONENT      aaaaaaaaaaA15  SEQ aaA4      REVISION aaaaA6
DESCRIPTION    aaaaaaaaaaA30

OPERATION WHERE USED  aaA4
STOCK LOCATION      aaaaaaA7
ADJ QTY PER         nnnnnnnn.nnnnnnn-
STD QTY PER         nnnnnnnn.nnnnnnn-
UNIT COST           nnnnnnnnnnn.nnnnnnnn-
CUSTOMER JOB NUMBER  aaaaaaaaaA12

LINE LOCATION      aaaaaaA7
FLOOR STOCK CODE < ,C,U>  A
BACKFLUSH CODE    *
COMPONENT ACTIVE <Y,N>   A

F03 PREVIOUS DISPLAY
F10 ALLOCATIONS

```

### What to do

- To add a component record, type in the information you need. Press **Enter**.
- To add a discrete allocation record, use **F10**. Go to display AMQ5B7.
- To return to the previous display, use **F03**. Go to display AMQ5B2.

### Function keys

F03 PREVIOUS DISPLAY shows you the previous display (AMQ5B2).

F10 ALLOCATIONS goes to the Discrete Allocation display (AMQ5B7).

### Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WH (Warehouse) (FITWH)**. Required. The warehouse from which components are issued and the finished items are received.

**ITEM (ITNBR)**. Required. The item number selected on the display AMQ5B1.

**REVISION (SREVN)**. This field appears only if EPDM is activated. The revision identifier associated with this item.

**LINE (WKCTR).** Required. The production line selected on display AMQ5B1.

**SCHED DATE (ODUDT).** Required. The date the item's schedule is due to be completed.

**SCHEDULE NUMBER (ORDNO).** Required. The control number assigned by the system to each schedule in the data base.

**S-NUMBER (SNMBR).** Required. The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**COMPONENT (ITNBR) [?].** Required. Type in the material used in the production of the scheduled item and the operations shown.

**SEQ (USRS1).** Type in the user defined sequence number used to uniquely identify the component.

**REVISION (SREVN).** This field appears only if EPDM is activated. The revision identifier associated with this component. Accept the default of \*CUR or type in a specific revision identifier.

**DESCRIPTION (ITDSC).** Required. Type in the description of the component to be added to the schedule.

**OPERATION WHERE USED (OPRWU).** Type in the operation sequence number Required. that identifies the operation where the component is used.

**STOCK LOCATION (WHSLC).** Required. Type in the default location from which parts are taken to supply production line requirements.

**LINE LOCATION (WHSLC).** Required. Type in the location on the production line where the component is normally delivered.

**ADJ QTY PER (Adjusted quantity per) (QTYPRE).** Required. Type in the quantity (adjusted for yield) of a component required to produce a single unit of the scheduled item.

**STD QTY PER (Standard quantity per) (SQTYE).** Required. Type in the standard quantity (not adjusted for yield) of a component required to produce a single unit of the scheduled item. If you leave this field blank or if the backflush code is 1, the application sets the standard quantity per to equal the adjusted quantity per.

**FLOOR STOCK CODE (FLSTK).** Type in the code that indicates if an item is classified as floor stock.

**Blank** Not floor stock  
**C** Controlled floor stock item  
**U** Uncontrolled floor stock item

Once a schedule is primed (status = 40) the floor stock code cannot be accessed in change mode.

**BACKFLUSH CODE (BFFL).** The code that identifies whether component backflushing for controlled floor stock items is done using the component quantity per adjusted for yield or the standard component quantity per.

- 0** Use the value of the backflush code for the warehouse.
- 1** Use adjusted quantity per to backflush (default).
- 2** Use standard quantity per to backflush.

**UNIT COST (CSTPC).** Type in the cost per component which the manufacturer is charged to produce a single unit.

**COMPONENT ACTIVE <Y,N>.** Required. Type in one of the following:

- Y** The component is active.
- N** The component is not active.

**CUSTOMER JOB NUMBER (JOBNO).** Type in the customer order number.

## AMQ5B5—Released Schedules, Component (Change/Delete)

Use this display to make changes to existing components for a released schedule.

This display appears after selecting a component on display AMQ5B2 or when you press **Enter** on display AMQ5B5 (in delete mode) or AMQ5B10, or use **F20 DELETE COMPONENT** on display AMQ5B5 (in delete mode).

```

DATE **/**/**                RELEASED SCHEDULES          *****  AMQ5B5  **
                               COMPONENT

WH ***  ITEM *****
LINE **** *****
SCHED DATE **/**/**  SCHEDULE NUMBER *****  S-NUMBER *****

COMPONENT *****  SEQ ****  REVISION *****
DESCRIPTION aaaaaaaaaaaaaaaaaaaaaaaaaA30

OPERATION WHERE USED aaA4                REQUIRED DATE          *****
STOCK LOCATION       aaaaaa7             LINE LOCATION         aaaaaa7
ADJ QTY PER          nnnnnnnn.nnnnnnn-   FLOOR STOCK CODE < ,C,U> A
STD QTY PER          nnnnnnnn.nnnnnnn-   BACKFLUSH CODE       *
UNIT COST            nnnnnnnnnnn.nnnnnnn- COMPONENT ACTIVE <Y,N> A
CUSTOMER JOB NUMBER aaaaaaaaaA12

                                           F10 ALLOCATIONS
                                           F19 RETURN TO SELECT
                                           F20 DELETE COMPONENT
    
```

### What to do

- To change a component, type in the information you need. Press **Enter** to update the records.
- To change a discrete allocation, use **F10**. Go to display AMQ5B8.
- To delete a component, type in the information you need. Use **F20** to delete the component.
- To delete a discrete allocation, use **F10**. Go to display AMQ5B8.

- To return to the previous display, use **F19**. Go to display AMQ5B2.

## Function keys

F10 ALLOCATIONS goes to the Discrete Allocation (Add) display (AMQ5B7) if no allocations exist. If allocations exist, F10 ALLOCATIONS goes to the Discrete Allocations (Change) display (AMQ5B8).

F19 RETURN TO SELECT returns to the Select display (AMQ5B2) so you can select another record.

F20 DELETE COMPONENT deletes the component record from the schedule and causes display AMQ5B5 to appear again.

## Fields

**WH (Warehouse) (FITWH)**. Required. The warehouse from which components are issued and the finished items are received.

**ITEM (ITNBR)**. Required. The item number selected on display AMQ5B1.

**REVISION (SREVN)**. This field appears only if EPDM is activated. The revision identifier associated with this item.

**LINE (WKCTR)**. Required. The production line selected on display AMQ5B1.

**SCHED DATE (ODUDT)**. Required. The date the item's schedule is due to be completed.

**SCHEDULE NUMBER (ORDNO)**. Required. The control number assigned by the system to each schedule in the data base.

**S-NUMBER (SNMBR)**. Required. The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**COMPONENT (ITNBR)**. Required. The material used in the production of the scheduled item and the operations shown.

**SEQ (USRS1)**. The field indicates the product structure sequence used for the component.

**REVISION (SREVN)**. This field appears only if EPDM is activated. The revision identifier associated with this component.

**DESCRIPTION (ITDSC)**. Required. The description of the component to be added to the schedule.

**OPERATION WHERE USED (OPRWU)**. Required. The operation sequence number that identifies the operation where the component is used.

**REQUIRED DATE (REQDT)**. Required. The date that the component is required for the production of the scheduled item.

**STOCK LOCATION (WHSLC).** Required. The default location from which parts are taken to supply production line requirements.

**LINE LOCATION (WHSLC).** Required. The location on the production line where the component is normally delivered.

**ADJ QTY PER (Adjusted quantity per) (QTYPRE).** Required. The quantity (adjusted for yield) of a component required to produce a single unit of the scheduled item. If you leave this field blank and enter a standard quantity per in that field, the application calculates a new adjusted quantity per.

**STD QTY PER (Standard quantity per) (SQTYE).** Required. The standard quantity (not adjusted for yield) of a component required to produce a single unit of the scheduled item.

**FLOOR STOCK CODE (FLSTK).** The code that indicates if an item is classified as floor stock.

**Blank** Not floor stock  
**C** Controlled floor stock item  
**U** Uncontrolled floor stock item

**BACKFLUSH CODE (BFFL).** The code that identifies whether component backflushing for controlled floor stock items is done using the component quantity per adjusted for yield or the standard component quantity per.

**0** Use the value of the backflush code for the warehouse.  
**1** Use adjusted quantity per to backflush (default).  
**2** Use standard quantity per to backflush.

**UNIT COST (CSTPC).** The cost per component which the manufacturer is charged to produce a single unit.

**COMPONENT ACTIVE <Y,N>.** Required. Type in one of the following:

**Y** The component is active.  
**N** The component is not active.

**CUSTOMER JOB NUMBER (JOBNO).** Type in the customer order number.

## AMQ5B6—Released Schedules, Component Substitution (Change)

Use this display to substitute components on a released schedule. When you use this function, a new component is added to the schedule and the old component is deactivated after the cut-off quantity for the old component is met. The fields below New Component Description are not shown until you enter correct old and new components. After you substitute a component, item demand is recalculated. If the schedule has been primed, replenishment records are generated.

This display appears when you select **F22 COMPONENT SUBST** on display AMQ5B2.

```

DATE **/**/**                RELEASED SCHEDULES                CHANGE    AMQ5B6  **
                              COMPONENT SUBSTITUTION

WH ***  ITEM *****
LINE *****
SCHED DATE **/**/**  SCHEDULE NUMBER *****  S-NUMBER *****

OLD COMPONENT *****  SEQ ****  CUTOFF QUANTITY nnnnnnn.nnn

NEW COMPONENT aaaaaaaaaaA15  SEQ aaA4  REVISION aaaaA6
DESCRIPTION   aaaaaaaaaaA30

OPERATION WHERE USED  aaA4                REQUIRED DATE                *****
STOCK LOCATION        aaaaaA7             LINE LOCATION              aaaaaA7
ADJ QTY PER           nnnnnnnn.nnnnnnn-   FLOOR STOCK CODE < ,C,U>  A
STD QTY PER           nnnnnnnn.nnnnnnn-   BACKFLUSH CODE             *
UNIT COST             nnnnnnnnnn.nnnnnnn-

CUSTOMER JOB NUMBER  aaaaaaaaaA12

                                F03 PREVIOUS DISPLAY
                                F10 ALLOCATIONS

```

### What to do

- To substitute a component, type in the information you need. Press **Enter**. The substitution is made and you are returned to display AMQ5B2.
- To return to the previous display, use **F03**. Go to display AMQ5B2.

### Function keys

F03 PREVIOUS DISPLAY shows you the previous display (AMQ5B2).

F10 ALLOCATIONS goes to the Discrete Allocations (Change) display (AMQ5B8) if allocations exist, or to the Discrete Allocation (Add) display (AMQ5B7) if no allocations exist.

### Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WH (Warehouse) (FITWH)**. Required. The warehouse from which components are issued and the finished items are received.



**ITEM (ITNBR).** Required. The item number selected on display AMQ5B1.

**REVISION (SREVN).** This field appears only if EPDM is activated. The revision identifier associated with this item.

**LINE (WKCTR).** Required. The production line selected on display AMQ5B1.

**SCHED DATE (ODUDT).** Required. The date the item's schedule is due to be completed.

**SCHEDULE NUMBER (ORDNO).** Required. The control number assigned by the system to each schedule in the data base.

**S-NUMBER (SNMBR).** Required. The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**OLD COMPONENT (ITNBR) [?].** The component that was selected on display AMQ5B2.

**SEQ (USRS1).** The product structure sequence used for the old component.

**CUTOFF QUANTITY.** Required. Type in the quantity of the item that you want to make using the old component. After this quantity is completed, the new component is used.

**NEW COMPONENT (ITNBR) [?].** Required. Type in the component to be substituted in the bill of material for this schedule.

**SEQ (USRS1).** The sequence number from the old component appears, but you can change it.

**REVISION (SREVN).** This field appears only if EPDM is activated. The revision identifier associated with this component. Accept the default of \*CUR or type in a specific revision identifier.

**DESCRIPTION (ITDSC).** Required. Type in the description of the component to be added to the schedule.

**OPERATION WHERE USED (OPRWU).** Required. Type in the operation sequence number that identifies the operation where the component is used.

**REQUIRED DATE (REQDT).** Required. Type in the date that the component is required for the production of the scheduled item.

**STOCK LOCATION (WHS LC).** Required. Type in the default location from which parts are taken to supply production line requirements.

**LINE LOCATION (WHS LC).** Required. Type in the location on the production line where the component is normally delivered.

**ADJ QTY PER (Adjusted quantity per) (QTYPRE).** Required. Type in the quantity (adjusted for yield) of a component required to produce a single unit of the scheduled item.

**STD QTY PER (Standard quantity per) (SQTYE).** Required. Type in the standard quantity (not adjusted for yield) of a component required to produce a single unit of the scheduled item. If you leave this field blank or if the backflush code is 1, the application sets the standard quantity per to equal the adjusted quantity per.

**FLOOR STOCK CODE (FLSTK).** Type in the code that indicates if an item is classified as floor stock.

- Blank** Not floor stock
- C** Controlled floor stock item
- U** Uncontrolled floor stock item

**BACKFLUSH CODE (BFFL).** The code that identifies whether component backflushing for controlled floor stock items is done using the component quantity per adjusted for yield or the standard component quantity per.

- 0** Use the value of the backflush code for the warehouse.
- 1** Use adjusted quantity per to backflush (default).
- 2** Use standard quantity per to backflush.

**UNIT COST (CSTPC).** Type in the cost per component which the manufacturer is charged to produce a single unit.

**CUSTOMER JOB NUMBER (JOBNO).** Required. Type in the customer order number.

## AMQ5B7—Released Schedules, Discrete Allocation (Add)

Use this display to allocate inventory in specific locations to this schedule. The inventory is used to replenish the production line when the schedule is run.

This display appears when you select **F10 ALLOCATIONS** on display AMQ5B4, AMQ5B5, or AMQ5B6, or when you select **F05 ADD ALLOCATION** on display AMQ5B8.

DATE **/**/**	RELEASED SCHEDULES DISCRETE ALLOCATION		ADD	AMQ5B7	**
WH ***	ITEM *****			REVISION *****	
LINE *****					
SCHED DATE **/**/**	SCHEDULE NUMBER *****	S-NUMBER *****			
COMPONENT *****			REVISION *****		
REQUIRED *****	ALLOCATED *****	UNALLOCATED *****			
LOCATION	QUANTITY TO ALLOCATE	QUANTITY AVAILABLE	LOCATION QUANTITY	BATCH/LOT	FIFO
*****	nnnnnnn.nnn	*****.***	*****.***	*****	**/**/**
*****	nnnnnnn.nnn	*****.***	*****.***	*****	**/**/**
*****	nnnnnnn.nnn	*****.***	*****.***	*****	**/**/**
*****	nnnnnnn.nnn	*****.***	*****.***	*****	**/**/**
*****	nnnnnnn.nnn	*****.***	*****.***	*****	**/**/**
*****	nnnnnnn.nnn	*****.***	*****.***	*****	**/**/**
*****	nnnnnnn.nnn	*****.***	*****.***	*****	**/**/**
*****	nnnnnnn.nnn	*****.***	*****.***	*****	**/**/**
*****	nnnnnnn.nnn	*****.***	*****.***	*****	**/**/**
		USE ROLL UP/DOWN	F07 CHANGE ALLOCATIONS		
		F03 PREVIOUS DISPLAY	F11 POSITION TO		
				+	

```

                                     DISCRETE ALLOCATION
=====
WH ***  ITEM *****
LINE *****
SCHED DATE **/**/**  SCHEDULE NUMBER *****  S-NUMBER=====
                                     POSITION TO
                                     LOC aaaaaA7
                                     BATCH/LOT aaaaaaaA10

```

**What to do**

To add a discrete allocation record, type in the information you need. Press **Enter**.

**Function keys**

USE ROLL UP/ROLL DOWN scrolls up and down through the pages of allocations.

F03 PREVIOUS DISPLAY shows you the previous display (AMQ5B4, AMQ5B5, or AMQ5B6).

F07 CHANGE ALLOCATIONS goes to the Discrete Allocation (Change) display (AMQ5B8).

F11 POSITION TO shows you a window that allows you to search for a specific location or batch/lot.

**Fields**

**WH (Warehouse) (FITWH).** The warehouse from which components are issued and the finished items are received.

**ITEM (ITNBR).** The item number selected on display AMQ5B1.

**REVISION (SREVN).** This field appears only if EPDM is activated. The revision identifier associated with this item.

**LINE (WKCTR).** The production line selected on display AMQ5B1.

**SCHED DATE (ODUDT).** The date the item’s schedule is due to be completed.

**SCHEDULE NUMBER (ORDNO).** The control number assigned by the system to each schedule in the data base.

**S-NUMBER (SNMBR).** The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**COMPONENT (CITEM).** The material used in the production of the scheduled item and the operations shown.

**REVISION (SREVN).** This field appears only if EPDM is activated. The revision identifier associated with this component.

**REQUIRED (DAREQ).** The quantity of the component needed to produce the scheduled quantity of the finished item.

**ALLOCATED (DAALO).** The quantity currently reserved at the location.

**UNALLOCATED (DAUNA).** The quantity currently not allocated at the location.

**LOCATION (LLOCN).** The location of the item in the warehouse.

**QUANTITY TO ALLOCATE (LALQY).** Type in the number of parts reserved for a schedule for a specific location.

**QUANTITY AVAILABLE (DAAVL).** The quantity not already allocated from this specific location.

**LOCATION QUANTITY (LQNTY).** The actual quantity onhand for the specific location.

**BATCH/LOT (LBHNO).** The batch/lot number assigned to an item lot received into inventory.

**FIFO (First In First Out) (FDATE).** The date an item lot was received into inventory. FIFO dates appear if you select FIFO support during application tailoring.

### AMQ5B8—Released Schedules, Discrete Allocation (Change)

Use this display to change existing discrete allocations for specific components in the schedule. The inventory is used to replenish the production line when the schedule is run.

This display appears when you select **F10 ALLOCATIONS** on display AMQ5B4, AMQ5B5, or AMQ5B6, or when you select **F07 CHANGE ALLOCATIONS** on display AMQ5B7.

DATE **/**/**	RELEASED SCHEDULES DISCRETE ALLOCATION			CHANGE	AMQ5B8	**
WH ***	ITEM *****	*****	*****	*****	REVISION	*****
LINE *****	*****					*****
SCHED DATE **/**/**	SCHEDULE NUMBER *****	S-NUMBER *****	*****			
COMPONENT *****	*****	*****	*****	*****	REVISION *****	*****
REQUIRED *****	*****	ALLOCATED *****	*****	UNALLOCATED *****	*****	*****
LOCATION	QUANTITY TO ALLOCATE	QUANTITY AVAILABLE	LOCATION QUANTITY	BATCH/LOT	FIFO	
*****	nnnnnnn.nnn	***** .***	***** .***	*****	**/**/**	
*****	nnnnnnn.nnn	***** .***	***** .***	*****	**/**/**	
*****	nnnnnnn.nnn	***** .***	***** .***	*****	**/**/**	
*****	nnnnnnn.nnn	***** .***	***** .***	*****	**/**/**	
*****	nnnnnnn.nnn	***** .***	***** .***	*****	**/**/**	
*****	nnnnnnn.nnn	***** .***	***** .***	*****	**/**/**	
*****	nnnnnnn.nnn	***** .***	***** .***	*****	**/**/**	
*****	nnnnnnn.nnn	***** .***	***** .***	*****	**/**/**	
*****	nnnnnnn.nnn	***** .***	***** .***	*****	**/**/**	+
				F03 PREVIOUS DISPLAY		
				F05 ADD ALLOCATION		
				USE ROLL UP/DOWN		+

## What to do

- To change a discrete allocation, type in the information you need. Press **Enter** to update records.
- To delete a discrete allocation, type in **0** in the **Quantity to Allocate** field. Press **Enter** to delete allocations.
- To delete additional operation descriptions, type in **2** to designate the record for deletion. Press **Enter** to delete records.

## Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of allocations.

F03 PREVIOUS DISPLAY shows you the previous display (AMQ5B4, AMQ5B5, or AMQ5B6).

F05 ADD ALLOCATIONS goes to the Discrete Allocation (Add) display (AMQ5B7).

## Fields

**WH (Warehouse) (FITWH)**. The warehouse from which components are issued and the finished items are received.

**ITEM (ITNBR)**. The item number selected on display AMQ5B1.

**REVISION (SREVN)**. This field appears only if EPDM is activated. The revision identifier associated with this item.

**LINE (WKCTR)**. The production line selected on display AMQ5B1.

**SCHED DATE (ODUDT)**. The date the item's schedule is due to be completed.

**SCHEDULE NUMBER (ORDNO)**. The control number assigned by the system to each schedule in the data base.

**S-NUMBER (SNMBR)**. The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**COMPONENT (CITEM)**. The material used in the production of the scheduled item and the operations shown.

**REVISION (SREVN)**. This field appears only if EPDM is activated. The revision identifier associated with this component.

**REQUIRED (DAREQ)**. The quantity of the component needed to produce the scheduled quantity of the finished item.

**ALLOCATED (DAALO)**. The quantity currently reserved at the location.

**UNALLOCATED (DAUNA)**. The quantity currently not allocated at the location.

**LOCATION (LLOCN)**. The location of the item in the warehouse.

**QUANTITY TO ALLOCATE (LALQY).** Type in the number of parts reserved for a schedule for a specific location.

**QUANTITY AVAILABLE (DAAVL).** The quantity not already allocated from this specific location.

**LOCATION QUANTITY (LQNTY).** The actual quantity onhand for the specific location.

**BATCH/LOT (LBHNO).** The batch/lot number assigned to an item lot received into inventory.

**FIFO (First In First Out) (FDATE).** The date an item lot was received into inventory. FIFO dates appear if you select FIFO support during application tailoring.

## AMQ5B9—Released Schedules, Operations (Add)

Use this display to add operations to the released schedule. You can create a new operation by typing in all of the information required, or you can copy an existing operation.

This display appears when you select **F06 ADD OPERATION** on AMQ5B2.

DATE **/**/**	RELEASED SCHEDULES OPERATIONS	ADD	AMQ5B9	**
WH ***	ITEM *****		REVISION	*****
LINE *****	*****			
SCHED DATE **/**/**	SCHEDULE NUMBER *****	S-NUMBER *****		
COPY ROUTING ID aaaaaaaaaaA15 VERSION aaaaA6 FROM OPER aaA4				
OPER aaA4 aaaaaaaaaaA20				
REPORTING POINT <Y,N>	A	CURRENT OPERATION YIELD	n.nnn	
OPERATION ACTIVE <Y,N>	A	WORK CENTER	aaaA5	
STD SETUP LABOR HRS	nnn.nn	STD SETUP LABOR RATE	nnnnn.nnn	
STD RUN MACHINE HRS	nnnnn.nn	STD MACHINE RATE	nnnnn.nnn	
STD RUN LABOR HRS	nnnnn.nn	STD RUN LABOR RATE	nnnnn.nnn	
		OPER RUN QTY	nnnn.nnn	
REWORK FLAG <Y,N>	A	TIME BASIS CODE	A	
DEPARTMENT	aaA4	ACCOUNTING CLASS	aA3	
PROCESS SHEET	aaaaA6	OUTSIDE COST	nnnnnnnnn.nnnn	
TOOL NUMBER	aaaaA6			
		F03 PREVIOUS DISPLAY		
		F22 ADDL OPERATION DESC		
		F23 COPY OPERATION		
				+

### What to do

- To add an operation record, type in the information you need. Press **Enter**.
- To add additional operation description, use **F22**. Go to display AMQ5B11.

### Function keys

F03 PREVIOUS DISPLAY shows you the previous display (AMQ5B2).

F22 ADDL OPERATION DESC goes to Additional Operation Description display AMQ5B11 if you selected additional operation descriptions during application tailoring.

F23 COPY OPERATION allows you to copy an operation from an existing routing.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WH (Warehouse) (FITWH).** The warehouse from which components are issued and the finished items are received.

**ITEM (ITNBR).** The item number selected on display AMQ5B1.

**REVISION (SREVN).** This field appears only if EPDM is activated. The revision identifier associated with this item.

**LINE (WKCTR).** The production line selected on display AMQ5B1.

**SCHED DATE (ODUPT).** The date the item's schedule is due to be completed.

**SCHEDULE NUMBER (ORDNO).** The control number assigned to each schedule in the data base by the system.

**S-NUMBER (SNMBR).** The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**COPY ROUTING ID.** Required. Type in the routing identifier for this item. This field appears only if EPDM is activated.

**COPY VERSION.** Required. Type in the version identifier for this routing. This field appears only if EPDM is activated.

**FROM OPER.** Type in the operation sequence number of the operation you want to copy. Leave this blank if you do not want to copy an operation. Select **F23 COPY OPERATION** to complete entry.

**OPER (Operation) (OPSEQ).** Required. Type in the operation sequence number that identifies the new operation detail record.

**REPORTING POINT (IRCOD).** Required. Type in the code that identifies an operation where transactions can be reported.

**Y** Reporting point  
**N** Not a reporting point

**CURRENT OPERATION YIELD (CYTOP).** Required. Type in the percentage of good units produced in the operation. The value is used to calculate a cumulative yield for the routing. It is also used to recalculate a required quantity and planned scrap quantity for each component on the schedule.

**OPERATION ACTIVE <Y,N> (AGFLG).** Required. Type in the code that designates an operation as being active or inactive.

**Y** Active  
**N** Inactive

**WORK CENTER (WKCTR) [?]**. Type in one to five alphanumeric characters representing the work centers or production lines within each department.

**STD SETUP LABOR HRS (SSLHU)**. Type in the standard setup labor time (in hours) for a manufacturing operation.

**STD SETUP LABOR RATE (SSLAB)**. Type in the standard set up labor rate (in dollars). It is used to calculate the standard setup labor cost.

**STD RUN MACHINE HRS (SRMHU)**. Type in the standard run machine time (in hours) per unit, times the scheduled quantity.

**STD MACHINE RATE (SMACH)**. Type in the standard machine rate (in dollars) per hour. It is used to calculate the standard run machine cost.

**STD RUN LABOR HRS (SRLHU)**. Type in the standard run labor time (in hours) per unit, times the scheduled quantity.

**STD RUN LABOR RATE (SRLAB)**. Type in the standard run labor rate (in dollars) per hour.

**OPER RUN QTY**. Required. Type in the number of units that the operation produces.

**TIME BASIS CODE (TBCOD)**. Type in the code to indicate the relationship between standard operation run unit time and expected operation quantities. The code is used to determine standard operation run labor hours and run machine hours.

**blank** Hours per unit  
**C** Cost per piece (outside operation)  
**H** Hours per lot size  
**P** Pieces per hour  
**M** Minutes per piece  
**1** Hours per 10 units  
**2** Hours per 100 units  
**3** Hours per 1000 units  
**4** Hours per 10000 units

**REWORK FLAG <Y,N> (REWRK)**. Required. Type in the code that identifies if the operation is for rework.

**Y** Rework operation  
**N** Not a rework operation

**DEPARTMENT (DPTNO)**. Type in the department associated with the specific operation.

**ACCOUNTING CLASS**. Class, defined by your company, to group or classify orders for accounting purposes.

**PROCESS SHEET (PRONO)**. Type in the process sheet number used to identify the detailed instruction for the operation. The actual process sheet is kept outside of the data base.



**OUTSIDE COST (OSCS).** The cost per piece charged by the vendor to produce the item. This field is used when the time basis code is C.

**TOOL NUMBER (TOOLS).** Type in the number assigned to a specific tool or list of tools needed to perform the operation. The control of special tools is done outside of the data base.

## AMQ5B10—Released Schedules, Operations (Change)

Use this display to change or delete operations for a specific schedule. If you are activating an inactive operation record or deleting an operation, the new cumulative yield and operation start dates are calculated for all operations in the schedule. All components are also updated with a required quantity, planned scrap quantity, and component need dates. Replenishment records and item demand is recalculated for each component.

This display appears after you select an operation on display AMQ5B2 or AMQ5B5, or when you select **F03 PREVIOUS DISPLAY** on display AMQ5B11 or AMQ5B10 (delete mode).

```

DATE **/**/**                RELEASED SCHEDULES          *****   AMQ5B10 **
                              OPERATIONS

WH ***  ITEM *****
LINE **** *****
SCHED DATE **/**/**  SCHEDULE NUMBER *****  S-NUMBER *****

OPER ****  aaaaaaaaaaaaaaaaaA20

REPORTING POINT <Y,N>      A          CURRENT OPERATION YIELD      n.nnn
OPERATION ACTIVE <Y,N>    A          WORK CENTER                aaaA5
STD SETUP LABOR HRS       nnn.nn    STD SETUP LABOR RATE       nnnnn.nnn
STD RUN MACHINE HRS       nnnnn.nn  STD MACHINE RATE           nnnnn.nnn
STD RUN LABOR HRS        nnnnn.nn  STD RUN LABOR RATE         nnnnn.nnn
OPER RUN QTY              nnnn.nnn

REWORK FLAG <Y,N>        A          TIME BASIS CODE            A
DEPARTMENT                aaA4    ACCOUNTING CLASS           aA3
PROCESS SHEET            aaaaA6    OUTSIDE COST               nnnnnnnnn.nnnn
TOOL NUMBER              aaaaA6

                                F19 RETURN TO SELECT
                                F20 DELETE OPERATION
                                F22 ADDL OPERATION DESC
                                +

```

### What to do

- To change an operation, type in the information you need. Press **Enter** to update records.
- To delete an operation, type in the information you need. Use **F20** to delete the operation.
- To delete or maintain additional operation description, use **F22**. Go to display AMQ5B11.

### Function keys

F19 RETURN TO SELECT returns to the Select display (AMQ5B2) so you can select another record.

F20 DELETE OPERATION deletes the operation record from the routing.

F22 ADDL OPERATION DESC goes to the Additional Operation Description display (AMQ5B11) if you selected additional operation description during application tailoring.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WH (Warehouse) (FITWH).** The warehouse from which components are issued and the finished items are received.

**ITEM (ITNBR).** The item number selected on the previous display.

**REVISION (SREVN).** This field appears only if EPDM is activated. The revision identifier associated with this item.

**LINE (WKCTR).** The production line selected on the previous display.

**SCHED DATE (ODUPT).** The date the item's schedule is due to be completed.

**SCHEDULE NUMBER (ORDNO).** The control number assigned by the system to each schedule in the data base.

**S-NUMBER (SNMNR).** The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**OPER (Operation) (OPSEQ).** The operation sequence number that identifies the new operation detail record.

**REPORTING POINT (IRCOD).** Required. Type in the code that identifies an operation where transactions can be reported.

**Y** Reporting point  
**N** Not a reporting point

**CURRENT OPERATION YIELD (CYTOP).** Required. Type in the percentage of good units produced in the operation. The value is used to calculate a cumulative yield for the routing. It is also used to recalculate a required quantity and planned scrap quantity for each component on the schedule.

**OPERATION ACTIVE <Y,N> (AGFLG).** Required. Type in the code that designates an operation as being active or inactive.

**Y** Active  
**N** Inactive

**WORK CENTER (WKCTR) [?].** Type in one to five alphanumeric characters representing the work centers or production lines within each department.

**STD SETUP LABOR HRS (SSLHU).** Type in the standard setup labor time (in hours) for a manufacturing operation.

**STD SETUP LABOR RATE (SSLAB).** Type in the standard set up labor rate (in dollars). It is used to calculate the standard setup labor cost.

**STD RUN MACHINE HRS (SRMHU).** Type in the standard run machine time (in hours) per unit, times the scheduled quantity.

**STD MACHINE RATE (SMACH).** Type in the standard machine rate (in dollars) per hour. It is used to calculate the standard run machine cost.

**STD RUN LABOR HRS (SRLHU).** Type in the standard run labor time (in hours) per unit, times the scheduled quantity.

**STD RUN LABOR RATE (SRLAB).** Type in the standard run labor rate (in dollars) per hour.

**OPER RUN QTY.** Required. Type in the number of units that the operation produces.

**TIME BASIS CODE (TBCOD).** Type in the code to indicate the relationship between standard operation run unit time and expected operation quantities. The code is used to determine standard operation run labor hours and run machine hours.

<b>blank</b>	Hours per unit
<b>C</b>	Cost per piece (outside operation)
<b>H</b>	Hours per lot size
<b>P</b>	Pieces per hour
<b>M</b>	Minutes per piece
<b>1</b>	Hours per 10 units
<b>2</b>	Hours per 100 units
<b>3</b>	Hours per 1000 units
<b>4</b>	Hours per 10000 units

**REWORK FLAG <Y,N> (REWRK).** Required. Type in the code that identifies if the operation is for rework.

<b>Y</b>	Rework operation
<b>N</b>	Not a rework operation

**DEPARTMENT (DPTNO).** Type in the department associated with the specific operation.

**ACCOUNTING CLASS.** Class, defined by your company, to group or classify orders for accounting purposes.

**PROCESS SHEET (PRONO).** Type in the process sheet number used to identify the detailed instruction for the operation. The actual process sheet is kept outside of the data base.

**OUTSIDE COST (OSCS).** The cost per piece charged by the vendor to produce the item. This field is used when the time basis code is C.

**TOOL NUMBER (TOOLS).** Type in the number assigned to a specific tool or list of tools needed to perform the operation. The control of special tools is done outside of the data base.

# AMQ5B11—Released Schedules, Additional Operation Description (Change)

Use this display to add, change, or delete additional operation description records.

This display appears when you select **F22 ADDL OPERATION DESC** on display AMQ5B9 or AMQ5B10 if additional operation description was selected during tailoring.

```

DATE **/**/**                RELEASED SCHEDULES                CHANGE    AMQ5B11 **
                        ADDITIONAL OPERATION DESCRIPTION

WH ***  ITEM *****
LINE *****
SCHED DATE **/**/**  SCHEDULE NUMBER *****  S-NUMBER *****
OPER **** *****

              SEQ NBR          ADDITIONAL DESCRIPTION
              ***              aaaaaaaaaaaaaaaaaaaaaaaA40
              ***              aaaaaaaaaaaaaaaaaaaaaaaA40
              ***              aaaaaaaaaaaaaaaaaaaaaaaA40
              ***              aaaaaaaaaaaaaaaaaaaaaaaA40
              ***              aaaaaaaaaaaaaaaaaaaaaaaA40
              ***              aaaaaaaaaaaaaaaaaaaaaaaA40
              ***              aaaaaaaaaaaaaaaaaaaaaaaA40
              ***              aaaaaaaaaaaaaaaaaaaaaaaA40
              ***              aaaaaaaaaaaaaaaaaaaaaaaA40
              ***              aaaaaaaaaaaaaaaaaaaaaaaA40
              ***              aaaaaaaaaaaaaaaaaaaaaaaA40
              ***              aaaaaaaaaaaaaaaaaaaaaaaA40
              ***              aaaaaaaaaaaaaaaaaaaaaaaA40
              ***              aaaaaaaaaaaaaaaaaaaaaaaA40
              ***              aaaaaaaaaaaaaaaaaaaaaaaA40
              ***              aaaaaaaaaaaaaaaaaaaaaaaA40
              ***              aaaaaaaaaaaaaaaaaaaaaaaA40
              +

SEQUENCE NUMBER  nnn
ADD/DELETE <1,2> n

                          USE ROLL UP/DOWN
                          F03 PREVIOUS DISPLAY
                          +
    
```

### What to do

To add or maintain additional operation descriptions, type in the information you need. Press **Enter** to update the data.

### Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of additional descriptions.

F03 PREVIOUS DISPLAY shows you the previous display (AMQ5B9 or (AMQ5B10).

### Fields

**WH (Warehouse) (FITWH).** The warehouse from which components are issued and the finished items are received.

**ITEM (ITNBR).** The item number selected on display AMQ5B1.

**REVISION (SREVN).** This field appears only if EPDM is activated. The revision identifier associated with this item.

**LINE (WKCTR).** The production line selected on display AMQ5B1.

**SCHED DATE (ODUDT).** The date the item's schedule is due to be completed.

**SCHEDULE NUMBER (ORDNO).** The control number assigned by the system to each schedule in the data base.

**S-NUMBER (SNMBR).** The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**OPER (Operation) (OPSEQ).** The operation sequence number that identifies the operation detail record.

**SEQ NBR (DSQNO).** The sequence for the text records associated with the specific operation.

**ADDITIONAL DESCRIPTION (ADDSC).** Type in your changes to the additional description detail for the operation.

**SEQUENCE NUMBER (DSQNO).** Type in the sequence number associated with the line of text that you want to add or delete.

**ADD/DELETE <1,2>(SELWK).** Type in the code to perform the function you want to do:

- 1 Add line of text
- 2 Delete line of text

## AMQ5B12—Released Schedules (Status)

Use this display to show the number of records added, changed, or deleted during the maintenance function.

This display appears when you select **F24 DISPLAY STATUS** on display AMQ5B1 or AMQ5B2.

DATE **/**/**	RELEASED SCHEDULES	STATUS	AMQ5B12 **
FILE NAME		RECORDS ADDED	RECORDS CHANGED RECORDS DELETED
MOMAST	SCHEDULE MASTER		** , ***
MODATA	SCHEDULE DETAIL	** , ***	** , *** ** , ***
MOROUT	SCHEDULE OPERATIONS	** , ***	** , *** ** , ***
MODESC	OPERATION DESCRIPTION	** , ***	** , *** ** , ***
SLQNTY	LOCATION QUANTITY		** , ***
SLALLO	ALLOCATION QUANTITY	** , ***	** , *** ** , ***
RPLMNT	REPLENISHMENT	** , ***	** , *** ** , ***
CMPSTS	COMPONENT STATUS	** , ***	** , *** ** , ***
F24 END OF JOB			

## What to do

- To return to the previous display, press **Enter**. Go to display AMQ5B1 or AMQ5B2.
- To end the session and print the Released Schedule Maintenance Edit List (AMQ5B), use **F24**.

## Function keys

F24 END OF JOB places the audit report (AMQ5B) on the job queue, and shows you the File Maintenance menu (AMQM50) again so you can choose another file to maintain or end the file maintenance activity.

## Fields

**SCHEDULE MASTER RECORDS CHANGED.** The number of MOMAST records changed during the session.

**SCHEDULE DETAIL RECORDS ADDED, CHANGED, DELETED.** The number of component records added, changed, or deleted during the session.

**SCHEDULE OPERATIONS RECORDS ADDED, CHANGED, DELETED.** The number of routing operations records added, changed, or deleted during the session.

**OPERATION DESCRIPTION RECORDS ADDED, CHANGED, DELETED.** The number of operation description records added, changed, or deleted during the session.

**LOCATION QUANTITY RECORDS CHANGED.** The number of location quantity records changed during the session.

**ALLOCATION QUANTITY RECORDS ADDED, CHANGED, DELETED.** The number of allocation quantity records added, changed, or deleted during the session.

**REPLENISHMENT RECORDS ADDED, CHANGED, DELETED.** The number of replenishment records added, changed, or deleted during the session.

**COMPONENT STATUS RECORDS ADDED, CHANGED, DELETED.** The number of component status records added, changed, or deleted during the session.

# AMQX31—Data Queue Transaction Status (Inquiry)

Use this display to check the status of the data transaction queue.

This display appears when you select **F09 DATA QUEUE STATUS** on display AMQ5B2.

```

DATE **/**/**          *****          INQUIRY   AMQX31  **
                        DATA QUEUE TRANSACTION STATUS
DATA QUEUE *****          STATUS *****          JOB NAME *****
*****          *****          JOB NUMBER *****

  TRAN          SCHED
  DATE          DATE          NBR
**/**/** **:**:** ** ***** ** ** ***** **/**/** *****
*****          *****
**/**/** **:**:** ** ***** ** ** ***** **/**/** *****
*****          *****
**/**/** **:**:** ** ***** ** ** ***** **/**/** *****
*****          *****
**/**/** **:**:** ** ***** ** ** ***** **/**/** *****
*****          *****
**/**/** **:**:** ** ***** ** ** ***** **/**/** *****
*****          *****

                                F12 ADDITIONAL FIELDS +
                                F18 REFRESH DISPLAY   +
                                USE ROLL UP/DOWN

```

### What to do

- To see additional fields, use **F12**. To return to the original display format, use **F12** again.
- To exit this display, press **Enter**. Go to display AMQ5B2.

### Function keys

USE ROLL UP/DOWN scrolls up and down through the pages of locations.

F12 ADDITIONAL FIELDS allows you to review any associated S-numbers for items. Using **F12** a second time returns you to the original format. This key appears if you chose features/options support during PDM/EPDM tailoring.

F18 REFRESH DISPLAY shows the display again with the current status of the transaction data queue.

### Fields

**DATA QUEUE (UJDQN/UJDSC)**. The name and description of the data queue.

**STATUS (UJCST)**. The current status (ACTIVE, HELD, or ENDED) of the unattached job.

**JOB NAME (UJPGM)**. The name assigned to the job.

**JOB NUMBER (UJNBR).** The number assigned to the job.

**TRAN DATE (UPDDT).** The date the transaction was submitted to the data queue.

**TIME (UPDTM).** The time the transaction was submitted to the data queue.

**WS (WKSID).** The ID of the submitting work station.

**USER ID (USERN).** The code assigned to the person who entered the transaction.

**TR (TCODE).** The code of the transaction.

<b>RM</b>	Schedule receipts
<b>RO</b>	Operation reporting
<b>SM</b>	Schedule scrap
<b>01</b>	Recalculate Cumulative Yield/Dates
<b>02</b>	Recalculate Quantities

**WH (Warehouse) (HOUSE).** The warehouse from which components are issued and the finished items are received.

**LINE (PLINE).** The production line selected on the previous display.

**ITEM (FITEM).** The number and description of the item selected on the previous display.

**S-NUMBER (SNMBR).** The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**SCHED DATE (ODUDT).** The date the item's schedule is due to be completed.

**SCHED NBR (ORDNO).** The control number assigned by the system to each schedule in the data base.



---

## Option 3. Work With Item/Line (AMQM50)

Use this option to access the Work With Item/Line Definitions panels so you can define or review what products are to be built, and which production lines are used to build these products.

### Item/Line panels

- AMQWIL01—Work with Item/Line Definitions
- AMQSIL00—Subset Item/Line Definitions
- AMQAIL01—Create Item/Line Definition
- AMQCIL01—Change Item/Line Definition
- AMQRIL01—Confirm Delete of Item/Line Definitions
- AMQDIL01—Display Item/Line Definition

### Component/Line panels

- AMQWCL01—Work with Component/Line Definitions
- AMQSCL00—Subset Component/Line Definitions
- AMQCCL01—Change Component Line Item Definition
- AMQCCL02—Mass Change

See Chapter 9, “Work with Repetitive” for more information on using the Work With panels.

---

## Option 4. Production Facility (AMQM50)

Use this option to add a new facility to the Production Facility file, change or delete a facility already in the file, change cost information for multiple facilities, or make temporary changes to the capacity of an applicable facility.

**Notes:**

1. You can maintain production facility information in the Production Facility file only if you selected the Production Facility file during application tailoring.
2. When EPDM is activated, file maintenance to the Production Facility file must be done from EPDM.
3. Variable capacity information can apply only to work centers and production lines.

**What information you need:** None.

**What reports are printed:** One or two of the following reports are printed, depending on the option you choose:

- Production Facility Maintenance (AMVT7)
- Production Facility Percent Change Audit Report (AMET8)
- Variable Capacity Maintenance (AMVTC)

**What forms you need:** None.

The basic steps to maintain production facility information follow each display.

## AMVT70—Production Facility Maintenance (Select)

Use this display to type the ID of the production facility you want to make changes to and select the action you want to take.

This display appears when you select option 3 on the PDM File Maintenance menu (AMEM05), option 5 on the PM&C File Maintenance menu (AMJM50), option 5 on the PCC File Maintenance menu (AMCM70), option 4 on the REP File Maintenance menu (AMQM50), or option 4 on the CRP Planning Run Control menu (AMTM10).

```

DATE **/**/**      PRODUCTION FACILITY MAINTENANCE      SELECT      AMVT70  **

                                     ENTER--
                                     FACILITY ID  aaaA5
                                     ACTION        A

SELECT ONE OF THESE ACTIONS
1 ADD
2 CHANGE
3 DELETE
4 PERCENT CHANGE OF COST RATES
5 VARIABLE CAPACITY

                                     F23 STATUS
                                     F24 END OF JOB
    
```

### What to do

- To select a production facility and the type of maintenance you want to perform, type in the requested information and press **Enter**. Go to one of the following displays, depending on which type of maintenance you selected:

Action	Display
1 (Add)	AMVT71
2 (Change)	AMVT72
3 (Delete)	AMVT73
4 (Percent change)	AMVT74
5 (Variable capacity)	AMVTC1

- To review the status of or end the session, use **F23**. Go to display AMVT75.
- To end the session and schedule the Production Facility Maintenance report (AMVT7) and the Production Facility Percent Change Audit report (AMET8) for printing, use **F24**.

## Function keys

F23 STATUS causes the Production Facility Maintenance (Status) display (AMVT75) to appear.

F24 END OF JOB ends the session and schedules the reports to be printed. The menu appears again.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**FACILITY ID (WKCTR) [?]**. Required except for Action 4. Type in a facility ID for all actions except 4.

**ACTION**. Required. Select and type in one of the following action codes:

- 1 Add a facility record.
- 2 Change a facility record.
- 3 Delete a facility record.
- 4 Change cost rate percentages.
- 5 Maintain Variable Capacity information.

Use option 5 only if REP or CRP is installed.

## AMVT71—Production Facility Maintenance (Add)

Use this display to add production facility records to the Production Facility file.

This display appears when you type in a facility ID and select action 1 (add) on display AMVT70.

DATE **/**/**	PRODUCTION FACILITY MAINTENANCE				ADD	AMVT71 **
FACILITY ID *****		FACILITY TYPE A		*****		
DESCRIPTION aaaA40						
DEPARTMENT	aaA4	PN FAC ACTG CLS	aA3	QUEUE TIME-DAYS	nn.nn	
FOREMAN	aA3	PRIME LOAD CODE	A	AVG QUEUE TIME	nnnnn.nn	
LOCATION	aaaA5	TRACKING SIGNAL	nnnnn.nn	QUEUE MAD	nnnnn.nn	
STD EFFICIENCY	n.nn	AVG STD OUTPUT	nnnnn.nn	MACH RESOURCE NO.	aaaA5	
AVG EFFICIENCY	n.nn	AVG ACTL OUTPUT	nnnnn.nn	LABOR RESOURCE NO.	aaaA5	
EXTRACT MACH BRKS	A	REPORTING METHOD	n	CLOCKING WINDOW	n:nn	
	MACHINE RATE	RUN LABOR RATE	SETUP LABOR RATE	OVERHEAD RATE/PERCENT	OVERHEAD CODE	
CURRENT	nnnnn .nnn	nnnnn .nnn	nnnnn .nnn	nnnnn .nnn	A	
STANDARD	nnnnn .nnn	nnnnn .nnn	nnnnn .nnn	nnnnn .nnn	A	
	----LENGTH----		----CAPACITY----		CALENDAR ID	aaaaaaaA10
	DESIRED	MAXIMUM	DESIRED	MAXIMUM	POST TO OLDEST SCHED	A
SHIFT 1	nn.n	nn.n	nn.n	nn.n		
SHIFT 2	nn.n	nn.n	nn.n	nn.n	POST TO FUTURE SCHED	A
SHIFT 3	nn.n	nn.n	nn.n	nn.n	FACILITY STOCK LOC aaaaaA7	
					F19 RETURN TO SELECT	

## What to do

To add a production facility to the Production Facility file, type in the information requested and press **Enter**. Go to display AMVT70.

## Function keys

F19 RETURN TO SELECT ignores any data you typed in and causes display AMVT70 to appear again.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

Fields that show historical statistics are updated by Production Control and Costing (PC&C), if it is installed and interfacing.

Three queue statistics (average queue time, queue MAD, and tracking signal) are updated every time PC&C prints the Production Facility Analysis report, when PC&C closes out and purges an order, or when work list generation is run.

Three output statistics (average standard output, average efficiency, and average actual output) can be updated when PC&C closes out and purges orders.

**FACILITY ID (WKCTR)**. The ID of the facility you are adding to the Production Facility file. If the time basis code is C, this ID represents a vendor (or group of vendors).

**FACILITY TYPE (WLNCD)**. This field appears only if REP is installed. Type a code that indicates the kind of information you are adding:

**blank** Work center  
**1** Production line  
**2** Work station.

**Facility Type Description**. This field has no heading and appears to the immediate right of **FACILITY TYPE**. It contains a verbal description of the code in the **FACILITY TYPE** field, such as **WORK CENTER**, **WORK STATION**, or **PRODUCTION LINE**.

**DESCRIPTION (WCDSC)**. Required. Type in a description of the production facility.

**DEPARTMENT (DEPNO)**. Type in the department where this facility is located. If Payroll is installed and interfacing, this number should correspond to the department in Payroll's Labor Distribution file.

**Note:** A single department can have multiple facilities.

**PN FAC ACTG CLS (PFAC)**. Class, defined by your company, to group or classify orders or items by production facility for accounting purposes.

**QUEUE TIME-DAYS (STDQT)**. Type in the expected number of days a job waits in the queue at this facility before work begins on it.

**FOREMAN (FRMAN)**. Type in the code that identifies the foreman for this facility.

**PRIME LOAD CODE (PLOAD).** Type in the prime load code for this facility. The prime load code is used to calculate the duration of the operation for PC&C and CRP scheduling routines. It identifies the critical (constraining) operation time factors necessary to schedule each operation's due date from its operation start date. The valid codes are:

- 0 No hours accumulated
- 1 Run machine hours
- 2 Setup labor hours divided by setup crew size
- 3 (Setup labor hours divided by setup crew size) + run machine hours
- 4 Run labor hours
- 5 (Setup labor hours divided by setup crew size) + run labor hours

**AVG QUEUE TIME (Average Queue Time) (AVGQT).** Type in the average total standard hours of work in the queue at this facility.

**LOCATION (WCLOC).** Type in the code that indicates the location of the facility. If the time basis code is C, this is the location of the vendor.

**TRACKING SIGNAL (TRSIG).** Type in the tracking signal for this facility. The tracking signal, which is used by PC&C, is the sum of the differences of current queue time from old average queue time that is calculated with each running of the Production Facility Analysis report.

**QUEUE MAD (QUEUE MEAN ABSOLUTE DEVIATION) (WQMAD).** Type in the average difference of the queue at this facility. The queue mean absolute deviation, which is used by PC&C, is an average of the differences between the current queue within a facility and the old average queue of that facility. This shows how much the queue fluctuates in the facility.

**Note:** A negative amount is made positive when you press **Enter**.

**STD EFFICIENCY (Standard Efficiency) (STDEF).** Type in the standard efficiency of the facility. It should reflect the expected value of average actual output divided by average standard output.

**Note:** A negative amount is made positive when you press **Enter**.

**AVG STD OUTPUT (Average Standard Output) (AVGSO).** Type in the average standard output of this facility. The average standard output is an average of the standard time (hours) produced per day per period (PC&C order close out) at a facility. The standard hours are based on standard times from the detail operations performed in the facility.

**Note:** A negative amount is made positive when you press **Enter**.

**MACH RESOURCE NO. (MACRN) [?].** Type in the resource number used by MPSP (if installed and interfacing) to identify machine hours in this facility as a critical resource; for example, a machine that affects major work flow in a facility. If MPSP is not installed, leave this field blank or type in 0 (zero).

**Note:** You must enter the machine resource number in the MPSP Resource Master file before you can enter it into the Production Facility file.

**AVG EFFICIENCY (Average Efficiency) (AVGEF).** Type in the average efficiency of this facility. The average efficiency is the average of the actual hours worked per day for this period divided by the average standard output per day for this period.

**Note:** A negative amount is made positive when you press **Enter**.

**AVG ACTL OUTPUT (Average Actual Output) (AVGAO).** Type in the average actual output of this facility. The average actual output is the average of the actual time (hours) worked per day for this period (PC&C order close out) at a facility.

**Note:** A negative amount is made positive when you press **Enter**.

**LABOR RESOURCE NO. (LABRN) [?].** Type in the resource number used by MPSP (if installed and interfacing) to identify labor hours in this facility as a critical resource. For example, a facility with limited available labor hours because of workers with special skills. If MPSP is not installed, leave this field blank or type in **0** (zero).

**Note:** You must enter the Labor Resource Number in the MPSP Resource Master file before you can enter it into the Production Facility file.

**EXTRACT MACH BRKS (BRKXT) <1/0>.** Required. Type in the letter that indicates to the PM&C application whether you want to extract break time from machine hours. The valid entries are:

- 1** Extract break time.
- 0** Do not extract break time.

Only the standard rates of the following five fields are discussed. The other fields are the same except that current rates are used.

**REPORTING METHOD.** Type in the method used at the facility for reporting job transactions in PM&C. The values for the methods are:

- 0** ON/OF reporting. Both ON (On) and OF (Off) transactions are required for each job. Jobs completed without both transactions are flagged as errors.
- 1** Off-Only reporting with full ON override. OF transactions are required for each job. ON transactions are optional. If a job starts with an ON transaction, all information is used from the ON transaction. If an ON transaction does not exist, start times for the job are calculated from previous OF and T/A transactions. All other information is used from the OF transaction.
- 2** Off-Only reporting with ON facility ID override. OF transactions are required for each job. ON transactions are optional. If the job starts with an ON transaction, the only information used from the ON transaction is the facility ID. All other information is used from the OF transaction. Start times are always calculated from previous OF and T/A transactions (even if an ON transaction exists).

**CLOCKING WINDOW.** The clocking window time defined in PM&C for facilities using off-only reporting to group jobs that run concurrently and apportion time among those jobs. If the facility uses off-only reporting and jobs are run concurrently by the same employee, type in a clocking window time. The system groups jobs that have OF transactions spaced equal to or less than the clocking window time and apportions the time among them. For example, if you set the clocking window to 5:00 (five minutes) and OF transactions occur at 10:00:00, 10:03:00, and 10:06:00 (less than five minutes apart), the system treats the group as if they were started and completed at the same time and apportions the time among them.

The time can be any value from 0:00 to 9:59 (one second less than ten minutes). Use the default time (0:00) to have the jobs treated as if they were run consecutively.

**CURRENT  
STANDARD.**

**MACHINE RATE (CMACH or SMACH):** This rate, in cost per hour, is used with the run machine field of the associated routing to calculate the run machine cost. If the time basis code is C, this field should be zero. PDM product costing also uses this value to calculate labor overhead content this-level in the associated Item Master B-records.

**RUN LABOR RATE (CRLAB or SRLAB):** This rate, in cost per hour, is used with the run labor field of the associated routing to calculate the run labor cost. PDM product costing also uses this value to calculate standard labor and labor overhead content this-level in the associated Item Master B-records. This field is not used in calculating run labor costs for routing operations with time basis code = C (outside operation).

**SETUP LABOR RATE (CSLAB or SSLAB):** This rate, in cost per hour, is used with the setup labor hours field of the associated routing to calculate the setup labor cost. If the time basis code is C, this field should be zero in most cases. PDM product costing also uses this value to calculate labor and labor overhead content this-level in the associated Item Master B-records.

**OVERHEAD RATE/PERCENT (COVER or SOVER):** The labor overhead rate or percent is used in the labor overhead calculation of PDM costing formulas based on the labor overhead code (COCOD or SOCOD) you enter. If the time basis code is C, this field should be zero.

**OVERHEAD CODE (SOCOD):** This code indicates which of four methods (A, B, C, or D) is used to calculate standard labor overhead this level in the associated Item Master B-records. If the time basis code is C, this field should be blank. PDM product costing must be installed and interfacing, and the cost technique code in associated Item Master B-records must be R if this code is used.

**Note:** A negative amount is made positive when you press **Enter**.

**SHIFT LENGTH.** If this is a production line, at least one shift length is required.

**DESIRED (DLEN1, DLEN2, DLEN3):** These fields, which are used in scheduling calculations, show the number of prime load code hours normally available for the duration of shifts 1, 2, or 3 for this facility.

**MAXIMUM (MLEN1, MLEN2, MLEN3):** These fields show the maximum number of prime load code hours available for the duration of shifts 1, 2, or 3 for this facility.

**Note:** A negative amount is made positive when you press **Enter**.

**SHIFT CAPACITY.**

**DESIRED (DCAP1, DCAP2, DCAP3):** These fields, which are used in scheduling calculations, show the number of workers or machines (whichever is the critical resource) normally scheduled at this facility during shifts 1, 2, or 3.

**MAXIMUM (MCAP1, MCAP2, MCAP3):** These fields show the maximum number of workers or machines that can be scheduled at this facility during shifts 1, 2, or 3.

**Note:** A negative amount is made positive when you press **Enter**.



**CALENDAR ID (CALN) [?].** The identifier of the production calendar associated with this facility. This field is used by REP to explicitly define the days a production line is available for work.

**POST TO OLDEST SCHED (APSQ).** Appears if REP is interfacing. Type a code that indicates how you want to apply RM, RO, and SM transaction quantities. The valid codes are:

- blank** Defaults to the setting in the REPCTL record.
- 0** Off, posting is by individual schedules for all items on this production line.
- 1** On, multi-schedule posting, beginning with the oldest schedule, is used for all items on this production line.

**POST TO FUTURE SCHED (APTQ).** Appears if REP is interfacing. Type a code that indicates how you want to apply RM, RO, and SM transaction quantities. The valid codes are:

- blank** Defaults to the setting in the REPCTL record.
- 0** Off, post to past and current schedules on this production line.
- 1** On, post to past, current, and future schedules on this production line.

**FACILITY STOCK LOC (FSLC).** If the facility is a workstation, this field represents the line location where items are delivered and used in a production line operation. If the facility is a production line, then this field represents the stocking location where finished goods are stored. This field is used by REP as a default line location when setting up the Item-Line definition for a schedule controlled item.

## AMVT72—Production Facility Maintenance (Change)

Use this display to change an existing production facility record in the Production Facility file.

This display appears when you type in a valid facility ID and select action 2 (change) on display AMVT70.

DATE **/**/**	PRODUCTION FACILITY MAINTENANCE				CHANGE	AMVT72	**
FACILITY ID *****		FACILITY TYPE A		*****			
DESCRIPTION		aaA40					
DEPARTMENT	aaA4	PN FAC ACTG CLS	aA3	QUEUE TIME-DAYS	nn.nn		
FOREMAN	aA3	PRIME LOAD CODE	A	AVG QUEUE TIME	nnnn.nn		
LOCATION	aaaA5	TRACKING SIGNAL	nnnnn.nn	QUEUE MAD	nnnnn.nn		
STD EFFICIENCY	n.nn	AVG STD OUTPUT	nnnnn.nn	MACH RESOURCE NO.	aaaA5		
AVG EFFICIENCY	n.nn	AVG ACTL OUTPUT	nnnnn.nn	LABOR RESOURCE NO.	aaaA5		
EXTRACT MACH BRKS	A	REPORTING METHOD	n	CLOCKING WINDOW	n:nn		
	MACHINE	RUN LABOR	SETUP LABOR	OVERHEAD	OVERHEAD		
	RATE	RATE	RATE	RATE/PERCENT	CODE		
CURRENT	nnnnn . nnn	nnnnn . nnn	nnnnn . nnn	nnnnn . nnn	A		
STANDARD	nnnnn . nnn	nnnnn . nnn	nnnnn . nnn	nnnnn . nnn	A		
	-----LENGTH-----		-----CAPACITY-----				
	DESIRED MAXIMUM		DESIRED MAXIMUM		CALENDAR ID	aaaaaaA10	
SHIFT 1	nn.n nn.n		nn.n nn.n		POST TO OLDEST SCHED	A	
SHIFT 2	nn.n nn.n		nn.n nn.n		POST TO FUTURE SCHED	A	
SHIFT 3	nn.n nn.n		nn.n nn.n		FACILITY STOCK LOC	aaaaaA7	
					F18 REFRESH SCREEN		
					F19 RETURN TO SELECT		

## What to do

To change a production facility record, type in the information you want to change and press **Enter**. Go to display AMVT70.

## Function keys

F18 REFRESH SCREEN erases any data you typed in and shows AMVT72 as it first appeared.

F19 RETURN TO SELECT ignores any data you typed in and causes display AMVT70 to appear again.

## Fields

Any of the fields, except **FACILITY ID**, entered using display AMVT71 can be changed using this display. For descriptions of these fields, see 'AMVT71—Production Facility Maintenance (Add)'.

## AMVT73—Production Facility Maintenance (Delete)

Use this display to delete a production facility record from the Production Facility file.

This display appears when you type in a valid facility ID and select action 3 (delete) on display AMVT70.

```

DATE **/**/**      PRODUCTION FACILITY MAINTENANCE      DELETE      AMVT73  **
FACILITY ID *****      FACILITY TYPE *      *****
DESCRIPTION *****

DEPARTMENT      ****      PN FAC ACTG CLS      ***      QUEUE TIME-DAYS      **. **
FOREMAN      ***      PRIME LOAD CODE      *      AVG QUEUE TIME      ***** **
LOCATION      *****      TRACKING SIGNAL      ***** **      QUEUE MAD      ***** **
STD EFFICIENCY      *. **      AVG STD OUTPUT      ***** **      MACH RESOURCE NO.      *****
AVG EFFICIENCY      *. **      AVG ACTL OUTPUT      ***** **      LABOR RESOURCE NO.      *****
EXTRACT MACH BRKS      *      REPORTING METHOD      *      CLOCKING WINDOW      *: **

MACHINE      RUN LABOR      SETUP LABOR      OVERHEAD      OVERHEAD
RATE      RATE      RATE      RATE/PERCENT      CODE
CURRENT      **, ** . ***      **, ** . ***      **, ** . ***      **, ** . ***      *
STANDARD      **, ** . ***      **, ** . ***      **, ** . ***      **, ** . ***      *

-----LENGTH-----      -----CAPACITY-----
DESIRED MAXIMUM      DESIRED MAXIMUM      CALENDAR ID      *****
SHIFT 1      **. *      **. *      **. *      **. *      POST TO OLDEST SCHED      *
SHIFT 2      **. *      **. *      **. *      **. *      POST TO FUTURE SCHED      *
SHIFT 3      **. *      **. *      **. *      **. *      FACILITY STOCK LOC      *****
P R E S S      E N T E R      T O      D E L E T E      F19 RETURN TO SELECT
    
```

## What to do

To delete a production facility from the Production Facility file, press **Enter**. The record is flagged for deletion. Go to display AMVT70.

## Function keys

F19 RETURN TO SELECT does not delete the record and causes display AMVT70 to appear again.

## Fields

All of the fields on this display are informational only. For descriptions of the fields on this display, see 'AMVT71—Production Facility Maintenance (Add)'.

## AMVT74—Production Facility Maintenance (Change)

Use this display to change cost information for multiple production facility records in the Production Facility file.

This display appears when you type in a valid facility ID and select action 4 (percent change of cost rates) on display AMVT70.

You can select the rate you want to change (setup labor, run labor, machine labor, or labor overhead—current and/or standard) and the percent change you want to use. Only one percent change (the last one you entered if you entered more than one) is processed at a time.

```

DATE **/**/**          PRODUCTION FACILITY MAINTENANCE          CHANG%  AMVT74  **

                                ENTER--
                                RATE TYPE   n
                                % CHANGE    nnn.nn
SELECT ONE OF THESE RATE TYPES  COST TYPE   A
1 SETUP LABOR RATE
2 RUN LABOR RATE
3 MACHINE RATE
4 OVERHEAD RATE/PERCENT

SELECT ONE OF THESE COST TYPES
C CURRENT
S STANDARD
B BOTH

                                F19 RETURN TO SELECT

```

## What to do

To change cost information for multiple production facility records, type in the information requested and press **Enter**. The percent change you entered is applied to the rate you selected when the session ends. Go to display AMVT70.

## Function keys

F19 RETURN TO SELECT ignores the data you just entered and causes display AMVT70 to appear again.

## Fields

**RATE TYPE.** Required. Type in one of the following rate types:

- 1 Setup Labor Rate
- 2 Run Labor Rate
- 3 Machine Rate
- 4 Overhead Rate/Percent.

**% CHANGE.** Required. Type in the percent change you are applying to the selected rate. The percent change is the difference between the current rate and the target rate, divided by the current rate. Use a positive value to increase the current rate or a negative value to decrease it.

Only one percent change (the last one you entered if you entered more than one) is processed at a time.

**COST TYPE.** Required. Type in one of the following cost types:

- C Current
- S Standard
- B Both.

## AMVT75—Production Facility Maintenance (Status)

This display appears when you use **F23** on the Select display (AMVT70). The Production Facility Maintenance Control Sheet prints after you update the Production Facility file using file maintenance.

The following statistics should be the same on the display and the report:

- 1. Maintenance number and update number
- 2. Adds entered and facilities added
- 3. Changes entered and facilities changed
- 4. Deletes entered and facilities deleted.

DATE **/**/**	PRODUCTION FACILITY MAINTENANCE	STATUS	AMVT75	**
SESSION STATISTICS				
[1]	MAINTENANCE NUMBER	10		
[2]	ADDS ENTERED	1		
[3]	CHANGES ENTERED	1		
[4]	DELETES ENTERED	1		
	TOTAL TRANSACTIONS	3		
F24 END OF JOB				

## What to do

- To end the session and schedule the Production Facility Maintenance report (AMVT7) for printing, use **F24**. The menu appears again.
- To return to the previous display, press **Enter**.

## Function keys

F24 END OF JOB causes the menu to appear again.

## Fields

All of the fields on this display are informational.

**SESSION STATISTICS.** These fields show the statistics for the current file maintenance session

**MAINTENANCE NUMBER:** The number assigned to this session.

**ADDS ENTERED:** The number of records added.

**CHANGES ENTERED:** The number of records changed.

**DELETES ENTERED:** The number of records deleted.

**TOTAL TRANSACTIONS:** The total number of transactions (adds, changes, and deletes) for this file maintenance session.

## AMVTC1—Variable Capacity Maintenance (Select)

Use this display to select a facility and the type of maintenance to be performed on its variable capacity records.

This display appears when you select option 2 on CRP menu AMTM10, or when you select action 5 on the Production Facility Maintenance (Select) display (AMVT70) or when you use **F19** (Return to Select) on displays AMVTC2, AMVTC3, AMVTC4, or AMVTC5.

If EPDM is activated, this display and the following displays are disabled in PDM and CRP. If you try to access these displays, you will receive an error message.

**Note:** This display appears only if CRP is installed and interfacing.

```

DATE **/**/**          VARIABLE CAPACITY MAINTENANCE          SELECT          AMVTC1  **

ENTER:  ACTION              A
        SITE                aA3
        FACILITY ID         aaaA5
        START DATE (OPTIONAL) nnnnnn
        RECORDS TO REVIEW   A

SELECT ONE OF THESE ACTIONS:
1 - ADD
2 - CHANGE
3 - DELETE
9 - DELETE ALL PRODUCTION FACILITY VARIABLE CAPACITY

SELECT TYPE OF RECORDS TO REVIEW DURING MAINTENANCE:
1 - REVIEW SHIFT LENGTH CHANGE RECORDS ONLY
2 - REVIEW RESOURCE CHANGE RECORDS ONLY
3 - REVIEW ALL VARIABLE CAPACITY RECORDS

F23 DISPLAY STATUS
    
```

### What to do

- To select a production facility and the type of maintenance you want to perform on the variable capacity records, type in the requested information and press **Enter**. Go to one of the following displays, depending on which type of maintenance you selected:

Action	Display
1 (Add)	AMVTC2
2 (Change)	AMVTC3
3 (Delete)	AMVTC4
9 (Delete all))	AMVTC5

**Note:** **FACILITY ID**, as used in field descriptions for variable capacity maintenance, refers to both production lines and work centers if Repetitive Production Management (REP) is installed and interfacing. Otherwise, it refers to work centers only.

- To review the status of and end the session, use **F23**.

## Function keys

F23 DISPLAY STATUS causes the Variable Capacity Maintenance (Status) display (AMVTC6) to appear.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**ACTION (ACTON).** Required. Select and type in one of the following actions:

- 1 Add
- 2 Change
- 3 Delete
- 9 Delete all production facility variable capacity.

**SITE (STID) [?].** Type in the site identifier for the production facility to be maintained. This field appears only if EPDM is activated.

**FACILITY ID (WKCTR) [?].** Required. Type in the ID of the production facility to be maintained.

**START DATE (STDAT).** This field allows you to type in the date that the review is to begin. If no date is entered, the earliest variable capacity start date is used.

**RECORDS TO REVIEW (INCLU).** Required. This field allows you to specify the type of records to be reviewed for possible maintenance.

Type in one of the following numbers:

- 1 Review shift length change records only.
- 2 Review resource change records only.
- 3 Review all variable capacity records.

## AMVTC2—Variable Capacity Maintenance (Add)

Use this display to add variable capacity records for work centers or production lines. (You can work with production lines only if Repetitive Production Management is installed and interfacing.)

This display appears when you select action A (Add) on the Variable Capacity Maintenance (Select) display (AMVTC1) or when you use **F04 (Add)** on either display AMVTC3 or AMVTC4.

```

DATE **/**/**          VARIABLE CAPACITY MAINTENANCE      ADD      AMVTC2  **
SITE ***

*****  *****  DESCRIPTION *****

      START NBR  -SHIFT LENGTH-  -RESOURCE UNITS-
      DATE  DAYS  1    2    3    1    2    3  SOURCE DESCRIPTION
- TOP OF DATA -  **.* **.* **.* **.* **.* **.* **.* ***** BASE VALUES
**/**/** ** **.* **.* **.* **.* **.* **.* **.* *****
**/**/** ** **.* **.* **.* **.* **.* **.* **.* *****
**/**/** ** **.* **.* **.* **.* **.* **.* **.* *****
**/**/** ** **.* **.* **.* **.* **.* **.* **.* *****
**/**/** ** **.* **.* **.* **.* **.* **.* **.* *****
**/**/** ** **.* **.* **.* **.* **.* **.* **.* *****
**/**/** ** **.* **.* **.* **.* **.* **.* **.* *****
**/**/** ** **.* **.* **.* **.* **.* **.* **.* *****
      ONLY RECORDS WITH ***** CHANGES SHOWN

ADD RECORD
START DATE      nnnnnn
NUMBER OF DAYS  nn      SHIFT 1  SHIFT 2  SHIFT 3  USE ROLL UP/DOWN
NEW SHIFT LENGTH nn.n   nn.n     nn.n     nn.n     F01 RESTART FACILITY
INCREMENTAL RESOURCE nn.n-  nn.n-   nn.n-   F05 CHANGE RECORDS
SOURCE DESCRIPTION aaaaaaaaaaaaaaaaaaaaaaA25  F06 DELETE RECORDS
                                                    F19 RETURN TO SELECT
                                                    F23 DISPLAY STATUS
  
```

### What to do

- To add a variable capacity record, type in the information requested and press **Enter**. The record you just added is shown on the top half of the display.
- To see the variable capacity records for the production facility from the beginning, use **F01**.
- To change a variable capacity record for a production facility, use **F05**. Go to display AMVTC3.
- To delete a variable capacity record for a production facility, use **F06**. Go to display AMVTC4.
- To review the status of and end the session, use **F23**. Go to display AMVTC6.

### Function keys

USE ROLL UP/DOWN allows you to scroll forward and backward through the variable capacity records associated with this facility if the word CONTINUED appears. If END OF DATA appears, no additional records exist and the first page of records is shown.

F01 RESTART FACILITY shows all variable capacity records for this facility starting with the first based on the Include for Review code entered on Select display AMVTC1.



F05 CHANGE RECORDS causes the Variable Capacity Maintenance (Change) display (AMVTC3) to appear.

F06 DELETE RECORDS causes the Variable Capacity Maintenance (Delete) display (AMVTC4) to appear.

F19 RETURN TO SELECT causes the Variable Capacity Maintenance (Select) display (AMVTC1) to appear.

F23 DISPLAY STATUS causes the Variable Capacity Maintenance (Status) display (AMVTC6) to appear.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**SITE (STID)**. This field contains the site identifier of the facility. This field appears only if EPDM is activated.

**Facility Identifier (WKCTR)**. This field appears below the date and site, without a heading, and contains the ID of the facility you entered on display AMVTC1. If the facility is a work center, the field heading is WORK CENTER ID; otherwise the heading is PRODUCTION LINE.

**DESCRIPTION (WCDSC)**. This field contains the description of the facility.

**START DATE (VDATE)**. This field contains the date the variable capacity is due to start.

**NBR DAYS (Number of Days) (VDAYS)**. This field contains the number of days this resource (workers or machines) is available.

A total of 99 days indicates indefinite resource availability over the planning horizon.

**SHIFT LENGTH (HOURS) (VLEN1, VLEN2, VLEN3)**. These fields contain the length in hours of up to three shifts.

**RESOURCE UNITS (MEN/MACHINES) (VCAP1, VCAP2, VCAP3)**. These fields contain the number of resource units available for each of the three shifts.

**SOURCE DESCRIPTION (VDESC)**. This field contains a description of the variable capacity add record; for example, scheduled overtime.

\*\*\*\*\* **BASE VALUES**. If this facility is a work center, the heading for this field is WORK CENTER BASE VALUES. Otherwise, the heading is PRODUCTION LINE BASE VALUES.

The base values (shift lengths and resource units) for this facility are shown on the line just above the first variable capacity record. These are the values for this facility from the Production Facility file.

**START DATE (STDAT)**. Required. Type in the date that this variable capacity is to begin.

**NUMBER OF DAYS (VDAYS).** Required. Type in the number of days that this variable capacity change is to be effective.

Typing in **99** signifies indefinite resource over the planning horizon.

**NEW SHIFT LENGTH (HOURS) (NLEN1, NLEN2, NLEN3).** Required if you do not use the **INCREMENTAL RESOURCE** field. Type in the number of hours available during each shift for up to three shifts. The number of hours you enter here is used as a replacement value for the base shift length.

**Note:** The start date and duration of this shift length may not overlap the shift length in any other variable capacity record.

**INCREMENTAL RESOURCE (MEN/MACHINES) (NCAP1, NCAP2, NCAP3).** Required if you do not use the **NEW SHIFT LENGTH** field. Type in the number of additional resource units above or below the base capacity for this resource. The number you enter here is used to increment (add to or subtract from) the base incremental resource.

Resource units are expressed in shift length increments such that each resource unit is understood to be working the entire shift; for example, if shift length is 8 hours and you want to add one resource unit for 4 hours, you would type in **5** to indicate 0.5 resource units.

To reduce the number of resource units for a certain time period due to vacation or down time, type in a value and press the **FIELD - (minus)** key.

**Note:** The start date and duration of a negative incremental resource may not allow shift capacity to become negative during this period.

**SOURCE DESCRIPTION (NDESC).** Type in a description of this variable capacity change; for example, "scheduled overtime," "add one employee," or "operator on vacation."

## AMVTC3—Variable Capacity Maintenance (Change)

Use this display to change variable capacity records for a facility.

This display appears when you select action 2 (Change) on the Variable Capacity Maintenance (Select) display (AMVTC1) or when you use **F05 (Change)** on either display AMVTC2 or AMVTC4.

When this display first appears, the bottom half is blank except for the function keys and the **ENTER CHANGE REFERENCE NUMBER** field. When you type in a change reference number and press **Enter**, the record you want to change appears on the bottom half of the display.

```

DATE **/**/**          VARIABLE CAPACITY MAINTENANCE      CHANGE      AMVTC3  **
SITE ***

*****      *****      DESCRIPTION *****

REF  START  NBR  -SHIFT LENGTH-  -RESOURCE UNITS-  SOURCE DESCRIPTION
NBR  DATE  DAYS  1    2    3      1    2    3
- TOP OF DATA -  **.* **.* **.* **.* **.* **.* **.* **.* **.* **.* ***** BASE VALUES
* **/**/** **  **.* **.* **.* **.* **.* **.* **.* **.* *****
* **/**/** **  **.* **.* **.* **.* **.* **.* **.* **.* *****
* **/**/** **  **.* **.* **.* **.* **.* **.* **.* **.* *****
* **/**/** **  **.* **.* **.* **.* **.* **.* **.* **.* *****
* **/**/** **  **.* **.* **.* **.* **.* **.* **.* **.* *****
* **/**/** **  **.* **.* **.* **.* **.* **.* **.* **.* *****
* **/**/** **  **.* **.* **.* **.* **.* **.* **.* **.* ***** +

ENTER CHANGE REFERENCE NUMBER n

                                           USE ROLL UP/DOWN
                                           F01 RESTART FACILITY
                                           F04 ADD RECORDS
                                           F06 DELETE RECORDS
                                           F19 RETURN TO SELECT
                                           F23 DISPLAY STATUS
  
```

---

```

*-CHANGE RECORD
START DATE      nnnnnn
NUMBER OF DAYS  nn      SHIFT 1  SHIFT 2  SHIFT 3  USE ROLL UP/DOWN
NEW SHIFT LENGTH  nn.n  nn.n    nn.n    F01 RESTART FACILITY
INCREMENTAL RESOURCE nn.n-  nn.n-  nn.n-  F04 ADD RECORDS
SOURCE DESCRIPTION aaaaaaaaaaaaaaaaaaaA25  F06 DELETE RECORDS
                                           F19 RETURN TO SELECT
                                           F23 DISPLAY STATUS
  
```

### What to do

- To change a variable capacity record, type in a reference number and press **Enter**. The record associated with the reference number appears on the bottom half of the display. Type in the necessary changes for this record and press **Enter** again. The changed record appears on the top half of the display.
- To see the variable capacity records for the production facility from the beginning, use **F01**.
- To delete a variable capacity record for a production facility, use **F06**. Go to display AMVTC4.
- To review the status of and end the session, use **F23**. Go to display AMVTC6.

## Function keys

USE ROLL UP/DOWN allows you to scroll forward and backward through the variable capacity records associated with this facility.

F01 RESTART FACILITY shows all variable capacity records for this facility starting with the first based on the Include for Review code entered on Select display AMVTC1.

F04 ADD RECORDS causes the Variable Capacity Maintenance (Add) display (AMVTC2) to appear.

F06 DELETE RECORDS causes the Variable Capacity Maintenance (Delete) display (AMVTC4) to appear.

F19 RETURN TO SELECT causes the Variable Capacity Maintenance (Select) display (AMVTC1) to appear.

F23 DISPLAY STATUS causes the Variable Capacity Maintenance (Status) display (AMVTC6) to appear.

## Fields

**SITE (STID).** This field contains the site identifier of the facility. This field appears only if EPDM is activated.

**REF NBR (Reference Number) (REFNO).** This field contains an application-assigned number used to select a specific record to be changed or deleted.

**ENTER CHANGE REFERENCE NUMBER.** Type in the reference number of the variable capacity record you want to change and press **Enter**.

For a description of the other fields on this display, see 'AMVTC2—Variable Capacity Maintenance (Add)'.

## AMVTC4—Variable Capacity Maintenance (Delete)

Use this display to delete an individual variable capacity record for a facility.

This display appears when you select action D (Delete) on the Variable Capacity Maintenance (Select) display (AMVTC1) or when you use **F06 (Delete)** on either display AMVTC2 or AMVTC3.

When this display first appears, the bottom half is blank except for the function keys and the **ENTER DELETE REFERENCE NUMBER** field. When you type in a delete reference number and press **Enter**, the record you want to delete appears on the bottom half of the display.

```

DATE **/**/**          VARIABLE CAPACITY MAINTENANCE     DELETE     AMVTC4   **
SITE ***

***** DESCRIPTION *****

REF  START  NBR  -SHIFT LENGTH-  -RESOURCE UNITS-
NBR  DATE  DAYS  1    2    3    1    2    3  SOURCE DESCRIPTION
- TOP OF DATA -  **.* **.* **.* **.*- **.- **.- **.- ***** BASE VALUES
* **/**/** **  **.* **.* **.* **.*- **.- **.- **.- *****
* **/**/** **  **.* **.* **.* **.*- **.- **.- **.- *****
* **/**/** **  **.* **.* **.* **.*- **.- **.- **.- *****
* **/**/** **  **.* **.* **.* **.*- **.- **.- **.- *****
* **/**/** **  **.* **.* **.* **.*- **.- **.- **.- *****
* **/**/** **  **.* **.* **.* **.*- **.- **.- **.- *****
* **/**/** **  **.* **.* **.* **.*- **.- **.- **.- *****
* **/**/** **  **.* **.* **.* **.*- **.- **.- **.- *****
* **/**/** **  **.* **.* **.* **.*- **.- **.- **.- *****
* **/**/** **  **.* **.* **.* **.*- **.- **.- **.- *****
* **/**/** **  **.* **.* **.* **.*- **.- **.- **.- *****

ENTER DELETE REFERENCE NUMBER n

                                  USE ROLL UP/DOWN
                                  F01 RESTART FACILITY
                                  F04 ADD RECORDS
                                  F05 CHANGE RECORDS
                                  F19 RETURN TO SELECT
                                  F23 DISPLAY STATUS
    
```

```

*-DELETE RECORD
START DATE *****
DAYS AVAILABLE **
SOURCE DESCRIPTION *****
PRESS ENTER TO DELETE THIS VARIABLE CAPACITY

                                  USE ROLL UP/DOWN
                                  F01 RESTART FACILITY
                                  F04 ADD RECORDS
                                  F05 CHANGE RECORDS
                                  F19 RETURN TO SELECT
                                  F23 DISPLAY STATUS
    
```

### What to do

- To delete a variable capacity record, type in a reference number and press **Enter**. The record associated with the reference number appears on the bottom half of the display. Press **Enter** again to flag the record for deletion. The flagged record appears on the top half of the display.
- To see the variable capacity records for the production facility from the beginning, use **F01**.
- To add a variable capacity record for a production facility, use **F04**. Go to display AMVTC2.

- To change a variable capacity record for a production facility, use **F05**. Go to display AMVTC3.
- To review the status of and end the session, use **F23**. Go to display AMVTC6.

## Function keys

USE ROLL UP/DOWN allows you to scroll forward and backward through the variable capacity records associated with this facility.

F01 RESTART FACILITY shows all variable capacity records for this facility starting with the first based on the Include for Review code entered on Select Display AMVTC1.

F04 ADD RECORDS causes the Variable Capacity Maintenance (Add) display (AMVTC2) to appear.

F05 CHANGE RECORDS causes the Variable Capacity Maintenance (Change) display (AMVTC3) to appear.

F19 RETURN TO SELECT causes the Variable Capacity Maintenance (Select) display (AMVTC1) to appear.

F23 DISPLAY STATUS causes the Variable Capacity Maintenance (Status) display (AMVTC6) to appear.

## Fields

**SITE (STID)**. This field contains the site identifier of the facility. This field appears only if EPDM is activated.

**REF NBR (Reference Number) (REFNO)**. This field contains an application-assigned number used to select a specific record to be changed or deleted.

**ENTER DELETE REFERENCE NUMBER**. Type in the reference number of the variable capacity record you want to delete.

For a description of the other information fields on the top half of this display, see 'AMVTC2—Variable Capacity Maintenance (Add)'.

## AMVTC5—Variable Capacity Maintenance (Delete All)

Use this display to delete all of the variable capacity records for a facility.

This display appears when you select action 9 (Delete All) on the Variable Capacity Maintenance (Select) display (AMVTC1).

**Note:** Use **ROLL UP/DOWN** and **F01** to review the records for this facility. As a safeguard, it is necessary to press **Enter** twice before all variable capacity records for the facility are deleted. When you are satisfied that these variable capacity records are to be deleted, press **Enter**. Then, to delete all variable capacity records for this facility, press **Enter** again.

```

DATE **/**/**          VARIABLE CAPACITY MAINTENANCE          DELETE ALL AMVTC5  **
SITE ***

*****      *****      DESCRIPTION *****

      START  NBR  -SHIFT LENGTH- -RESOURCE UNITS-
      DATE  DAYS   1    2    3     1     2     3  SOURCE DESCRIPTION
- TOP OF DATA -  **.* **.* **.* **.* **.*- **.*- **.*- **.*- ***** BASE VALUES
**/**/** **  **.* **.* **.* **.* **.*- **.*- **.*- **.*- *****
**/**/** **  **.* **.* **.* **.* **.*- **.*- **.*- **.*- *****
**/**/** **  **.* **.* **.* **.* **.*- **.*- **.*- **.*- *****
**/**/** **  **.* **.* **.* **.* **.*- **.*- **.*- **.*- *****
**/**/** **  **.* **.* **.* **.* **.*- **.*- **.*- **.*- *****
**/**/** **  **.* **.* **.* **.* **.*- **.*- **.*- **.*- *****
**/**/** **  **.* **.* **.* **.* **.*- **.*- **.*- **.*- *****
**/**/** **  **.* **.* **.* **.* **.*- **.*- **.*- **.*- ***** +

PRESS ENTER TWICE TO DELETE ALL VARIABLE CAPACITY FOR THIS WORK CENTER

                                         USE ROLL UP/DOWN
                                         F01 RESTART FACILITY
                                         F19 RETURN TO SELECT
                                         F23 DISPLAY STATUS
    
```

### What to do

- To delete all variable capacity records for a production facility, press **Enter**. Press **Enter** again to flag all the records for deletion. Go to display AMVTC1.
- To see the variable capacity records for the production facility from the beginning, use **F01**.
- To review the status of and end the session, use **F23**. Go to display AMVTC6.

### Function keys

USE ROLL UP/DOWN allows you to scroll forward and backward through the variable capacity records associated with this facility if the word CONTINUED appears.

F01 RESTART FACILITY shows all variable capacity records for this facility starting with the first based on the Include for Review code entered on Select display AMVTC1.

F19 RETURN TO SELECT causes the Variable Capacity Maintenance (Select) display (AMVTC1) to appear.

F23 DISPLAY STATUS causes the Variable Capacity Maintenance (Status) display (AMVTC6) to appear.

### Fields

For a description of the fields on this display, see 'AMVTC2—Variable Capacity Maintenance (Add)'.

## AMVTC6—Variable Capacity Maintenance (Status)

Use this display to review the status of the current maintenance session.

This display appears when you use **F23 DISPLAY STATUS** on the Select (AMVTC1), Add (AMVTC2), Change (AMVTC3), Delete (AMVTC4), or Delete All (AMVTC5) display.

```

DATE **/**/** A2      VARIABLE CAPACITY MAINTENANCE      STATUS      AMVTC6  **

      MAINTENANCE NUMBER          ***

      -----SESSION STATISTICS-----
      ADDS ENTERED                *****
      CHANGES ENTERED            *****
      DELETES ENTERED             *****
      DELETE ALL ENTERED          *****
      TOTAL TRANSACTIONS          *****

                                     F24 END OF JOB

```

### What to do

- To end the session and schedule the Variable Capacity Master File Maintenance report (AMVTC) for printing, use **F24**. Go to display AMVT70.
- To return to the previous display, press **Enter**.

### Function keys

**F24** END OF JOB causes the Production Facility Maintenance display (AMVT70) to appear.

### Fields

All the fields on this display are information only.



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**SESSION STATISTICS.**

**ADDS ENTERED:** This field contains the number of variable capacity add transactions.

**CHANGES ENTERED:** This field contains the number of variable capacity change transactions.

**DELETES ENTERED:** This field contains the number of variable capacity delete transactions.

**DELETE ALL ENTERED:** This field contains the number of Delete All transactions entered.



## What to do

To change the QC due date or FIFO date or to accept a previously rejected batch/lot, enter the item number, batch/lot number, and location you want to change and press **Enter**. Go to display AMIQF2.

## Function keys

F08 SHOW STOCK LOC/LINE LOC allows you to alternate this display between stock location mode and line location mode. This function key is available when REP and IM are interfacing.

F24 DISPLAY STATUS causes display AMIQF3 to appear.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**ITEM [?]**. Required. Type in the item number. You can make changes only to items that are not waiting inspection.

**BATCH/LOT (Batch or Lot Number)**. Type in the batch or lot number for the item. The batch or lot number is required only if the item is Batch/Lot controlled.

### **STOCK LOCATION.**

**WH** (Warehouse Code). If you have multiple warehouses defined in the Warehouse Master file, type in the code of the warehouse where the stock location is to be created or updated. If you have only one warehouse, the warehouse defined in the Warehouse Master file appears in this field and cannot be changed.

**AISLE [?]**. Required in stock location mode. Type in the stock location row.

**BAY**. Type in the vertical aisle location.

**LEVEL**. Type in the horizontal bay location.

**PALLET**. Type in the pallet code that indicates the lowest division in an individual bay/level combination.

**SUBDIV**. Type in the subdivision code that indicates the lowest division in an individual pallet. Depending on what was selected during application tailoring, type in A through E, or 1 through 5.

**LINE LOCATION**. Required in line location mode. Type in the line location. This field replaces the stock location fields when REP and IM are interfacing.

**FIFO DATE (First-In-First-Out Date)**. Type in the date the item was received in stock, whether at approved or unapproved status. This field appears only if FIFO control is active.

**LAST RECORD UPDATED.** The item, warehouse, location, and batch/lot numbers for the record last updated during this session.

## AMIQF2—Batch/Lot Quality Control Status (Change)

Use this display to change the QC due date or FIFO date for the record entered on display AMIQF1 or to accept a previously rejected batch/lot (QC type is 8). If REP is interfacing, the display appears in the mode you selected on display AMIQF1. Otherwise, the first example is how it will appear.

This display appears when you enter an item number and location code on the Batch/Lot Quality Control Status (Select) display (AMIQF1).

```

DATE **/**/**          BATCH/LOT QUALITY CONTROL STATUS  CHANGE  AMIQF2  **

ITEM *****

WH   LINE LOCATION
***  *****
    
```

```

DATE **/**/**          BATCH/LOT QUALITY CONTROL STATUS  CHANGE  AMIQF2  **

ITEM *****

WH   STOCK LOCATION
***  AISLE  BAY  LEVEL  PALLET  SUBDIV  FIFO DATE
      **    **    *    *    *    *    **/**/**

QC TYPE      QC DUE DATE      FIFO DATE      REASON
  n          nnnnnn          nnnnnn          aaaaA6

                                     F19 RETURN TO SELECT
                                     F24 DISPLAY STATUS
    
```

### What to do

- To accept a previously rejected batch/lot, type in **1** or **2** in the **QC TYPE** field and press **Enter**. Go to display AMIQF1.
- To change the QC due date or the FIFO date for the batch/lot shown, type in the new date and press **Enter**. Go to display AMIQF1.

## Function keys

F19 RETURN TO SELECT causes display AMIQF1 to appear.

F24 DISPLAY STATUS causes display AMIQF3 to appear.

## Fields

The **ITEM**, **BATCH/LOT**, **WH**, **LOCATION**, and **FIFO DATE** field values were typed in on display AMIQF1. You can type in or change the following fields.

**QC TYPE.** A QC type code. When QC type is 8, you must type in **1** for a QC controlled item or **2** for a non-QC controlled item and then type in the other fields to be changed. Otherwise, the application does not process your changes.

- 1** The item has shelf life control and is checked. You cannot change 1.
- 2** The item does not have shelf life control.
- 8** The item has been rejected. You can change 8 to 1 or 2.

**QC DUE DATE (Quality Control Due Date).** The next required QC inspection date if the QC status is 1. You can type in a different date.

**FIFO DATE (First-In-First-Out Date).** The date that the item was received in stock, whether at approved or unapproved status. This field appears only if FIFO control is active. You can type in a different date if QC type is 1.

**REASON.** Type in a code to indicate the reason for accepting the batch or changing either date. This field is printed on the Batch/Lot Quality Control Status report (AMIQF).

## AMIQF3—Batch/Lot Quality Control Status (Status)

Use this display to review the number of records maintained in the Location Quantity and Transaction History files and to end the job.

This display appears when you select **F24** on display AMIQF1 or AMIQF2.

DATE **/**/**	BATCH/LOT QUALITY CONTROL STATUS	STATUS	AMIQF3 **
SESSION STATUS	LOCATION QUANTITY FILE	TRANSACTION HISTORY FILE	
RECORDS ADDED		* , * , * , *	
RECORDS CHANGED	* , * , * , *		
F24 END OF JOB			

### What to do

- To end the session, use **F24**. The Batch/Lot Quality Control Status report is scheduled for printing. Go to display AMIM79.
- To return to the display where you selected **F24**, press **Enter**. Go to display AMIQF1 or display AMIQF2.

### Function keys

F24 END OF JOB schedules the Batch/Lot Quality Control Status report (AMIQF) for printing and causes the menu to appear.

### Fields

**SESSION STATUS.** The number of records in the Location Quantity and Transaction History files affected during this session.

**RECORDS ADDED.** The number of records added during this session.

**RECORDS CHANGED.** The number of records changed during this session.



## What to do

To select the batch/lot you want to change, type in the item number, warehouse code, location, batch/lot number, and FIFO date. Press **Enter**. Go to display AMIQK2.

## Function keys

F08 SHOW STOCK LOC/LINE LOC allows you to alternate this display between stock location and line location mode. This function key is available when REP and IM are interfacing.

F24 DISPLAY STATUS causes display AMIQK3 to appear.

## Fields

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**ITEM [?]**. Required. Type in the number of the item associated with the batch/lot number to change.

**WH (Warehouse Code)**. If you have multiple warehouses defined in the Warehouse Master file, type in the code of the warehouse where the stock location is to be created or updated. If you have only one warehouse, the warehouse defined in the Warehouse Master file appears in this field and cannot be changed.

### **STOCK LOCATION.**

**AISLE [?]**. Required in stock location mode. Type in the stock location row.

**BAY**. Required in stock location mode. Type in the vertical aisle location.

**LEVEL**. Type in the horizontal bay location.

**PALLET**. Type in the pallet code that indicates the lowest division in an individual bay/level combination.

**SUBDIV**. Type in the subdivision code that indicates the lowest division in an individual pallet. Depending on what was selected during application tailoring, type in A through E, or 1 through 5.

**LINE LOCATION**. Required in line location mode. Type in the line location. This field replaces the stock location fields when REP and IM are interfacing.

**CURRENT BATCH/LOT**. Type in the batch/lot number to change. Leave this field blank if you are assigning a batch/lot number for the first time. This is the batch/lot number that is passed to history when the record is accepted.

**FIFO DATE (First-In-First-Out Date)**. Type in the date the item was received in stock, whether at approved or unapproved status. If FIFO control is not active, this field does not appear.

**LAST RECORD UPDATED**. The item number, warehouse, stock location, and new batch/lot numbers for the record last updated during this session.



## AMIQK2—Batch/Lot Numbers (Change)

Use this display to enter the batch/lot number change and the reason for the change. The display appears in the mode you selected on display AMIQK1.

This display appears when you enter an item number, location, and batch/lot number on display AMIQK1. If REP is interfacing with IM, two display modes are available: stock location and line location.

DATE **/**/**	BATCH/LOT NUMBERS	CHANGE	AMIQK2 **
ITEM *****			
WH ***	LINE LOCATION *****	CURRENT BATCH/LOT *****	FIFO DATE **/**/**

DATE **/**/**	BATCH/LOT NUMBERS	CHANGE	AMIQK2 **
ITEM *****			
WH ***	STOCK LOCATION AISLE BAY LEVEL * * * *	PALLET * SUBDIV *	CURRENT BATCH/LOT ***** FIFO DATE **/**/**
	NEW BATCH/LOT aaaaaaaA10	REASON aaaaA6	
F19 RETURN TO SELECT F24 DISPLAY STATUS			

### What to do

To change the batch/lot number for the item shown, type in the new batch/lot number and, if needed, the reason for the change. Press **Enter**. Display AMIQK2 appears again to continue file maintenance.

### Function keys

F19 RETURN TO SELECT causes display AMIQK1 to appear.

F24 DISPLAY STATUS causes display AMIQK3 to appear.

## Fields

The *ITEM*, *WH*, a location, *CURRENT BATCH/LOT*, and *FIFO DATE* fields were typed in on display AMIQK1.

**NEW BATCH/LOT.** Required. Type in the batch/lot number to replace the current number.

**REASON.** Type in a code to indicate the reason for changing the batch/lot number.

## AMIQK3—Batch/Lot Numbers (Status)

Use this display to review the number of records maintained in the Location Quantity and Transaction History files and to end the job.

This display appears when you select **F24** on display AMIQK1 or AMIQK2.

DATE **/**/**	BATCH/LOT NUMBERS	STATUS	AMIQK3 **
SESSION STATUS	LOCATION QUANTITY FILE	TRANSACTION HISTORY FILE	
RECORDS ADDED	*, ***, ***	*, ***, ***	
RECORDS CHANGED	*, ***, ***	*, ***, ***	
F24 END OF JOB			

### What to do

- To end the session, use **F24**. The Batch/Lot Numbers report is scheduled for printing. Go to display AMIM79.
- To return to the display where you selected **F24**, press **Enter**.

### Function keys

F24 END OF JOB schedules the Batch/Lot Numbers report (AMIQK) for printing and causes the menu to appear.

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## Fields

**SESSION STATUS.** The number of records maintained in the Location Quantity and Transaction History files during this session.

**RECORDS ADDED.** The number of records added during this session.

**RECORDS CHANGED.** The number of records changed during this session.

---

## Option 7. Location Detail (AMQM50)

Use this option to create or update stock locations and assign the multiple items or multiple lots per location codes. These steps are also used to assign item quantities to specific locations or to change item quantities in a given location.

**What information you need:**

- Form IM-38 for individual locations
- Form IM-39 for multiple locations
- Form IM-40 for location quantities

**What reports are printed:** One of the following reports is printed depending on the option you select on the Location Detail (Select) display (AMIXK1):

- Location Detail–Individual Locations (AMICA)
- Location Detail–Multiple Locations (AMICB)
- Location Detail–Location Quantities (AMIZD)
- Location Detail–Location Detail (AMIXK)

**Note:** A Location Detail report is printed at the end of your session.

**What forms you need:** None.

The basic steps to maintain stock locations and assign (or change) item quantities to specific locations follow each display.

## AMIXK1—Location Detail (Select)

Use this display to select options for adding or maintaining locations or location quantity detail information.

This display appears when you select option 9 on the File Maintenance menu (AMIM70), followed by option 3 from the Location Control menu (AMIM79) or option 7 on the REP File Maintenance menu (AMQM50).

```
DATE **/**/**          LOCATION DETAIL          SELECT          AMIXK1  **

                                OPTION      n
                                1  INDIVIDUAL LOCATIONS
                                2  MULTIPLE LOCATIONS
                                3  LOCATION QUANTITIES

                                F24 DISPLAY STATUS
```

### What to do

- To create, change, or delete individual locations within a warehouse, select option 1 and press **Enter**. Go to display AMICA1.
- To create or delete multiple locations within a warehouse, select option 2 and press **Enter**. Go to display AMICB1.
- To assign or change location quantities, select option 3 and press **Enter**. Go to display AMIZD1.

### Function keys

F24 DISPLAY STATUS causes display AMIXK2 to appear.

### Fields

**OPTION.** Required. Type in one of the following:

- 1** Individual locations. Create, change or delete individual locations within a warehouse. This option is also used to assign the multiple items or multiple lots per location codes.
- 2** Multiple locations. Create or delete multiple locations within a warehouse. This option is also used to assign the multiple items or multiple lots per location codes.

- 3 Location quantities. Assign item quantities to specific locations or to change item quantities in a given location.

## AMICA1—Location Detail—Individual Locations (Select)

Use this display to enter the warehouse code, location, and maintenance action for the record you want to add, change, or delete.

This display appears when you select option 1 on the Location Detail (Select) display (AMIXK1). If REP is interfacing with IM, two display modes are available: stock location and line location.

```

DATE **/**/**                LOCATION DETAIL          SELECT  AMICA1  **
                              INDIVIDUAL LOCATIONS

                               WH   LINE LOCATION
                               aA3  aaaaaA7
    
```

```

DATE **/**/**                LOCATION DETAIL          SELECT  AMICA1  **
                              INDIVIDUAL LOCATIONS

                               STOCK LOCATION
                               WH   AISLE  BAY   LEVEL  PALLET  SUBDIVISION
                               aA3   A2    A2    A      A      A

                               ACTION  A

                               A-ADD
                               C-CHANGE
                               D-DELETE

LAST LOCATION UPDATED  ***  *****

                               F08 SHOW LINE LOC
                               F19 RETURN TO SELECT
                               F24 DISPLAY STATUS
    
```

### What to do

- To create an individual stock location, type in the warehouse code, location, and action code **A**. Press **Enter**. Go to display AMICA2.
- To change the multiple items or multiple lots per location codes for an existing location, type in the warehouse code, location, and action code **C**. Press **Enter**. Go to display AMICA2.
- To delete an existing location, type in the warehouse code, location, and action code **D**. Press **Enter**. Go to display AMICA3.

## Function keys

F08 SHOW STOCK LOC/LINE LOC allows you to alternate this display between stock location and line location mode. This function key is available when REP and IM are interfacing.

F19 RETURN TO SELECT schedules the Location Detail – Individual Locations report (AMICA) for printing and causes the Location Detail (Select) display (AMIXK1) to appear.

F24 DISPLAY STATUS schedules the Location Detail – Individual Locations report (AMICA) for printing and causes the Location Detail (Status) display (AMIXK2) to appear.

## Fields

**WH (Warehouse Code).** Required. If you have multiple warehouses defined in the Warehouse Master file, type in the code of the warehouse where the stock location is to be created or updated. If you have only one warehouse, the warehouse defined in the Warehouse Master file appears in this field and cannot be changed.

### **STOCK LOCATION.**

**AISLE.** Required. Type in the stock location row.

**BAY.** Required. Type in the vertical aisle location.

The next three fields are required if you select action code C or D and the location you are maintaining is defined to the level, pallet, and/or subdivision.

**LEVEL.** Type in the horizontal bay location.

**PALLET.** Type in the pallet code that indicates the lowest division in an individual bay/level combination.

**SUBDIVISION.** Type in the subdivision code that indicates the lowest division in an individual pallet. Based on what was selected during application tailoring, type in A through E, or 1 through 5. You must build the main location before you can build subdivisions for that location.

**LINE LOCATION.** Required in line location mode. Type in the line location. This field replaces the stock location fields when REP and IM are interfacing.

**ACTION.** Required. Type in one of the following codes to indicate the kind of maintenance to be performed:

<b>A</b>	Add
<b>C</b>	Change
<b>D</b>	Delete

**LAST LOCATION UPDATED.** Required in line location mode. The warehouse code and location for the record last updated during this session appears.

## AMICA2—Location Detail—Individual Locations (Add or Change)

Use this display to allow multiple item numbers and/or multiple batch/lots to be stored in one location.

This display appears in the maintenance mode selected when you enter A or C in **ACTION** on the Location Detail—Individual Locations (Select) display (AMICA1). If REP is interfacing with IM, two display modes are available: stock location and line location.

```

DATE **/**/**                LOCATION DETAIL          *****  AMICA2  **
                              INDIVIDUAL LOCATIONS

                               WH      LINE LOCATION
                               ***      *****
  
```

```

DATE **/**/**                LOCATION DETAIL          *****  AMICA2  **
                              INDIVIDUAL LOCATIONS

                               STOCK LOCATION
                               AISLE   BAY    LEVEL  PALLET  SUBDIVISION
                               ***    **    *      *      *
                               MULTIPLE ITEMS  A      Y-YES
                               MULTIPLE LOTS   A      N-NO

                                               F19 RETURN TO SELECT
                                               F24 DISPLAY STATUS
  
```

### What to do

To assign or change the multiple items or multiple lots per location codes, type in the necessary information and press **Enter**. Go to display AMICA1 to continue file maintenance.



## Function keys

F19 RETURN TO SELECT schedules the Location Detail – Individual Locations report (AMICA) for printing and causes the Location Detail – Individual Locations (Select) display (AMICA1) to appear.

F24 DISPLAY STATUS schedules the Location Detail – Individual Locations report (AMICA) for printing and causes display AMIXK2 to appear.

## Fields

In stock location mode, the **WH**, **aisle**, **BAY**, **LEVEL**, **PALLET**, and **SUBDIVISION** fields were typed in on display AMICA1. In line location mode, **WH** and **LINE LOCATION** were typed in.

You can type in the following fields:

**MULTIPLE ITEMS.** In Add mode, type in one of the following codes:

**N** No. Can contain only one item. This is the default.  
**Y** Yes. Can contain multiple items.

If the MULTIPLE ITEMS field appears in Change mode and the code is Y, it can be changed only if the location is empty. If the code is N, it can be changed at any time.

**MULTIPLE LOTS.** In Add mode, type in one of the following codes:

**N** No. Can contain only one batch/lot. This is the default.  
**Y** Yes. Can contain multiple batch/lots.

If multiple lots appeared in Change mode and the code is Y, it can be changed only if the location is empty. If the code is N, it can be changed at any time.

## AMICA3—Location Detail—Individual Locations (Delete)

Use this display to delete the selected Location Detail record.

This display appears when you enter D in **ACTION** on the Location Detail—Individual Locations (Select) display (AMICA1). If REP is interfacing with IM, two display modes are available: stock location and line location.

```

DATE **/**/**              LOCATION DETAIL          DELETE   AMICA3  **
                           INDIVIDUAL LOCATIONS

                               WH   LINE LOCATION
                               ***   *****
  
```

```

DATE **/**/**              LOCATION DETAIL          DELETE   AMICA3  **
                           INDIVIDUAL LOCATIONS

                               STOCK LOCATION
                               AISLE  BAY   LEVEL  PALLET  SUBDIVISION
                               ***   **   **    *    *      *
                               *
                               MULTIPLE ITEMS *      Y-YES
                               *                N-NO
                               MULTIPLE LOTS  *

                                               F19 RETURN TO SELECT
                                               F24 DISPLAY STATUS
  
```

### What to do

To confirm that you want to delete the location detail shown on the display, press **Enter**. Go to display AMICA1.

### Function keys

F19 RETURN TO SELECT schedules the Location Detail – Individual Locations report (AMICA) for printing and causes the Location Detail – Individual Locations (Select) display (AMICA1) to appear.

F24 DISPLAY STATUS schedules the Location Detail – Individual Locations report (AMICA) for printing and causes display AMIXK2 to appear.

## Fields

**MULTIPLE ITEMS.** Indicates whether the location can contain multiple items.

**N** No. Only one item.  
**Y** Yes. Multiple items.

**MULTIPLE LOTS.** Indicates whether the location can contain multiple batches/lots.

**N** No. Only one batch/lot.  
**Y** Yes. Multiple batches/lots.

## AMICB1—Location Detail—Multiple Locations (Select)

Use this display to enter the warehouse code, location, and maintenance action for the record.

This display appears when you select option 2 on the Location Detail (Select) display (AMIXK1). If REP is interfacing with IM, two display modes are available: stock location and line location.

DATE **/**/**	LOCATION DETAIL MULTIPLE LOCATIONS	SELECT	AMICB1 **
	WAREHOUSE aA3		
	LINE LOCATION		
FROM	aaaaaA7		
TO	aaaaaA7		

DATE **/**/**	LOCATION DETAIL MULTIPLE LOCATIONS	SELECT	AMICB1 **
	WAREHOUSE aA3		
	AISLE A2		
	BAY LEVEL PALLET SUBDIVISION		
FROM	A2 A A A		
TO	A2 A A A		
	ACTION A		
	A-ADD D-DELETE		
LAST LOCATION UPDATED	*** *****		
			F08 SHOW LINE LOC F19 RETURN TO SELECT F24 DISPLAY STATUS

## What to do

- To create multiple locations, type in the warehouse code, location ranges, and action code **A**. Press **Enter**. The display appears again with a message showing the number of records that are created. Press **Enter** again and go to display AMICB2. Pressing **Enter** from display AMICB2 actually creates the records and causes display AMICB1 to appear to continue file maintenance.
- To delete multiple locations, type in the warehouse code, location ranges, and action code **D**. Press **Enter**. The display appears again with a message showing the number of records selected for deletion. Press **Enter** again to delete the records. The records are deleted and display AMICB1 appears to continue file maintenance.

Depending on the number of records selected for update, the processing may take some time. If you should decide not to process the records, select a function key before pressing **Enter**. The update selection is automatically voided.

## Function keys

F08 SHOW STOCK LOC/LINE LOC allows you to alternate this display between stock location and line location mode. This function key is available when REP and IM are interfacing.

F19 RETURN TO SELECT schedules the Location Detail – Multiple Locations report (AMICB) for printing and causes the Location Detail (Select) display (AMIXK1) to appear.

F24 DISPLAY STATUS schedules the Location Detail – Multiple Locations report (AMICB) for printing and causes display AMIXK2 to appear.

## Fields

**WAREHOUSE (Warehouse Code)**. Required. If you have multiple warehouses defined in the Warehouse Master file, type in the code of the warehouse where the stock location is to be created or updated. If you have only one warehouse, the warehouse defined in the Warehouse Master file appears in this field and cannot be changed.

### **Stock Location.**

**AISLE**. Required. Type in the stock location row.

**BAY FROM/TO**. Required. Type in the range of vertical aisle locations. If you type in a range in the Level fields, the first character of each Bay field must be equal.

**LEVEL FROM/TO**. Type in the range of horizontal bay locations.

**PALLET FROM/TO**. Type in the range of pallet codes that indicate the lowest division in an individual bay/level combination.

**SUBDIVISION FROM/TO**. Type in the range of subdivision codes that indicates the lowest division in an individual pallet. Depending on what was selected during application tailoring, type in A through E or 1 through 5. To create (add) multiple locations to the subdivision, you must type in the subdivision. When you delete multiple locations to the pallet all associated subdivisions are also deleted.

**LINE LOCATION FROM/TO.** Required in line location mode. Type in a range of line locations. This field replaces the stock location fields when REP and IM are interfacing.

**ACTION.** Required. Type in one of the following codes to indicate the kind of maintenance to be performed:

- A**     Add
- D**     Delete

**LAST LOCATION UPDATED.** Required in line location mode. The warehouse code and aisle for the record last updated appears.

## AMICB2—Location Detail—Multiple Locations (Add)

Use this display to enter multiple items and/or multiple lots per location codes and to create the records selected on display AMICB1.

This display appears when you enter A in **ACTION** and press **Enter** on the Location Detail—Multiple Locations (Select) display (AMICB1). If REP is interfacing with IM, two display modes are available: stock location and line location.

DATE **/**/**	LOCATION DETAIL MULTIPLE LOCATIONS	ADD	AMICB2 **
	WAREHOUSE ***		
	LINE LOCATION		
FROM	*****		
TO	*****		

DATE **/**/**	LOCATION DETAIL MULTIPLE LOCATIONS	ADD	AMICB2 **
	WAREHOUSE ***		
		AISLE **	
	BAY     LEVEL     PALLET     SUBDIVISION		
FROM	**     *     *     *		
TO	**     *     *     *		
	MULTIPLE ITEMS     A     Y-YES		
	MULTIPLE LOTS     A     N-NO		
			F19 RETURN TO SELECT F24 DISPLAY STATUS

## What to do

To assign multiple items or multiple lots per location codes, type in the code and press **Enter**. The records selected for creation on display AMICB1 are processed. Go to display AMICB1 to continue file maintenance.

Depending on the number of records to be created, the processing may take some time. If you should decide not to process the records, select a function key before pressing **Enter**. The Add function is automatically voided.

## Function keys

F19 RETURN TO SELECT schedules the Location Detail – Multiple Locations report (AMICB) for printing and causes the Location Detail – Multiple Locations (Select) display (AMICB1) to appear.

F24 DISPLAY STATUS schedules the Location Detail – Multiple Locations report (AMICB) for printing and causes display AMIXK2 to appear.

## Fields

The field information was entered on display AMICB1 whether for stock location mode or line location mode

You can type in the following fields.

**MULTIPLE ITEMS.** Type in the code that indicates whether the location can contain multiple items.

- N** No. Only one item.
- Y** Yes. Multiple items. This is the default.

**MULTIPLE LOTS.** Type the code that indicates whether the location can contain multiple batches/lots.

- N** No. Only one batch/lot.
- Y** Yes. Multiple batches/lots. This is the default.

## AMIZD1—Location Detail—Location Quantities (Select)

Use this display to designate the stock location for a particular item and specific batch/lot.

This display appears when you select option 3 from display AMIXK1. If REP is interfacing with IM, two display modes are available: stock location and line location.

DATE **/**/**	LOCATION DETAIL LOCATION QUANTITIES	SELECT	AMIZD1 **
WH	LINE LOCATION	REASON	
aA3	aaaaA7	aaaaA6	

```

DATE **/**/**                                LOCATION DETAIL                                SELECT    AMIZD1  **
                                           LOCATION QUANTITIES

      STOCK LOCATION
WH  AISLE  BAY  LEVEL  PALLET  SUBDIVISION  REASON
aA3  A2    A2    A      A      A          aaaaA6

ITEM  aaaaaaaaaA15    BATCH/LOT  aaaaaA10    FIFO DATE  mnnnnn

LAST UPDATED *** ***** *****

                                           F08 SHOW LINE LOC
                                           F19 RETURN TO SELECT
                                           F24 DISPLAY STATUS

```

**What to do**

- To assign item quantities to a specific location during installation, type in the necessary information and press **Enter**. Go to display AMIZD2.
- To change item quantities in a particular location, type in the necessary information and press **Enter**. Go to display AMIZD2.

Make sure that the sum of the quantities for this item in all locations in the Location Quantity file does not exceed the on hand quantity in the Item Balance file. The value in the on hand quantity field does not reflect any items that have a waiting inspection status. These quantities are not added to the Item Balance file until the item is approved. You can use a report or inquiry transaction to check the quantity of items that have a waiting inspection status.

**Warning:** Changing item quantities can reduce the integrity of your files and should be done with great care.

**Function keys**

F08 SHOW STOCK LOC/LINE LOC allows you to alternate this display between stock location and line location mode. This function key is available when REP and IM are interfacing.

F19 RETURN TO SELECT schedules the Location Detail – Location Quantities report (AMIZD) for printing and causes the Location Detail (Select) display (AMIXK1) to appear.

F24 DISPLAY STATUS schedules the Location Detail – Location Quantities report (AMIZD) for printing and causes display AMIXK2 to appear.

**Fields**

[?] appears next to a field name in the following field definitions to identify a field from which you can begin a master file search.

**WH (Warehouse Code).** If you have multiple warehouses defined in the Warehouse Master file, type in the code of the warehouse where the stock location is to be created or updated. If you have only one warehouse, the warehouse defined in the Warehouse Master file appears in this field and cannot be changed.

**STOCK LOCATION.**

**AISLE [?].** Required. Type in the stock location row.

**BAY.** Required. Type in the vertical aisle locations..

**LEVEL.** Type in the horizontal bay locations.

**PALLET.** Type in the pallet code that indicates the lowest division in an individual bay/level combination.

**SUBDIVISION.** Type in the subdivision codes that indicate the lowest division in an individual pallet. Depending on what was selected during application tailoring, type in A through E or 1 through 5.

**LINE LOCATION.** Type in the line location. This field replaces the stock location fields when REP and IM are interfacing.

**REASON.** You can type in a code to indicate the reason for adding or changing location quantities.

**ITEM [?].** Required. Type in the number of the item associated with the location.

**BATCH/LOT (Batch Number or Lot Number).** Required. Type in the batch or lot number for the item.

**FIFO DATE (First-In-First-Out Date).** Type in the date the item was received in stock, whether at approved or unapproved status. This field appears only if FIFO control is active and defaults to the system date.

**LAST UPDATED.** The warehouse code, location, and item number for the record last updated appear.



## AMIZD2—Location Detail—Location Quantities (Add or Change)

In Add mode, use this display to enter the quantity and detail information for the item being added to the specified location.

In Change mode, use this display to change the item quantity. All other fields are protected and cannot be changed.

This display appears when you assign an item and batch/lot to a location on display AMIZD1. If REP is interfacing with IM, two display modes are available: stock location and line location.

```

DATE **/**/**                LOCATION DETAIL                *****  AMIZD2  **
                             LOCATION QUANTITIES

      WH  LINE LOCATION                REASON
      ***  *****                *****
  
```

```

DATE **/**/**                LOCATION DETAIL                *****  AMIZD2  **
                             LOCATION QUANTITIES

      STOCK LOCATION
      WH  AISLE  BAY  LEVEL  PALLET  SUBDIVISION  REASON
      ***  **   **   *     *       *             *****

ITEM *****  BATCH/LOT *****  FIFO DATE **/**/**
DESCRIPTION *****

      QUANTITY                ON HAND QTY
      nnnnnnn.nnn            *****.***
      GRN                    QC TYPE          QC DUE DATE
      aaaaaaaaaaaaaaaaaaaaaA26  n             nnnnnn

QC TYPE 1 = SHELF LIFE/CHK   QC TYPE 7 = MFG WAITING
QC TYPE 2 = NO SHELF LIFE   QC TYPE 8 = REJECT
QC TYPE 6 = DUE INSPECTION  QC TYPE 9 = PCH WAITING

                                F19 RETURN TO SELECT
                                F24 DISPLAY STATUS
  
```

### What to do

- In Add mode, to enter the quantity and detail information for the item at the specific location, press **Enter**. Go to display AMIZD1.
- In Change mode, to change the quantity for the item, press **Enter**. Go to display AMIZD1.
- Changing item quantities can reduce the integrity of your files and should be done with great care.

### Function keys

F19 RETURN TO SELECT schedules the Location Detail – Location Quantities report (AMIZD) for printing and causes the Location Detail – Location Quantities (Select) display (AMIZD1) to appear.

F24 DISPLAY STATUS schedules the Location Detail – Location Quantities report (AMIZD) for printing and causes display AMIXK2 to appear.

## Fields

In stock location mode, the **AISLE, BAY, LEVEL, PALLET, SUBDIVISION, REASON, ITEM, BATCH/LOT**, and **FIFO DATE** fields were typed in on display AMIZD1. In line location mode, the **LINE LOCATION** field was typed in. Only the **WH** and **QUANTITY** fields are required on this display. In Add mode, you can type in the following fields, except **DESCRIPTION**. In Change mode, only **QUANTITY** can be changed.

**DESCRIPTION.** The item description.

**QUANTITY.** Type in the quantity of the item that is being assigned to this location.

**ON HAND QTY.** The current on hand quantity as stored in the Item Balance file. This quantity does not include items that are waiting for inspection. Also, this quantity does not include any items that have a waiting status (QC type codes 6, 7, 8, and 9). The total quantity of all locations must be equal to, and cannot be greater than, this quantity in the Item Balance file.

**GRN (Goods Received Note Number).** Type in the number of the goods received note assigned to the item. This field appears only if the GRN system is active.

**QC TYPE (Quality Control Type Code).** This field appears only if QC control is active. Type in one of the following:

- 1 Shelf life/chk (shelf life/checked). The item is within shelf life, and inspection not yet required.
- 2 No shelf life. The item does not have shelf life.  
  
If you assign any of the following QC type codes to an item, the quantity is not reflected in the Item Balance file total (**ON HAND QTY** field) until the item is approved.
- 6 Due inspection. The item is waiting for inspection due to expiration of shelf life.
- 7 Mfg waiting (manufactured item waiting). The item is waiting for inspection on receipt.
- 8 Reject. The item is rejected, waiting disposal or rework.
- 9 Pch waiting (purchased item waiting). The item is waiting for inspection on receipt.

**QC DUE DATE.** Type in the date quality control is due on the item. This field appears only if QC control is active.

## AMIXK2—Location Detail (Status)

Use this display to review the number of records maintained in the Location Detail, Location Quantity, and Transaction History files and to end the job.

This display appears when you select **F24** from any of the Location Detail file maintenance displays.

DATE **/**/**	LOCATION DETAIL	STATUS	AMIXK2 **
	LOCATION DETAIL FILE	LOCATION QUANTITY FILE	TRANSACTION HISTORY FILE
SESSION STATUS			
RECORDS ADDED	*,***,***	*,***,***	*,***,***
RECORDS CHANGED	*,***,***	*,***,***	
RECORDS DELETED	*,***,***		
F24 END OF JOB			

### What to do

- To end the session, use **F24**. The report you selected is scheduled for printing. Return to the menu.
- To return to the display where you selected **F24**, press **Enter**.

### Function keys

F24 END OF JOB schedules the Location Detail report (AMIXK) for printing and causes the menu to appear.

### Fields

**SESSION STATUS.** The number of records in the Location Detail, Location Quantity and Transaction History files affected during this session.

**RECORDS ADDED.** The number of records added during this session.

**RECORDS CHANGED.** The number of records changed during this session.

**RECORDS DELETED.** The number of records deleted during this session.

## Option 8. Code Files (AMQM50)

Use this option to define information for codes you use with Repetitive Production Management. Code files consist of a code and a code description for each record in the file. Code file maintenance allows you to name and describe the values your company uses for these codes. Think of code values as abbreviations your company uses for specific fields.

Before you begin code file maintenance, make sure you have all your entry information at hand. You might find following a pattern is useful for setting up some codes. For example, each Territory code might begin with a letter representing a region of the country, such as “S” for all territories in the “South”.

### How you start code file maintenance

Menu	Option
Repetitive Production Management Main Menu (AMQM00)	File Maintenance option
File Maintenance menu (AMQM50)	Code Files option
Code File Maintenance menu (AMQM58)	Options 1–8

```

AMQM58                      Repetitive Production Management          *****
                             Code File Maintenance

Type option or command; press Enter.

1. Bill of Lading Commodity
2. Country
3. Item Class
4. Item Price Class
5. Item Sales Family
6. Item Sales Group
7. Transaction Unit of Measure Class
8. Unit of Measure Master

==> _____

F3=Exit      F4=Prompt    F9=Retrieve   F10=Actions
F11=Job status  F12=Return   F22=Messages
  
```

## Code file maintenance panels

The code file maintenance panels show you a list of codes or show you entry fields for adding new codes to the list. You have several ways to move through the list of codes.

### Scrolling the code list

Your company may have more codes than can be shown on the panel at one time. In that case, a plus sign (+) appears at the bottom of the list. Use **F7=Backward**, **F8=Forward**, **roll keys**, or **page keys** to scroll through the list of codes.

```
AMVAJDFR                      Display Countries                      DISPLA
Y                                                                    New mail waitin
g
Position to code . . . . . aA3
Subset by name . . . . . aaaaaaaaaaaaaaaaaaaaaA25

Code   Name
ARG    Argentina
AST    Austria
AUS    Australia
BRZ    Brazil
CAN    Canada
CZC    Czechoslovakia
DNM    Denmark
FRN    France
GBR    Great Britain
GER    Germany
GRC    Greece
ITY    Italy
JAM    Jamaica
JPN    Japan
+

F3=Exit      F6=Edit      F7=Backward  F8=Forward
F12=Cancel   F21=Print
```

When you use **F8=Forward**, the next country codes appear in the list.

```
AMVAJDFR                      Display Countries                      DISPLA
Y                                                                    New mail waitin
g
Position to code . . . . . aA3
Subset by name . . . . . aaaaaaaaaaaaaaaaaaaaaA25

Code   Name
MEX    Mexico
NTH    Netherlands
POL    Poland
PRT    Portugal
```

## Position to field

You can also move through the list by typing the code you want to see in the **Position to** field at the top of the panel.

```
AMVAJDFR                               Display Countries                               DISPLAY
New mail waiting

Position to code . . . . . GER
Subset by name . . . . . aaaaaaaaaaaaaaaaaaaaaA25

Code   Name
ARG   Argentina
AST   Austria
AUS   Australia
BRZ   Brazil
CAN   Canada
CZC   Czechoslovakia
DNM   Denmark
FRN   France
GBR   Great Britain
GER   Germany
GRC   Greece
ITY   Italy
JAM   Jamaica
JPN   Japan                                     +

F3=Exit      F6=Edit      F7=Backward  F8=Forward
F12=Cancel   F21=Print
```

When you type a code in the **Position to** field and press **Enter**, the system moves the list so that the code you typed is at the top of the list. If none of the codes match the one you typed, the list begins with the entry immediately following the code you want.

```
AMVAJDFR                               Display Countries                               DISPLAY
New mail waiting

Position to code . . . . . GER
Subset by name . . . . . aaaaaaaaaaaaaaaaaaaaaA25

Code   Name
GER   Germany
GRC   Greece
ITY   Italy
JPN   Japan
MEX   Mexico
```

To return to the original list, blank out the value in the **Position to** field and press **Enter**.

## Subset by field

If you want to limit the list of codes to only those with a certain description, you can type the string of letters or numbers you want to match in the **Subset by** field.

```
AMVAJDFR          Display Countries          DISPLA
Y
                                                    New mail waitin
g
Position to code . . . . . aA3
Subset by name . . . . . Austr

Code   Name
ARG    Argentina
AST    Austria
AUS    Australia
BRZ    Brazil
CAN    Canada
CZC    Czechoslovakia
DNM    Denmark
FRN    France
GBR    Great Britain
GER    Germany
GRC    Greece
ITY    Italy
JAM    Jamaica
JPN    Japan
+

F3=Exit   F6=Edit   F7=Backward  F8=Forward
F12=Cancel F21=Print
```

When you press **Enter**, only those codes that match the string you enter appear in the list.

```
AMVAJDFR          Display Countries          DISPLA
Y
                                                    New mail waitin
g
Position to code . . . . . aA3
Subset by name . . . . . Aus

Code   Name
AST    Austria
AUS    Australia
```

To return to the original list, blank out the value in the **Subset by** field and press **Enter**.

## Types of code file maintenance panels

You use two types of panels when you maintain code files: the Display panel and the Edit panel. Both panels show the list of codes. Each entry in the list contains a code and a name or description for that code.

**Display panel.** This panel is your starting point for code file maintenance. It is the first panel that appears when you choose an option on the Code File Maintenance menu.

The Display panel is like an inquiry panel. You can see information, but you cannot change it. For example, in the following panel, you see a list of three-position country codes and the names of the countries.

```
AMVAJDFR                      Display Countries                      DISPLAY
                                                                    New mail waiting
Position to code . . . . . aA3
Subset by name . . . . . aaaaaaaaaaaaaaaaaaaaaA25

Code   Name
ARG   Argentina
AST   Austria
AUS   Australia
BRZ   Brazil
CAN   Canada
ITY   Italy
CZC   Czechoslovakia
DNM   Denmark
FRN   France
GBR   Great Britain
GER   Germany
GRC   Greece
JAM   Jamaica
JPN   Japan

F3=Exit      F6=Edit      F7=Backward  F8=Forward
F12=Cancel   F21=Print
```

**Edit panel.** This panel appears when you use **F6=Edit** on the Display panel. It contains the same list of codes and code descriptions as the Display panel. It also contains an **Opt** field. Enter the number in this field that corresponds to the action you want to take against an entry in the list. The action available in code file maintenance is 4=Delete.



```

AMVAGEFR                      Edit Country Data                      CHANGE
                                New mail waiting

Position to code . . . .  aA3

Type options; press Enter.
4=Delete

                                - - - - EEC information - - - -
                                Country   Statistical   Member
                                code      value %      state?

Opt  Code   Name
ARG  ARG    Argentina
AST  AST    Austria
AUS  AUS    Australia
BRZ  BRZ    Brazil
CAN  CAN    Canada
CZC  CZC    Czechoslovakia
DNM  DNM    Denmark
FRN  FRN    France
GBR  GBR    Great Britain
GER  GER    Germany
GRC  GRC    Greece

F3=Exit      F6=Add      F7=Backward  F8=Forward
F12=Cancel   F21=Print

```

The Edit panel has two modes, Change and Add. In Change mode, you can type over the code name or description with a new name or description. You cannot change the code itself.

Use **F6=Add** to switch from Change mode to Add mode so that you can enter new codes and descriptions.

```

AMVAGEFR                      Edit Country Data                      ADD
                                New mail waiting

Type information; press Enter.

                                - - - - EEC information - - - -
                                Country   Statistical   Member
                                code      value %      state?

Code  Name
aA3   aaaaaaaaaaaaaaaaaaaaaaaaaa  aA3   nnn.nn      A
aA3   aaaaaaaaaaaaaaaaaaaaaaaaaa  aA3   nnn.nn      A
aA3   aaaaaaaaaaaaaaaaaaaaaaaaaa  aA3   nnn.nn      A
aA3   aaaaaaaaaaaaaaaaaaaaaaaaaa  aA3   nnn.nn      A
aA3   aaaaaaaaaaaaaaaaaaaaaaaaaa  aA3   nnn.nn      A
aA3   aaaaaaaaaaaaaaaaaaaaaaaaaa  aA3   nnn.nn      A
aA3   aaaaaaaaaaaaaaaaaaaaaaaaaa  aA3   nnn.nn      A
aA3   aaaaaaaaaaaaaaaaaaaaaaaaaa  aA3   nnn.nn      A
aA3   aaaaaaaaaaaaaaaaaaaaaaaaaa  aA3   nnn.nn      A
aA3   aaaaaaaaaaaaaaaaaaaaaaaaaa  aA3   nnn.nn      A
aA3   aaaaaaaaaaaaaaaaaaaaaaaaaa  aA3   nnn.nn      A
+

F3=Exit      F6=Change   F7=Backward  F8=Forward
F12=Cancel   F21=Print

```

Use **F6=Change** to switch back to Change mode. Or, use **F12=Cancel** to return to the Display panel.

## Code file report

If you want a report showing all codes defined in a code file, use **F21=Print**. The List Detail report prints for that code file. For example, using **F21** on the Display Country or Edit Country Data panels causes the List Country Detail report (AMVADPFR) to print.

---

AMVADPFR	SPELL	List Country Detail	7/12/**	Page	1
			08:13:51	ATLA1035	50
		- - - EEC information - - -			
Code	Name	Country	Statistical	Member	
		code	value %	state?	
ARG	Argentina		.00		
AST	Austria		.00		
AUS	Australia		.00		
BRZ	Brazil		.00		
CAN	Canada		.00		
CZC	Czechoslovakia		.00		
DNM	Denmark		.00		
FRN	France		.00		
GBR	Great Britain		.00		
GER	Germany		.00		

---

### Example: Maintain code files

Code file maintenance works the same way regardless of the code you want to add, change, or delete. When you first begin code file maintenance, the Display and Edit panels do not contain any code information. Use the Edit panel in Add mode to enter the code values your company uses. These code values make up the lists you see on the Display panel and Edit panel in Change mode.

You may have a long list of code values for some codes and a short list for others, depending on the number of different values your company uses for each code. Once you have added code information, you can change code names and descriptions and delete codes in the list.

The rest of this section demonstrates code file maintenance using one example: the Country code. Remember that you use the same types of panels and take the same actions to maintain information for any code.

**Note:** If you want to cancel the changes you've made and back out, use either **F3=Exit** or **F12=Cancel** before you press **Enter**. Once you press **Enter**, the changes are committed to the system.

**To see a list of codes.** When you select an option on the Code File Maintenance menu, the Display panel appears. This display panel shows you the list of codes already defined.

```
AMVAJDFR                      Display Countries                      DISPLAY
                                                                    New mail waiting

Position to code . . . . . _____
Subset by name . . . . . _____

Code   Name
ARG    Argentina
AST    Austria
AUS    Australia
BRZ    Brazil
CAN    Canada
ITY    Italy
CZC    Czechoslovakia
DNM    Denmark
FRN    France
GBR    Great Britain
GER    Germany
GRC    Greece
JAM    Jamaica
JPN    Japan                                     +

F3=Exit      F6=Edit      F7=Backward  F8=Forward
F12=Cancel   F21=Print
```

To change, delete, or add code information, use **F6=Edit**. The Edit panel appears in Change mode.

To return to the Code File Maintenance menu, use **F3=Exit**.

**To change code information.** The Edit panel in Change mode contains the same list of codes and code descriptions as the Display panel. To change the name or description for a code, type over the existing information and press **Enter**.

You cannot change the values in the **Code** column. To change a code value, you must first delete the existing code, using **option 4=Delete**, then add a new code.

```

AMVAGEFR                               Edit Country Data                               CHANGE
                                                                                   New mail waiting

g
Position to code . . . . . ____

Type options; press Enter.
4=Delete

                                     - - - - EEC information - - - - -
Country   Statistical   Member
code      value %      state?

Opt  Code   Name
ARG   ARG   Argentina
AST   AST   Austria
AUS   AUS   Australia
BRZ   BRZ   Brazil
CAN   CAN   Canada
CZC   CZC   Czechoslovakia
DNM   DNM   Denmark
FRN   FRN   France
GBR   GBR   Great Britain
GER   GER   Germany
GRC   GRC   Greece

F3=Exit   F6=Add   F7=Backward   F8=Forward
F12=Cancel F21=Print

```

For example, if you need to change the name of code CZC from “Czechoslovakia” to “Czech Republic,” you type the new name over the current name and press **Enter**.

```

AMVAGEFR                               Edit Country Data                               CHANGE
                                                                                   New mail waiting

Position to code . . . . . ____

Type options; press Enter.
4=Delete

                                     - - - - EEC information - - - - -
Country   Statistical   Member
code      value %      state?

Opt  Code   Name
ARG   ARG   Argentina
AST   AST   Austria
AUS   AUS   Australia
BRZ   BRZ   Brazil
CAN   CAN   Canada
CZC   CZC   Czech Republic
DNM   DNM   Denmark
FRN   FRN   France

```

To add a new code, use **F6=Add**. The Edit Data (Change) panel changes to Edit Data (Add).

**To add codes.** Use the Edit panel in Add mode to enter new codes with their descriptions. Type the information for the codes you want to add. The **Code** field is required.

```
AMVAGEFR                      Edit Country Data                      ADD
                                New mail waiting

Type information; press Enter.

                                - - - - EEC information - - - - -
                                Country   Statistical   Member
                                code      value %      state?

Code   Name
BEL    Belgium

F3=Exit   F6=Change   F7=Backward   F8=Forward
F12=Cancel F21=Print

+
```

When you finish adding code information, press **Enter**. The Edit panel returns to Change mode, and the codes you added now appear in the list.

```
AMVAGEFR                      Edit Country Data                      CHANGE
                                New mail waiting

Position to code . . . .   ____

Type options; press Enter.
4=Delete

                                - - - - EEC information - - - - -
                                Country   Statistical   Member
                                code      value %      state?

Opt  Code   Name
    ARG   Argentina
    AST   Austria
    AUS   Australia
    BEL   Belgium
    BRZ   Brazil
```

**To delete codes.** Type **4** in the **Opt** column next to the codes you want to delete.

```

AMVAGEFR                               Edit Country Data                               CHANGE
                                                                                   New mail waitin

g
Position to code . . . .  ____

Type options; press Enter.
4=Delete

                                     - - - - EEC information - - - -
Country   Statistical   Member
code      value %      state?

Opt  Code   Name
ARG   ARG   Argentina
AST   AST   Austria
AUS   AUS   Australia
4    BEL   Belgium
      BRZ   Brazil
      CAN   Canada
      CZC   Czech Republic
      DNM   Denmark
      FRN   France
      GER   Germany
      GRC   Greece
+

F3=Exit    F6=Add    F7=Backward  F8=Forward
F12=Cancel F21=Print

```

After you type 4 next to all of the codes you want to delete, press **Enter**. The system deletes those codes marked with 4. The list appears again without the deleted codes.

```

AMVAGEFR                               Edit Country Data                               CHAN
GE                                                                                   New mail wait

ing
Position to code . . . .  ____

Type options; press Enter.
4=Delete

                                     - - - - EEC information - - - -
Country   Statistical   Member
code      value %      state?

Opt  Code   Name
ARG   ARG   Argentina
AST   AST   Austria
AUS   AUS   Australia
      BRZ   Brazil
      CAN   Canada
      CZC   Czech Republic
      DNM   Denmark
      FRN   France
      GBR   Great Britain
      GER   Germany
      GRC   Greece

F3=Exit    F6=Add    F7=Backward  F8=Forward
F12=Cancel F21=Print

```

**To end code file maintenance.** When you have finished maintaining codes, use **F3=Exit** to return to the Code File Maintenance menu. If you are on an Edit panel, you return to the Display panel. Use **F3=Exit** again to return to the menu.

---

## Option 9. Work With Location/Component (AMQM50)

Use this option to access the Work With Location/Component Definitions panels so you can define or review what mode of replenishment is used at a location and specify or review other replenishment controls.

### Location/Component panels

- AMQWLC01—Work with Location Component Definitions
- AMQWLC02—Change Defaults
- AMQSCL00—Subset Location Component Definitions
- AMQALC01—Create Location/Component Definition
- AMQCLC01—Change Location/Component Definition
- AMQDLC01—Display Location/Component Definition
- AMQRLC01—Confirm Delete - Location Component Definitions
- AMQVLC01—Validate Location Component Definitions

See Chapter 9, “Work with Repetitive” for more information on using the Work With panels.

## Option 10. Control File (AMQM50)

Use this option to access the Repetitive Control File Maintenance displays that allow you to set tailoring options that control how Repetitive handles certain functions. These options are in addition to those defined during Install/Tailor.

**What information you need:** None.

**What report is printed:** None.

**What forms you need:** None.

Answer the questions that appear on the following displays. These options remain in effect until changed here.

See Chapter 2, “Managing Repetitive Production Management” for more information regarding this option.

### AMQ5Z1—Control File Maintenance

Use this display to enter and maintain Repetitive Control File options.

This display appears when you use choose option 10 on the File Maintenance menu (AMQM50). The shipped defaults appear on the display as shown.

```
AMQ5Z1                                REPETITIVE
                                       Control File Maintenance

Select tailoring options                Page 1 of 4

1. If negative inventory is allowed,
   what action do you want taken
   when a batch/lot controlled
   component has no inventory
   to issue? . . . . . 0                0 = Create an unapplied
                                       planned issue transaction
                                       1 = Create a planned issue
                                       transaction with a
                                       batch/lot ID of #####

2. Do you want to allow changes
   to the quantity or schedule
   date for a primed schedule? . . 0    0 = Do not allow changes
                                       1 = Allow changes

F3=Exit
```

#### What to do

Type in the information requested and press **Enter**. The Repetitive Control file is updated and the next page of options appears.

#### Function keys

F3=Exit returns to the File Maintenance menu (AMQM50).



## AMQ5Z2—Control File Maintenance

Use this display to continue to enter and maintain Repetitive Control File options.

This display appears when you press **Enter** on display AMQ5Z1. The shipped defaults appear on the display as shown.

```
AMQ5Z2                                REPETITIVE
                                Control File Maintenance

Select tailoring options                                Page 2 of 4

3. Do you want to use stock
   reserved at a line location for
   a specific schedule to satisfy
   the need of another schedule? . 1      0 = No
                                           1 = Yes

4. By what percentage can the
   receipt or operation quantity
   for an item exceed the open
   schedule quantities for the
   item? . . . . . blank = Do not check
                                           001% to 999%

5. By what percentage can the
   scrap quantity for an item
   exceed the open schedule
   quantities for the item . . . . . blank = Do not check
                                           001% to 999%

F3=Exit   F12=Cancel
```

### What to do

Type in the information requested and press **Enter**. The Repetitive Control file is updated and the next page of options appears.

### Function keys

F3=Exit returns to the File Maintenance menu (AMQM50).

F12=Cancel returns to the previous display without making any changes.

## AMQ5Z3—Control File Maintenance

Use this display to continue to enter and maintain Repetitive Control File options.

This display appears when you use press **Enter** on display AMQ5Z2. The shipped defaults appear on the display as shown.

```
AMQ5Z3                                REPETITIVE
                                      Control File Maintenance

Select tailoring options                                Page 3 of 4

6. How do you want to apply
   schedule receipt (RM),
   operation reporting (RO), and
   schedule scrap (SM) transaction
   quantities? . . . . . 0           0 = Apply quantity to a single
                                       schedule
                                       1 = Apply quantity to oldest
                                       schedules

7. How do you want to apply
   transaction quantities to
   future schedules? . . . . . 0     0 = Apply only to past and
                                       current schedules
                                       1 = Apply to past, current,
                                       and future schedules

F3=Exit   F12=Cancel
```

### What to do

Type in the information requested and press **Enter**. If EPDM is activated, the next page of options appears. If EPDM is not activated, the Repetitive Control file is updated and the File Maintenance menu (AMQM50) appears.

### Function keys

F3=Exit returns to the File Maintenance menu (AMQM50).

F12=Cancel returns to the previous display without making any changes.

## AMQ5Z4—Control File Maintenance

Use this display to continue to enter and maintain Repetitive Control File options.

This display appears when EPDM is activated and you press **Enter** on display AMQ5Z3. The shipped defaults appear on the display as shown.

```
AMQ5Z4                                REPETITIVE
                                       Control File Maintenance

Select tailoring options                Page 4 of 4

8. Do you want to have revision
   support on schedule receipt (RM),
   operation reporting (RO), and
   schedule scrap (SM) transaction
   quantities? . . . . . 0           0 = Do not apply revision
                                       support
                                       1 = Apply revision support

F3=Exit   F12=Cancel
```

### What to do

Type in the information requested and press **Enter**. The Repetitive Control file is updated and the File Maintenance menu (AMQM50) appears.

### Function keys

F3=Exit returns to the File Maintenance menu (AMQM50).

F12=Cancel returns to the previous display without making any changes.

---

## Option 11. Variable Capacity (AMQM50)

Use this option to perform file maintenance on variable capacity records when EPDM is activated, and you are blocked from access to the Production Facility files using option 4 on this menu.

**What information you need:** None.

**What report is printed:** Variable Capacity Maintenance (AMVTC).

**What forms you need:** TM-01.

See 'AMVTC1—Variable Capacity Maintenance (Select)' and the associated displays to complete this task.

---

## Chapter 8. General Ledger Interface

The General Ledger Interface captures business activity data from the REP application and converts the data into ledger entries. When you select option 6 on the REP Main Menu (AMQM00), the General Ledger Interface menu (AMQM60) appears. Use this menu to manage account assignments, edit and assign accounts, and create ledger entries.

Option 1. Account Assignment Rule Management (AMQM60) .....	8-21
Option 2. Transaction Account Assignment (AMQM60) .....	8-23
Option 2. Transaction Account Assignment (AMQM60) .....	8-23

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### Where to start

If you are using this interface for the first time, start out slowly. Here are some suggestions:

1. Review the section about the transaction types defined for each application. Read the rest of this section to see how the charge, offset, and variance (IM only) accounting works.
2. Start with COM first even if you have all four applications installed. The accounting issues in COM are simpler. Then implement the IM, PC&C, and REP interfaces as a group.
3. Be sure you completely understand the process you currently use to record application activity in your ledger. Focus on the following points:
  - What are the accounting practices you currently have for the business activity processed by COM, IM, PC&C, and REP?
  - How do you currently implement these policies?
  - What are the internal controls and reconciliations you currently do?
  - What accounting practice changes would you make if they were possible to make?
4. Reconcile the data in the XA applications to the balances in the general ledger. Ideally, the difference should be zero. If it is not zero, find out what the difference is and the reason for it.
5. Select the General Ledger interface in COM, IM, PC&C, and REP using the CAS install/tailor menu option. Selecting the interface enables you to use the General Ledger interface menus. It does not mean the application saves transactions for its General Ledger interface. Keep your existing ledger interface process in place for now.
6. Set up your rules and rule priorities to implement your current accounting practices. Use the Simulate Account Assignment menu option to test your work.
 

**Note:** From an accounting perspective, do not try to implement new accounting practices now.
7. Decide which transaction types you want to process via the ledger interface. Use the Maintain Interface Control File menu option on the General Ledger Management menu to activate the transactions for the General Ledger interface. The transactions remain activated until you deactivate them.
 

**Note:** It is best to do this at the start of an accounting period.

8. Use the menu options to assign accounts and create ledger entries. Reconcile the results to your current interface. If all is well, activate the General Ledger interface in GL using the CAS install/tailor menu option. Otherwise, determine what went wrong, and try again in the next period.

**Note:** If you do not use the XA General Ledger application, you can use these menus to capture data to send to your own programs. Just select the interface but do not activate it in order to use your own general ledger programs. You can create a General Ledger Master (GELMAS) file and work with the Temporary General Ledger (TEMGEN) records that the General Ledger interface creates.

9. Change the rules and rule priorities to make improvements to your current accounting practices.

**Note:** From an accounting perspective, if you are near the end of your fiscal year, first go through year-end processing with your current ledger interfaces before switching to this General Ledger interface. Start using the XA ledger interfaces at the start of the new year.

---

## REP transaction types for General Ledger interface

The General Ledger interface in REP creates ledger entries to record labor, machine, and overhead costs to manufacturing schedules. Accounting for other REP activities, such as material costs and production receipts is handled through the General Ledger interface in IM.

In REP, all costing is done by backflushing. When users enter transactions, REP calculates material, labor, machine, and overhead costs based on the quantities claimed and your current standards. Then REP charges these costs to the manufacturing schedule. When REP backflushes labor, material, machine, and overhead costs, it passes data to the General Ledger interface. This interface converts the transactions into ledger entries.

The following table shows the transaction types that the General Ledger interface in REP processes.

Remember that the General Ledger interface is making ledger entries to record material charged to manufacturing schedules and production receipts. You can account for scrap expense using the General Ledger interface in IM or REP. Using the interface in either application gets acceptable results. However, to charge scrap expense to a production facility, you must use the General Ledger interface in REP.

*Table 8-1. REP transaction types and accounting*

Type	Description	Charge	Offset
RSET	Setup labor	Work in process	Payroll cost applied
RRUN	Run labor	Work in process	Payroll cost applied
RMAC	Machine cost	Work in process	Machine cost applied
ROHD	Overhead cost	Work in process	Overhead applied
RVAR	Schedule variance	Variance expense	Work in process

When you use the General Ledger interface, use it with your current accounting practices. Consider the following when you make your decisions:

- A single work-in-process account. Use this account to accumulate all costs.

- Separate work-in-process accounts by cost element. For example, you might have work-in-process accounts for these cost elements:
  - Balance (start of the year)
  - Material
  - Setup labor
  - Run labor
  - Machine cost
  - Overhead
  - Production receipts
  - Manufacturing order scrap
- Separate work-in-process accounts for different product families. Within this structure, you could track costs by the elements shown above.
- Tracking labor, machine, and overhead costs by production facility within the cost elements above. Doing so allows you to generate departmental expense reports that measure performance by comparing “earned” versus “standard” costs.

REP applies labor, machine, and overhead costs to manufacturing schedules at standard rates. Ultimately, the costs applied at these rates must equal the actual costs incurred. To manage this, structure your chart of accounts so that you can monitor applied and incurred costs.

When you have an “under” or “over” applied condition, you need to understand why and take action. The following may help you:

- If the standards and rates that REP uses reflects annualized estimates and the under or over applied condition reflects short term fluctuations, the differences will balance out over the year. No action is needed.
- If the standards and rates that REP uses are wrong, you need to do one of the following depending on your accounting practices:
  - Write off the over or under applied balance as a variance. Adjust standards or rates to prevent future problems.
  - Adjust finished goods inventory and cost of sales to absorb the over or under applied balance. Adjust standards or rates to prevent future problems.
  - Adjust standards and rates so that future work-in-process charges absorb the over or under applied balance.

General Ledger balances are intended to reflect the activity that occurs in the system. For the General Ledger interface in REP, this means that the sum of the costs in the open manufacturing schedules equals the sum of the work-in-process balances in the General Ledger. If you are having problems reconciling, consider the following:

- Do your account assignment rules result in the right accounts being debited and credited?
- Have you adjusted REP balances using file maintenance transactions? If you do use file maintenance, you must make online journal entries to record the impact on inventory ledger balances.
- Have you made online journal entries to GL that affect work in process? If you have, you must adjust manufacturing schedule balances using file maintenance transactions.

## Accounting classes

At times, you need information from people who are not accountants so that you can classify business events. The accounting class fields let you get this information without requiring your non-accounting users to use account codes:

*Table 8-2. Accounting class fields*

Field	COM	IM	PC&C	REP
Item Accounting Class	x	x	x	x
Order Accounting Class		x	x	
Schedule Accounting Class				x
Production Facility Accounting Class			x	x

Usually, the users who maintain item, order, schedule, and production facility data are not accountants. You need to work out a process for setting up and maintaining these fields with the users who normally maintain these files.

### Item accounting class

Item accounting class can be entered in either the Item Master or the Item Balance file. If an item has an item accounting class in both files, XA uses the one in the Item Balance file.

Suppose you have item number 1000. In the Item Master record, it has item accounting class XXX. In the Item Balance record for warehouse 001, it has item accounting class ZZZ. If you process a transaction for item 1000 and warehouse 001, XA uses item accounting class ZZZ. If you process a transaction for item 1000 and any other warehouse, XA uses item accounting class XXX.

### Order accounting class and schedule accounting class

Order accounting class can be entered for each manufacturing order during manufacturing order entry. It is stored in the Manufacturing Order Master file. For example, you use this accounting class to have separate accounts for commercial and governmental work in process.

### Production facility accounting class

Production facility accounting class is maintained in the Production Facility file. Production planners define production facilities in ways that make sense from a production planning viewpoint. These definitions do not always match accounting needs. For example, you can use production facility accounting class to treat two or more production facilities as if they were one entity for accounting purposes.

When XA processes transactions that refer to an operation number, it uses the Open Operations Detail file to identify the production facility. XA then gets the production facility accounting class and makes it part of the General Ledger interface data.

## Rules, rule priorities, and simulation

In a manual system, you could work with documents and can use all the data in the document to make account assignment decisions. The General Ledger interface lets



you assign accounts based on a subset of the fields that make-up each transaction. This table shows the fields that each application uses when assigning accounts.

<b>COM</b>	<b>IM</b>	<b>PC&amp;C and REP</b>
Transaction type	Transaction type	Transaction type
Company number	Item number	Order number,
Customer number	Item class	schedule number
Customer class code	Item type	Order accounting class
Sales code	Item accounting class	schedule accounting
Salesrep number	Order number	class
Territory number	Order accounting class	Job number
Item number	Reason code	Finished item number
Item class	Warehouse	Finished item warehouse
Item accounting class		Item class
Warehouse		Item type
Special charge reference		Item accounting class
Tax code		Production facility ID
		Production facility
		accounting class

When you set up account assignment rules and rule priorities, you can base them on the transaction type and any combination of fields provided for each interface, as shown in the table. You can have multiple rules for one transaction and define the priority for using these rules in account assignments. All ledger entries have two sides. You can define the account assignment rules separately for each side of the ledger entry.

The General Ledger interface lets you test your rules and rule priorities. Use the Simulate Account Assignments menu option to enter data for a “would-be” transaction. When you press **Enter**, the application displays the accounts that would be assigned and the rules used to assign those accounts. Function keys let you move from the simulation display to the displays used to maintain rules and rule priorities.

## Account types: charge, offset, and variance

COM, IM, PC&C, and REP are single entry systems that indicate the flow of events by the sign of the transaction. Quantity and amount are two examples. When a planned requisition (IP) transaction quantity and amount are positive, it means that the item was taken from inventory and made part of a manufacturing order. When the quantity and amount are negative, it means that a previously entered IP transaction did not actually take place and its effect on the XA data needs to be reversed.

The GL application is a double entry system. When the General Ledger interface assigns accounts, it creates debit and credit entries that reflect the impact of the originating application’s transactions on account balances. The rules and rule priorities determine which accounts are debited and credited. The sign of the underlying transaction determines whether the impact on an account is a debit or credit.

If you set up a rule for IP transactions that said “debit work in process and credit inventory,” the rule would only work when the transaction quantity and amount were positive. Following such a rule would produce the wrong results when quantity and amount were negative. The way the General Ledger interface avoids this problem is by using the account assignment rules you define in terms of charge, offset, and variance accounts for each application:

Table 8-3. Charge, offset, and variance for the applications

Appl	Charge	Offset	Variance
IM	Inventory	Work in process Expense Clearing accounts	Purchase price Cost adjustment Quantity
COM	Accounts Receivable Cost of Sales	Revenue Sales tax Inventory	Not applicable
PC&C	Work In Process	Overhead Applied Inventory Variances	Not applicable
REP	Work In Process	Clearing Accounts Variances	Not applicable

**Note:** Only IM has all account types: charge, offset, and variance. COM, PC&C, and REP use only charge and offset accounts.

In the IM to GL interface, the charge account normally refers to the inventory account and the offset account always refers to the other side of the transaction. For example, in the IP transaction in Inventory Management, the charge account is inventory and the offset account is work in process. The IM to GL interface knows that an IP transaction normally decreases inventory and increases work in process. Therefore, it interprets the sign of the amount as follows:

Table 8-4. How the interface interprets signed data into debits and credits

IP transaction amount	Debit account	Credit account
Positive	Work in process	Inventory
Negative	Inventory	Work in process

## How rules and rule priorities are used to assign accounts

In order to create account assignment rules, you need to know which accounts to use. Suppose your chart of accounts includes these accounts:

Table 8-5. Sample: chart of accounts

Account	Description	Account	Description
1320	Work in process	2010	Undistributed outside operations
1325	Government contracts	5015	Machine cost
1330	Government contracts - special jobs	5025	Overhead applied

Suppose the following list represents your accounting practices for labor transactions.

1. All labor transactions go to company 01.
2. Manufacturing costs are normally charged to account 1320.
3. Any order with an order accounting class of 007 is charged to account 1325, with one exception.
4. Exception: an order with order accounting class 007 and job number J9999 is charged to account 1330.
5. Offset entry for machine costs is account 5015; Offset entry for overhead costs is account 5025.

6. Run labor and setup labor costs are offset to account 2010.

When you create an account assignment rule, you enter the information in the rule fields that must match the actual data for the saved transaction.

The numbers for the accounting practices shown in the following table refer to the previous numbered list:

Table 8-6. Sample: account assignment rules using sample transactions

Rule	Tran. type	Order no.	Order		Charge		Offset		Comments
			acctg class	Job no.	Co	Acct	Co	Acct	
R1	LMAC						01	5015	Accounting practice 1, 5
R2	LOHD						01	5025	Accounting practice 1, 5
R3	LRSA						01	2010	Accounting practice 1, 6
R4	LSSA						01	2010	Accounting practice 1, 6
R5	L***				01	1320			Accounting practice 1, 2
R6	L***		007		01	1325			Accounting practice 1, 3
R7	L***		007	J9999	01	1330			Accounting practice 1, 4

The rule priorities for these rules would be:

Table 8-7. Sample: rule priorities for assigning sample transactions

Priority	Trans. type	Seq. no.	Order acctg class	Job no.	Comments
P1	LMAC	100			Match on transaction type only
P2	LOHD	100			Match on transaction type only
P3	LRSA	100			Match on transaction type only
P4	LSSA	100			Match on transaction type only
P5	L***	100	1	1	Rule for class and job number must be applied first. Otherwise, sequence number 200 would cause a match on class only.
P6	L***	200	1		Match on order accounting class
P7	L***	300			Match on transaction type only.

“L\*\*\*” identifies a generalized transaction type. For example, a PC&C rule containing a generalized transaction type of L\*\*\* applies to any valid General Ledger interface transaction in PC&C that starts with L.

When the General Ledger interface assigns accounts, it uses both the rules and the rule priorities. Rule priorities are applied against the rules in the following order:

1. The rule priority with a specific transaction type, such as LMAC, is applied before any rule priority with a generalized transaction type, such as L\*\*\*.
2. Within a transaction type, the rule priority with the lower sequence number, such as 100, is applied before a rule priority with a higher sequence number, such as 200.
3. The General Ledger interface keeps looking until it assigns both charge and offset accounts. For IM, it assigns at least two of the following: charge, offset, and variance.

Because the first rule that matches the transaction is the one used for that transaction, be sure to prioritize your rules from most specific to most general.

To assign account 1320 to a transaction for a government contract with order accounting class of 007 and job number J9999, you want General Ledger interface to look for those values before using a rule for order accounting class of 007 and any job number. In the preceding table, priority P5 establishes that rule R7, a match on order accounting number 007 and job number J9999 will be found before a match using rules 5 or 6.

These rule priorities are stored in the application’s Account Assignment Sequence file.

The following shows how the General Ledger interface assigns accounts to actual transactions, using your rules and rule priorities:

*Table 8-8. Sample: results of account assignments using rules and rule priorities for sample transactions*

Trans type	Order no.	Order acctg class	Job no.	Charge		Offset		Comments
				Co	Acct	Co	Acct	
LMAC	M000010	007	J0001	01	1325	01	5015	Applied rule priorities P1, P6. Met rules R1, R6.
LOHD	M000020	007	J0001	01	1325	01	5025	Applied rule priorities P2, P6. Met rules R2, R6.
LRSA	M000030	007		01	1325	01	2010	Applied rule priorities P3, P6. Met rules R3, R6.
LSSA	M000040			01	1320	01	2010	Applied rule priorities P4, P7. Met rules R4, R5.
LOHD	M000050	007	J9999	01	1330	01	5025	Applied rule priorities P2, P5. Met rules R2, R7.
LMAC	M000060		J9999	01	1320	01	5015	Applied rule priorities P1, P7. Met rules R1, R5.

When the General Ledger interface assigns accounts, it assigns the charge and offset accounts independently. Therefore, it can have one transaction with charge and offset accounts assigned to different company numbers:

- The account assignment rules or rule priorities have been set up incorrectly. Correct the rules and rule priorities. Then you can correct the assigned accounts by running the account assignment again or by editing the assigned accounts.
- The account assignment rules and rule priorities are correct. See “Intercompany accounting”.

## Setting up your rules

Everything depends on how you set up and prioritize account assignment rules.

Each application has an account assignment file that contains the rules for assigning accounts to the transactions saved by the application. The rules are defined by transaction type alone in IM, PC&C, and REP, and by company and transaction type in COM. The rules can use any combination of the fields shown in the previous table showing charge, offset, and variance for the applications.

When you define a rule for assigning accounts, you must also define its priority. If you do not, XA gives you a warning. Rules without rule priorities are ignored.

## Setting up your rule priorities

Account assignment rules can overlap. It is possible for one transaction to match the conditions specified in two or more rules. When this happens, the General Ledger interface “breaks the tie” by using rule priority sequence numbers to determine the order in which the rules are applied when assigning accounts. The rule priority with the lowest sequence number is used first in assigning accounts. The application’s Account Assignment Sequence file contains the information about how you want to prioritize your rules.

Understanding your accounting practices is essential to setting up rule priorities so that you get the right results. In many cases the same rule priorities can apply to many different transaction types. If so, set up rule priorities for one transaction type, verify that you get the right results, and then use it as a model to set up rule priorities for other transaction types.

## Shortcuts to setting up rules and rule priorities

Several features of the Maintain Rules menu option and the Maintain Rule Priorities menu option can make these tasks easier:

- Generalized transactions. Lets you define one set of rules that apply to two or more transaction types.
- Copy. Lets you copy between transaction types, and add a record by copying an existing record and changing it.

You can also switch quickly between the displays used to define rules, define rule priorities, and simulate the results.

### Generalized transactions

You can define accounting rules for each transaction type. However, if you want to use the same rules for multiple transaction types, you can use generalized transactions to shorten the task.

**Note:** IM and REP do not support generalized transaction types. Rules for assigning accounts to IM and REP transactions are too transaction-specific to make “generalized transactions” useful.

You can use “generalized transaction” types to define accounting rules and rule priorities for blocks of related transactions. For example, COM has a generalized transaction type called “R\*\*\*\*” which you can use for all revenue transaction types.

Here are ways to use generalized transaction types:

- For rules that are truly the same for transactions, set up the wild card transaction type and do not bother setting up one for any individual transaction type.
- For isolated exceptions for specific transaction types, set up a rule for each type that is an exception. Then set up the generalized transaction type. The General Ledger interface applies the specific rules first, and then uses the generalized transaction rules. Remember to set up both the application’s Account Assignment (rules) and Account Assignment Sequence (rule priorities) files in the same way.

- For transaction types where the differences are substantial, consider using the generalized transaction type as a skeleton for setting up the specific transaction types. Use the copying feature, described next, to copy the generalized transaction type into the specific transaction type. Then change what you need to change.

## Copy

The General Ledger interface lets you copy rules without worrying about the credit and debit signs. The charge, offset, and variance account conventions are set up so that it is possible to copy rules for opposite transactions and still have the right debit or credit signs assigned to the ledger entries that result. By handling transaction amounts this way, the General Ledger interface lets you copy rules for “opposite” transaction types and still generate the right debit and credit ledger entries.

When you maintain rules or maintain rule priorities, you are asked to identify the records you want to process. If you select the Group Copy option, the General Ledger interface lets you copy from one transaction type to another. You can copy all the records for a given transaction type or a subset of those records. Once you do this, the ledger interfaces use the records that are on file to build new ones. Then, you can make additions, changes, and deletions as necessary. Group copy works best when you are setting up your rules and rule priorities for the first time.

Use “copy for add” to handle situations where you want to add the same rule to many transaction types. First, enter the full rule for the first transaction type. Then, copy it for other transaction types. When you change the transaction type and press **Enter**, you have a new rule.

## Simulating account assignments

You can set up simple or complex accounting rules depending on your needs. Use the Simulate Account Assignments menu option to test the accounting rules you define. After you enter information about a hypothetical transaction, the General Ledger interface assigns accounts to it using the same logic that it would use with a “live” transaction. It displays these accounts and tells you which account assignment rules were used to assign the account. If accounts cannot be assigned to a transaction, the General Ledger interface issues a warning message.

You can make any adjustments that are necessary by changing either the rules or rule priorities. Here are questions you can ask yourself:

- Did you enter the simulated transaction data correctly?
- Have you set up the account assignment rules correctly?
- Have you assigned the right priority to the account assignment rules?

In many cases, the information displayed about the rules used to assign accounts contain valuable clues about what is causing the problem.

## Converting transactions into ledger entries

When the application processes transactions, it saves the transactions for its General Ledger interface that you have identified for ledger processing. Use the Maintain Interface Control File menu option on the General Ledger Management menu to see the transaction types that apply to the application. Only those transaction types you select are sent to the ledger interface.

Normally, you activate all transaction types to be passed to the General Ledger interface. Exceptions are cases where the transaction is coming from an XA or non-XA application that has already made the ledger entries you need.

## Assigning accounts to transactions

When COM, IM, PC&C, or REP does its processing, it saves the transactions that you have selected and stores them until you are ready to assign accounts. As it saves the transactions, it keeps track of the number of records that need to have accounts assigned.

When you select the Assign Accounts menu option, the General Ledger interface shows you the status of the records that have been saved for ledger entries: number assigned, number unassigned.

How does the Assign Accounts menu option work?

- You can select to assign accounts to records that have not previously had accounts assigned.
- You can select to assign accounts to all records, including those that had already been assigned accounts. This selection could be very useful to you if you discover that the account assignment rules are wrong.
- You can select to list the contents of the transaction file, based on selection criteria you selected, of the transactions in the transaction file that have not yet been converted into ledger entries.

Assigning accounts lets you control whether or not the General Ledger interface prints a listing that documents what happened during the session even if accounts are not assigned.

You can choose to assign accounts interactively or in batch mode. Your transaction volumes may determine which mode you want to use.

## Editing assigned accounts

You can optionally use the Edit Assigned Accounts menu option to review and change the accounts assignments before you use the Create Ledger Entries menu option.

When you select the menu option, you see how many records for each transaction type that has had accounts assigned and how many of those records have invalid accounts or have charge, offset, and variance accounts in different companies.

How can accounts be invalid accounts when the General Ledger interface edits them against the General Ledger Master file (GELMAS) or the IFM tables for units, natures, and unit/nature combinations? The account could have been deleted from GL or IFM

after you defined the account assignment rule. In this case, you need to assign a valid account number before you can convert the transactions into ledger entries.

The General Ledger interface counts a transaction as a multiple company transaction whenever the charge, offset, and variance accounts do not have the same company number. You do not have to fix multiple company transactions if your accounting practices allow for them. The General Ledger interface will generate intercompany control account entries, based on the intercompany processing records you defined, to balance debits and credits by company when you create the ledger entries. If your practices do not allow for transactions that span companies, correct the problem and change your account assignment rules or rule priorities.

To help you locate the accounts you need to edit, use subsetting or processing options, such as invalid only or multiple company only, to narrow the list to a smaller subset.

### Ways of editing assigned accounts

You can override the charge, offset, and variance accounts assigned by the system by typing in a valid company and account. You can split a transaction so that the amount goes to multiple charge, offset or variance accounts. When you split a transaction, the sum of the split amounts must equal the original transaction.

For example, suppose you have an IM transaction that looks like this:

*Table 8-9. Sample: transaction before splitting*

Charge			Offset			Variance		
Co	Account	Amount	Co	Account	Amount	Co	Account	Amount
01	4000	1000.00	01	5000	900.00-	01	6000	100.00-

Suppose you decide you need to split the charge amount equally between the present account and company-account, 02-4000. After the split, the IM transaction looks like this:

*Table 8-10. Sample: transaction after splitting*

Charge			Offset			Variance		
Co	Account	Amount	Co	Account	Amount	Co	Account	Amount
01	4000	500.00	01	5000	900.00-	01	6000	100.00-
02	4000	500.00						

The multiple company count is increased by 1 and the record status is changed to “S” for split and “M” for multiple company. You see this information on the Edit Assigned Accounts display.

Here are some guidelines for splitting transactions:

- You must enter the split data for the charge, offset, and variance accounts separately.
- It is possible to split a transaction so it goes to more than one company number. If you do this, the General Ledger interface includes the transaction in its multiple company record counts.
- It is possible to unsplit a transaction that you have split by removing the company/account amount for each split you made.



## Creating ledger entries

You can see which transaction types have records, have had accounts assigned, and are waiting to be converted into ledger entries. When you are satisfied that the General Ledger interface has assigned the right accounts to your application transactions, you can convert them to ledger entries. Use the Create Ledger Entries menu option to create Temporary General Ledger (TEMGEN) file records or IFM ledger transactions and purge the GL interface transactions for which ledger entries are created.

The simple approach is to select **ALL** to convert them to ledger entries and write them to the TEMGEN file as a single ledger transmittal. Use this approach if the following is true:

- Timing differences between the originating applications and GL is not a concern.
- You want to summarize all transactions ledger entries in the same way.
- You use a net intercompany control account for both intercompany receivables and payables.

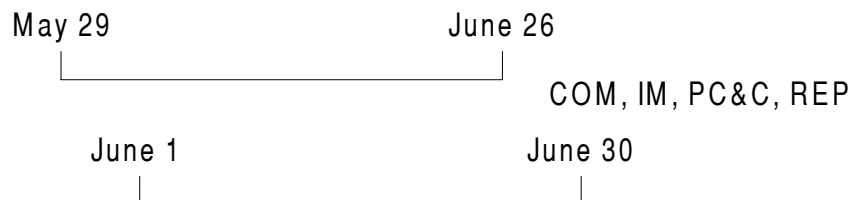
Otherwise, you need to use the selection criteria and subsetting functions to divide the saved transactions into separate ledger transmittals that meet your needs.

When IFM is interfacing, the only differences in this process are:

- Ledger entries are summarized by units and nature.
- Intercompany accounting is done differently and handled within IFM. Refer to the *IFM User's Guide* for more information.

### Ledger entry dates and GL periods

The GL and IFM applications are designed to measure financial activity that occurs during a specified time period. The COM, IM, PC&C, and REP applications are designed to provide on-going support in specific areas. Periodic measurements in these applications can be done independently of the periodic measurements in General Ledger or IFM. Timing differences could arise. For example, suppose your ledger uses a 12-month calendar and you want to create ledger entries for June. You only want transactions dated between June 1 and June 30. If COM, IM, PC&C and REP cut off June processing on June 30, there is no problem. However, it is possible for COM, IM, PC&C and REP cut-off dates to be different from the GL cut-off:



In this example, GL or IFM works on the calendar month but IM, PC&C, and REP applications are cut off on the last Friday of the month. The monthly balances in the originating application (COM, IM, PC&C, REP) cover the period from May 29 to June 26. If you use the originating application's accounting period, the data passed to General Ledger or IFM covers the period from May 29 to June 26 and is inconsistent with the General Ledger or IFM accounting period.

The General Ledger interface lets you handle timing differences between the originating application and GL or IFM by using the subsetting function:

- If you subset General Ledger entries based on transaction date, the ledger entries passed to GL or IFM cover the same dates as the GL accounting period. But, the amounts in GL or IFM will not agree with the amounts in the originating application.
- If you subset General Ledger entries based on the originating application's period number, the amounts passed to GL or IFM agree with the amounts in the originating application. However, the time period covered by the ledger entries will not be consistent with the time period covered by the same GL period.

If you must have both reconcilable data and the right dates, do one of the following:

- Avoid these problems by cutting off GL or IFM, COM, IM, and PC&C at the same time.
- Or, select General Ledger entries based on the originating application's period number. Use the online journal function to accrue for the post-cutoff activity. Reverse this accrual at the start of the next month. Run a System i Query against the application's General Ledger Interface Transaction file to find out how much has to be accrued. Select records with dates that fall within the accounting month that have not been converted into ledger entries.

You still need to be able to reconcile the amounts in General Ledger or IFM to the data in COM, IM, PC&C and REP. In order to record ledger entries in the right time period, the General Ledger interface needs to know:

- The ledger month or period for the ledger entries.
- The COM, IM, PC&C, and REP transactions that belong to the ledger month or period you specify.

## Summarizing ledger entries

The General Ledger interface saves the transactions that COM, IM, PC&C and REP process, but does not summarize transactions before assigning accounts. For many, using the General Ledger interface to convert the transactions into ledger entries without summarizing, results in unnecessary GL ledger entries. For example, if you pass unsummarized COM transactions to GL as ledger entries, you will have two ledger entries for each line on your invoices.

You can summarize the transaction data that you send to GL. You can make this choice for each account type: charge, offset, and variance. Within each type of account, you have these options:

- No summarization
- Summarization by company, account, and transaction type
- Summarization by company and account

If International Financial Management (IFM) is installed and interfacing, you can summarize transactions by unit and nature. Refer to the IFM User's Guide for additional information.

You can also summarize some transactions and not others. Suppose you normally want to summarize IM transactions by company and account. However, you want unsummarized ledger entries for the RP and CA transactions so that you can analyze material received versus material invoiced. To do this, have a special ledger entry transmittal for the RP and CA transactions. In this transmittal, leave the charge entries

unsummarized while summarizing offset and variance entries. Then, run a second ledger entry transmittal where the charge, offset, and variance entries for the remaining transaction types are fully summarized.

After you send ledger entries to GL, XA does not provide a way to summarize them. Therefore, the number of times you create ledger entries each month influences the degree of summarization you achieve. For example: if you create ledger entries every day, then only the transactions converted into ledger entries on that day are summarized. If you create ledger entries once a month, then all the transactions for that month are converted as a summarized, single set of ledger entries.

### Intercompany accounting

When IFM is installed, IFM does intercompany accounting when it receives ledger entries file from IM. See the *IFM User's Guide* for more information. In XA, debits and credits must balance by company number. You need to set up intercompany account records, using the Maintain Intercompany Accounts menu option. Then when you create ledger entries, you specify that multiple company transactions are to be processed. When the General Ledger interface creates ledger entries, it verifies that debits and credits are balanced by company. If they do not, it automatically generates intercompany control account entries to balance debits and credits.

The following example shows how the General Ledger interface creates intercompany control account entries. Suppose that after creating ledger entries, the General Ledger interface detects that total debits and credits are in balance, but there is an imbalance between companies. When this happens, the General Ledger interface uses the Intercompany Accounting file to generate intercompany control account entries to balance debits and credits by company:

Table 8-11. Sample: intercompany control account entries

	Company 01	Company 02	Company 03
Debits	3,000	2,000	1,000
Credits	2,000-	1,000-	3,000-
Net debits or credits	1,000	1,000	2,000-
Intercompany balancing entries	1,000-	1,000-	2,000
Net after intercompany balancing	0	0	0

The General Ledger interface lets you control how ledger entries are created for intercompany amounts by the way you set up information in the Intercompany Account file. Use the Maintain Intercompany Accounts menu option to set up information in this file.

- With the net intercompany account method, each company has a single intercompany control account with each related company that nets intercompany receivables and payables.
- With the separate intercompany account method, each company has separate intercompany receivable and payable accounts with each related company.

Suppose you have two companies, company 01 and company 02, and you have the following intercompany transfers:

*Table 8-12. Sample: intercompany transfers*

Company 01 transfers to Company 02	1,000
Company 02 transfers to Company 01	300

If you have net intercompany accounts, then a single intercompany control account entry suffices:

*Table 8-13. Sample: net intercompany control account entry*

Company	Account	Debit	Credit
01	Intercompany control	700	
02	Intercompany control		700

If you have separate intercompany receivable and liability accounts, then each company's intercompany sales have to be handled separately:

*Table 8-14. Sample: separate intercompany control account entries*

Company	Account	Debit	Credit
01	Intercompany receivables	1,000	
02	Intercompany liabilities		1,000
02	Intercompany receivables	300	
01	Intercompany liabilities		300

If you use the net intercompany control account method, set up intercompany accounts from company 01 to all the other related companies in the Intercompany Account file.

If you use the separate intercompany control account method, you must set up receivables and payables for each combination of companies in the Intercompany Account file. For example, suppose you have three companies. You would need six records in your Intercompany Account file:

*Table 8-15. Sample: records in Intercompany Account file*

From		To	
Company	Account	Company	Account
01	Receivable	02	Payable
01	Receivable	03	Payable
02	Receivable	01	Payable
02	Receivable	03	Payable
03	Receivable	01	Payable
03	Receivable	02	Payable

Next, create separate General Ledger entry transmittals for each company number that is selling to related companies. Suppose you use separate intercompany payable and receivable accounts, and warehouse 002 belongs to company 02. The company allows employees from company 01 to requisition items from this warehouse for manufacturing orders that belong to company 01. To get the right intercompany accounting results, do the following:

- Use 02 as the primary company number.
- Select the transaction types that represent issues, such as IP, IS, and so on.
- Use subsetting to limit the ledger entry transmittal to transactions from warehouse 002.

### Splitting ledger entries

The General Ledger interface scans the transactions from the originating application to determine if they should be converted into ledger entries. The following must be true for the transactions to be eligible:

- The transaction type must meet the criteria you entered
- The charge, offset, and variance accounts must be valid accounts

If transactions do not meet these requirements, they remain in the General Ledger Transaction file (xxxTRN, where xxx identifies your application). The record count information tells you if this has happened. Suppose you use the General Ledger interface in IM to create ledger entries for all transactions other than the CA. Before and after record counts might look like this:

Table 8-16. Sample: valid and invalid ledger entries

	Before		After	
	Records	Invalid	Records	Invalid
CA transactions	1,000	5	1,000	5
All other transactions	100,000	100	100	100

All of the CA transactions remained in the file as well as all other transactions with invalid account assignments.

When the General Ledger interface creates ledger entries, it first splits each transaction into separate charge, offset, and variance records. Here is a condensed example to illustrate this point:

Table 8-17. Sample: split ledger entries

Item	Charge			Offset			Variance		
	Co	Acct	Amt	Co	Acct	Amt	Co	Acct	Amt
1000	01	040	500.00	01	004	450.00-	01	999	50.00-

**Note:** Only IM uses variance accounts.

This record would be converted into three TEMGEN records:

*Table 8-18. Sample: split entries converted to TEMGEN records*

<b>Item</b>	<b>Company</b>	<b>Account</b>	<b>Amount</b>	<b>Debit or Credit</b>
1000	01	040	500.00	Debit
1000	01	004	450.00	Credit
1000	01	999	50.00	Credit

If IFM is installed, IM creates an IFM transaction that consists of a transaction header and G/L lines that correspond to the TEMGEN records.

The General Ledger interface summarizes the split records according to the summarization rules you entered.

After the General Ledger interface has processed all the transactions, it completes the job:

- Balances debits and credits by company and creates intercompany accounting entries if needed.
- Purges the converted transactions from the General Ledger Transaction Interface file and updates record counts.
- Adds the summarized ledger entries to the TEMGEN file or to IFM's file.
- Prints an audit trail.

If you use a non-XA general ledger, you need to have your own programs convert the TEMGEN records to your ledger's format. Use either the XA TEMGEN print and clear menu option or your own routines to ensure that the TEMGEN records are not passed to your ledger for a second time.

The General Ledger Interface works with the XA General Ledger application and non-XA general ledgers. If XA General Ledger is installed and interfacing and you specify transactions to be passed to General Ledger, your ledger reports will automatically reflect the ledger entries these interfaces create. If you have a non-XA general ledger application, you must convert the ledger entries to your system's format.

```
AMIMBO                               Inventory Management          *****
                                     General Ledger Interface

Type option or command; press Enter.

  1. Account Assignment Rule Management >>
  2. Transaction Account Assignment >>
  3. General Ledger Management >>

==> _____

F3=Exit      F4=Prompt    F9=Retrieve  F10=Actions
F11=Job status F12=Return   F22=Messages
```

**Option 1. Account Assignment Rule Management.** Use this option to go to the Account Assignment Rule Management menu (AMCM91) to maintain and list rules, rule priorities, intercompany accounts, and simulate account assignment.

**Option 2. Transaction Account Assignment.** Use this option to go to the Transaction Account Assignment menu (AMCM92) to assign accounts or edit the charge and offset accounts already assigned.

**Option 3. General Ledger Management.** Use this option to go to the General Ledger Management menu (AMCM93) to create ledger entries, print a Temporary General Ledger Listing, print and clear the Temporary General Ledger file, change transaction descriptions, maintain the General Ledger file, and print a Chart of Accounts.

**Note:** If you do not use the XA General Ledger application, you can use these menus to capture data to send to your own programs. Just select the interface but do not activate it in order to use your own general ledger programs. You can create a General Ledger Master (GELMAS) file and work with the Temporary General Ledger (TEMGEN) records that the General Ledger interface creates.

```
AMQM60                      Repetitive Production Management          *****
                             General Ledger Interface

Type option or command; press Enter.

  1. Account Assignment Rule Management >>
  2. Transaction Account Assignment >>
  3. General Ledger Management >>

==> _____

F3=Exit      F4=Prompt    F9=Retrieve   F10=Actions
F11=Job status F12=Return   F22=Messages
```

**Option 1. Account Assignment Rule Management.** Use this option to go to the Account Assignment Rule Management menu (AMQM61) to maintain and list rules, rule priorities, intercompany accounts, and simulate account assignments.

**Option 2. Transaction Account Assignment.** Use this option to go to the Transaction Account Assignment menu (AMQM62) to assign accounts or edit the charge and offset accounts already assigned.

**Option 3. General Ledger Management.** Use this option to go to the General Ledger Management menu (AMQM63) to create ledger entries, print a Temporary General Ledger Listing, print and clear the Temporary General Ledger file, change transaction descriptions, maintain the General Ledger file, and print a Chart of Accounts.

**Note:** If you do not use the XA General Ledger application, you can use these menus to capture data to send to your own programs. Just select the interface but do not activate it in order to use your own general ledger programs. You can create a General Ledger Master (GELMAS) file and work with the Temporary General Ledger (TEMGEN) records that the General Ledger interface creates.



## Option 1. Account Assignment Rule Management (AMQM60)

When you select option 1 on the REP General Ledger Interface menu (AMQM60), the Account Assignment Rule Management menu appears. Use this menu option to define rules for assigning accounts, prioritizing these rules, defining the accounts for intercompany processing, and simulating how XA will apply your rules to specific transactions. You can also get listings for the files used to assign accounts from this menu.

```

AMQM61                      Repetitive Production Management          *****
                             Account Assignment Rule Management

Type option or command; press Enter.

    1. Maintain Rules
    2. Maintain Rules Priorities
    3. Simulate Account Assignments
    4. Maintain Intercompany Accounts
    5. List Rules
    6. List Rule Priorities
    7. List Intercompany Accounts

-----

F3=Exit      F4=Prompt   F9=Retrieve  F10=Actions
F11=Job status F12=Return  F22=Messages

```

**Option 1. Maintain Rules.** Use this option to create, change, copy, delete, and show account assignment rule information.

**Option 2. Maintain Rule Priorities.** Use this option to create, change, copy, and delete account assignment priority information.

**Option 3. Simulate Account Assignments.** Use this option to simulate assigning charge and offset accounts to sample transactions that you enter.

**Option 4. Maintain Intercompany Accounts.** Use this option to create, change, copy, and delete company information used to assign intercompany receivable and liability accounts when ledger entries reflect transactions between companies.

**Option 5. List Rules.** Use this option to determine the transaction types to appear on your Rules List.

**Option 6. List Rule Priorities.** Use this option to determine the transaction types to appear on your Rule Priorities List.

**Option 7. List Intercompany Accounts.** Use this option to determine the companies to appear on the Intercompany Account File List.

Refer to the *Inventory Management User's Guide* for information about the displays related to this menu.

---

Option 1	AMVG501	Specify Rules to Maintain (Select)
	AMVG502	Maintain Rules
	AMVG503	Confirm Delete of Rules
	AMVG506	Create Account Assignment Rule
	AMVG507	Change Account Assignment Rule
	AMVG508	Copy Account Assignment Rule
	AMVG510	Display Account Assignment Rule
	AMVG511	Specify Rules to Copy
	AMVG512	Specify Rules to Delete
Option 2	AMVG601	Specify Priorities to Maintain (Select)
	AMVG602	Maintain Rule Priorities
	AMVG603	Confirm Delete of Rule Priorities
	AMVG606	Specify Priorities to Copy (Select)
	AMVG607	Specify Priorities to Delete
Option 3	AMVG401	Simulate Account Assignments
Option 4	AMVG101	Specify Intercompany Accounts to Maintain
	AMVG102	Maintain Intercompany Accounts
	AMVG103	Confirm Delete of Intercompany Accounts
	AMVG106	Specify Intercompany Accounts to Copy
	AMVG107	Specify Intercompany Accounts to Delete
Option 5	AMVG801	List Rules
Option 6	AMVG901	List Rule Priorities
Option 7	AMVG201	List Intercompany Accounts

## Option 2. Transaction Account Assignment (AMQM60)

When you select option 2 on the REP General Ledger Interface menu (AMQM60), the Transaction Account Assignment menu (AMQM62) appears. Use this menu option to have XA assign accounts to transactions and edit the accounts that XA assigns.

```

AMQM62                Repetitive Production Management          *****
                        Transaction Account Assignment

Type option or command; press Enter.

    1. Assign Accounts
    2. Edit Assigned Accounts

==> _____

F3=Exit      F4=Prompt   F9=Retrieve   F10=Actions
F11=Job status  F12=Return  F22=Messages
  
```

**Option 1. Assign Accounts.** Use this option to select transaction types that should be assigned account numbers. A display appears that shows the number of records (by transaction type) that are eligible to have accounts assigned. You select which transaction types go through the account assignment process.

**Option 2. Edit Assigned Accounts.** Use this option to select which transaction types with assigned account numbers are to be edited. You can change accounts previously assigned or split transactions into multiple accounts.

Refer to the *Inventory Management User's Guide* for information about the displays related to this menu.

---

Option 1	AMVGA01	Assign Accounts
	AMVGA02	Specify Accounts to Assign
Option 2	AMVGB01	Edit Assigned Accounts (Select)
	AMVGB02	Edit Assigned Accounts
	AMVGB06	Specify Transactions to Edit

## Option 3. General Ledger Management (AMQM60)

When you select option 3 on the REP Main Menu (AMQM60), the General Ledger Management menu (AMQM63) appears. Use this menu option to create ledger entries after you review the accounts that XA assigned. This menu also lets you control which transactions are passed to the ledger interfaces. Use the Maintain Interface Control File menu option to control which transactions are passed.

```

AMQM63                      Repetitive Production Management          *****
                             General Ledger Management

Type option or command; press Enter.

    1. Create Ledger Entries
    2. Print Temporary General Ledger
    3. Print and Clear Temporary General Ledger
    4. Maintain Interface Control File
    5. Maintain General Ledger Master
    6. List Chart of Accounts

==> _____

F3=Exit      F4=Prompt    F9=Retrieve   F10=Actions
F11=Job status  F12=Return  F22=Messages

```

**Option 1. Create Ledger Entries.** Use this option to create General Ledger entries for assigned accounts. You can select the transaction types that will be converted into ledger entries and enter data required for summarization and multiple company accounting.

**Option 2. Print Temporary General Ledger.** Use this option to print the Temporary General Ledger Listing.

**Option 3. Print and Clear Temporary General Ledger.** Use this option to print the Temporary General Ledger Listing and clear the Temporary General Ledger file. You can use this option only if General Ledger is not installed and interfacing. You must use the General Ledger application to print and clear if it is installed and interfacing.

**Option 4. Maintain Interface Control File.** Use this option to change the indicator that specifies whether or not transactions are sent to General Ledger and to change transaction descriptions that were shipped with the application in the General Ledger Interface Transaction Description file (LITDES).

**Option 5. Maintain General Ledger Master.** Use this option to add, change, and delete general ledger records. You can also view the status of a General Ledger Master File maintenance session and print the General Ledger Master Entry/Change listing (if chosen during application tailoring). You can use this option only if General Ledger is not installed and interfacing. You must use the General Ledger application to perform maintenance if it is installed and interfacing.

**Option 6. List Chart of Accounts.** Use this option to select the accounts and companies to print on your Chart of Accounts listing.

Refer to the *Inventory Management User's Guide* for information about the displays related to this menu.

---

Option 1	AMVG301	Create Ledger Entries
	AMVG304	Specify Ledger Entries to Create
Option 2	AMV601	Temporary General Ledger Print
Option 3	AMV601	Temporary General Ledger Print and Clear
Option 4	AMVL101	Maintain Interface Control File
	AMVL102	Maintain Interface Control File
Option 5	AMV041	General Ledger Maintenance (Select)
	AMV042	General Ledger Maintenance (Add, Change, Delete)
	AMV043	General Ledger maintenance (Status)
Option 6	AMV021	Chart of Accounts

## Chapter 9. Work with Repetitive

When you select option 7 on the Repetitive Production Management Main Menu, (AMQM00), the Work with Repetitive menu appears. This menu provides access to the REP work with options.

Option 1. Work with Schedules (AMQM70).....	9-6
Option 2. Work with Date Schedules (AMQM70) .....	9-8
Option 3. Work with Item/Warehouse Schedules (AMQM70).....	9-10
Option 4. Work with Line Schedules (AMQM70) .....	9-12
Option 5. Work with Planner Schedules (AMQM70) .....	9-14
Option 6. Work with Schedule Operations (AMQM70) .....	9-16
Option 7. Work with Schedule Materials (AMQM70) .....	9-19
Option 8. Work with Schedule Allocations (AMQM70) .....	9-22
Option 9. Work with Schedule Descriptions (AMQM70).....	9-24
Option 10. Work with Item/Line (AMQM70).....	9-26
Option 11. Work with Location/Components (AMQM70) .....	9-40
Option 12. Work with Component Status (AMQM70) .....	9-48

The options on this menu take you to work with lists that allow you to work with different objects. For detailed information about how to use the work with lists, see *Working with XA*.

Options 10 and 11 allow you to create, change, and delete as well as review information. Because these panels are more complex, panels and field descriptions are included for those options only. Online Help is available for all of the panels and fields in all options.

```

AMQM70                      Repetitive Production Management          *****
*
                                Work With

Type option or command; press Enter.

    1. Schedules
    2. Date Schedules
    3. Item Schedules
    4. Line Schedules
    5. Planner Schedules
    6. Schedule Operations
    7. Schedule Materials
    8. Schedule Allocations
    9. Schedule Descriptions
   10. Item/Line
   11. Location/Component
   12. Component Status

==> _____

F3=Exit      F4=Prompt    F9=Retrieve   F10=Actions
F11=Job status  F12=Return   F22=Messages

```

You can select from the following options:

**Option 1. Schedules.** Use this option to see a list of schedules. Use the different views of the list to identify which schedule you want to work with.

**Option 2. Date Schedules.** Use this option to see a list of schedules for a particular date. Use the different views of the list to identify which schedule you want to work with.

**Option 3. Item Schedules.** Use this option to see a list of schedules for an item/warehouse combination. Use the different views of the list to identify which schedule you want to work with.

**Option 4. Line Schedules.** Use this option to see a list of schedules for a particular line. Use the different views of the list to identify which schedule you want to work with.

**Option 5. Planner Schedules.** Use this option to see a list of schedules for a particular planner. Use the different views of the list to identify which schedule you want to work with.

**Option 6. Schedule Operations.** Use this option to see a list of operations for a particular schedule. Use the different views of the list to identify which operation for a schedule you want to work with.

**Option 7. Schedule Materials.** Use this option to see a list of component items used in a particular schedule. Use the different views of the list to identify which component item you want to work with.

**Option 8. Schedule Allocations.** Use this option to see a list of component allocations for a particular schedule. Use the different views of the list to identify which component allocation you want to work with.

**Option 9. Schedule Descriptions.** Use this option to see a list of additional operation descriptions for a schedule.

**Option 10. Item/Line.** Use this option to see a list of item/line and component/line information so you can define or review what products are to be built, and which production lines are used to build these products. You can create, change, and delete information as well as review information on these panels.

**Option 11. Location/Component.** Use this option to see a list of location and component information so you can define or review what mode of replenishment is used at a location or specify or review other replenishment controls. You can create, change, delete, and validate information as well as review information on these panels.

**Option 12. Component Status.** Use this option to see a list of information so you can review the replenishment cycle controlled by the Component Status (CMPSTS) file.

## Where to go from a work with list

Find your work with list panel in the left column and read to the right to see where each option takes you. Remember, you can always return to the menu to select another menu option.

<b>Work with list panels</b>	<b>Supplied options</b>	<b>Panel where option takes you</b>
Work with Component/Line Definitions	2=Change	Change Component/Line Item Definition
	7=Mass change	Mass Change
	15=Item detail	Display Item detail
Work with Component Status	16=Item warehouse	Display Item warehouse
	5=Display	Display Component Status
	15=Item detail	Display Item detail
	16=Item warehouse	Display Item warehouse
Work with Date Schedules	20=Location components	Display Location Components
	5=Display	Display Schedule Detail
	20=Materials	Work with Schedule Materials
	30=Operations	Work with Schedule Operations
	40=Allocations	Work with Schedule Allocations
Work with Item/Line Definitions	50=Descriptions	Work with Schedule Descriptions
	1=Create	Create Item/Line Definitions
	2=Change	Change Item/Line Definitions
	4=Delete	Delete Item/Line Definitions Confirmation
	5=Display	Display Item/Line Definitions
	15=Item detail	Display Item detail
Work with Item/Warehouse Schedules	16=Item warehouse	Display Item warehouse
	20=Component definition	Work With Component/Line Definitions
	5=Display	Display Schedule Detail
	20=Materials	Work with Schedule Materials
	30=Operations	Work with Schedule Operations
Work with Line Schedules	40=Allocations	Work with Schedule Allocations
	50=Descriptions	Work with Schedule Descriptions
	5=Display	Display Schedule Detail
	20=Materials	Work with Schedule Materials
	30=Operations	Work with Schedule Operations
	40=Allocations	Work with Schedule Allocations
	50=Descriptions	Work with Schedule Descriptions



<b>Work with list panels</b>	<b>Supplied options</b>	<b>Panel where option takes you</b>
Work with Location Components	1=Create	Create Location Component
	2=Change	Change Location Component
	4=Delete	Delete Location Component Confirmation
	5=Display	Display Location Component
	7=Validate	Validate Location Component Confirmation
	15=Item detail	Display Item detail
Work with Planner Schedules	16=Item warehouse	Display Item warehouse
	5=Display	Display Schedule Detail
	20=Materials	Work with Schedule Materials
	30=Operations	Work with Schedule Operations
	40=Allocations	Work with Schedule Allocations
Work with Schedule Allocations	50=Descriptions	Work with Schedule Descriptions
	5=Display	Display Discrete Allocation Detail
Work with Schedule Descriptions	5=Display	Display Schedule Description Detail
Work with Schedule Material Allocations	5=Display	Display Discrete Allocation Detail
Work with Schedule Materials	5=Display	Display Schedule Material Detail
	40=Allocations	Work with Schedule Material Allocations
Work with Schedule Operation Descriptions	5=Display	Display Schedule Description Detail
Work with Schedule Operations	5=Display	Display Schedule Operation Detail
	20=Materials	Work with Schedule Operation Materials
	50=Descriptions	Work with Schedule Operation Descriptions
Work with Schedule Operation Materials	5=Display	Display Schedule Material Detail
	40=Allocations	Work with Schedule Material Allocations
Work with Schedules	5=Display	Display Schedule Detail
	20=Materials	Work with Schedule Materials
	30=Operations	Work with Schedule Operations
	40=Allocations	Work with Schedule Allocations
	50=Descriptions	Work with Schedule Descriptions

---

## Display detail panels for Repetitive Production Management

When you type option 5 next to an entry on a work with list, you see a display detail panel showing detailed information about that entry.

### Where to go from a display detail page

You can return only to the work with panel where you started.

---

## Commands

You can use commands only on the command line that appears on work with panels.

### Display commands

Use one of the following commands to display detail for a particular object:

Command	Object
<b>DSPSOR</b>	schedules
<b>DSPSORDSC</b>	schedule descriptions
<b>DSPSORMTL</b>	schedule materials
<b>DSPSOROPS</b>	schedule operations
<b>DSPCMPSTS</b>	component status
<b>DSPILN</b>	item line
<b>DSPLOCCMP</b>	location component

### Work with commands

Use one of the following commands to work with a particular object:

Command	Object
<b>WRKDTESOR</b>	date schedules
<b>WRKITMSOR</b>	item schedules
<b>WRKLINSOR</b>	line schedules
<b>WRKPLNSOR</b>	planner schedules
<b>WRKSMTALC</b>	schedule material allocations
<b>WRKSOPDSC</b>	schedule operation descriptions
<b>WRKSOPMTL</b>	schedule operation materials
<b>WRKSOR</b>	schedules
<b>WRKSORALC</b>	schedule allocations
<b>WRKSORDSC</b>	schedule descriptions
<b>WRKSORMTL</b>	schedule materials
<b>WRKSOROPS</b>	schedule operations
<b>WRKCLN</b>	component/line detail
<b>WRKCOMPSTS</b>	component status
<b>WRKILN</b>	item/line detail
<b>WRKLOCCMP</b>	location component detail

---

## Option 1. Work with Schedules (AMQM70)

You can see a list of schedules. There is more information than can fit on a single panel. Unless you change the sequence, you see views in this order:

1. Schedule item information, including: schedule number, item number, item description, warehouse, and line.
2. Schedule configuration, including: schedule number, item number, warehouse, line, S-number, and planner.
3. Schedule hours, including: schedule number, item number, warehouse, line, due date, schedule hours, line hours scheduled, and line hours available.
4. Schedule status, including: schedule number, item number, due date, schedule quantity, open quantity, status, and last transaction flag.
5. Additional schedule information, including: schedule number, item number, due date, start date, alternate routing, carry forward option, and reference number.

Use the views to identify which schedule you want to work with.

**What information you need:** None. From this list of schedules, you can identify which one you want.

**What reports are printed:** None.

**What forms you need:** None.

The panels used with this option are listed below.

### Work with Schedules panels

Use these panels when you want to review schedule information.

#### Work with Schedules–AMQWSO1

This panel shows you a list of all schedules.

- Enter **5** in the **Option** field next to the appropriate schedule number to see more information about a schedule. See “Display Schedule Detail–AMQDSO1”.
- Enter **20** in the **Option** field to view a list of component materials for a particular schedule. See “Work with Schedule Materials–AMQWSM01”.
- Enter **30** in the **Option** field to view a list of operations for a particular schedule. See “Work with Schedule Operations–AMQWSR01”.
- Enter **40** in the **Option** field to view a list of component allocations for a particular schedule. See “Work with Schedule Allocations–AMQWSA01”.
- Enter **50** in the **Option** field to view a list of additional operation descriptions for a particular schedule. See “Work with Schedule Materials–AMQWSM01”.

## Change Defaults–AMQWSO02

To see schedule item information first on the Work with Schedules panel, enter 1 in the **First view** field. To see schedule configuration information first, enter 2. To see schedule hours information first, enter 3. To see schedule status information first, enter 4. To see additional schedule information first, enter 5.

## Subset Schedules List–AMQSSO00

To narrow the list of schedules shown on the Work with Schedules panel, enter the values that you want to use to select schedule records. You can select schedules by the following fields: schedule number, item number, item description, item warehouse, production line, planner, due date, status, schedule group, and reference number. The appropriate selection values appear to the right of each field. Remember to use **F8 (Forward)** to see the rest of the fields.

## Specify Schedule to Display–AMQDSO00

To select the schedule detail you want to see, enter the schedule number on this panel. You only see this panel if you call this function from a command line on another work with list.

## Display Schedule Detail–AMQDSO01

This panel shows you detailed information for the schedule you selected. Information for the selected schedule appears on this panel but on different pages and in the following categories:

- Schedule overview
- Additional schedule information
- Schedule hours and rates
- Item characteristics
- Cost summary.

To find specific information in a schedule record, page forward to the category of information you want.

## Change Defaults–AMQDSO02

To change the order in which you see pages of information on the Display Schedule Detail panel, enter the sequence of pages you want to see.

---

## Option 2. Work with Date Schedules (AMQM70)

You can see a list of schedules for a particular date. There is more information than can fit on a single panel. Unless you change the sequence, you see views in this order:

1. Schedule item information, including: line, item number, item description, warehouse, and schedule number.
2. Schedule configuration, including: line, item number, warehouse, S-number, and planner.
3. Schedule status, including: line, item number, warehouse, schedule quantity, line hours scheduled, and line hours available.
4. Schedule hours, including: line, item number, warehouse, start date, schedule quantity, open quantity, status, and last transaction flag.
5. Additional schedule information, including: line, item number, warehouse, schedule quantity, schedule group, alternate routing, carry forward option, and reference number.

Use the views to identify which schedule you want to work with.

**What information you need:** None. From this list of schedules, you can identify which one you want.

**What reports are printed:** None.

**What forms you need:** None.

The panels used with this option are listed below.

### Work with Date Schedules panels

Use these panels when you want to review schedules for a particular due date.

#### Specify Date Schedules to Work With—AMQWDS00

To select the schedules for which you want to view information, enter the schedule due date on this panel.

#### Work with Date Schedules—AMQWDS01

This panel shows you a list of all schedules for the date you entered.

- Enter **5** in the **Opt** field next to the appropriate schedule number to see more information about a particular schedule for this due date. See “Work with Date Schedules—AMQWDS01” on page 9-8.
- Enter **20** in the **Opt** field to view a list of component materials for a schedule for this due date. See “Work with Schedule Materials—AMQWSM01”.
- Enter **30** in the **Opt** field to view a list of operations for schedule for this due date. See “Work with Schedule Operations—AMQWSR01”.
- Enter **40** in the **Opt** field to view a list of component allocations for a schedule for this due date. See “Work with Schedule Allocations—AMQWSA01”.

- Enter **50** in the **Opt** field to view a list of additional operation descriptions for a schedule for this due date. See “Option 9. Work with Schedule Descriptions (AMQM70)“.

### **Change Defaults–AMQWDS02**

To see schedule item information first on the Work with Date Schedules panel, enter **1** in the **First view** field. To see date schedule configuration information first, enter **2**. To see date schedule hours information first, enter **3**. To see date schedule status information first, enter **4**. To see additional schedule information first, enter **5**.

### **Subset Date Schedules List–AMQSDS00**

To narrow the list of date schedules shown on the Work with Date Schedules panel, enter the values that you want to use to select date schedule records. You can select date schedules by the following fields: production line, item number, item description, warehouse, schedule number, planner, status, schedule group, and reference number. The appropriate selection values appear to the right of each field. Remember to use **F8 (Forward)** to see the rest of the fields.

---

## Option 3. Work with Item/Warehouse Schedules (AMQM70)

You can see a list of schedules for an item/warehouse combination. There is more information than can fit on a single panel. Unless you change the sequence, you see views in this order:

1. Schedule configuration, including: due date, line, schedule quantity, S-number, planner, and schedule number.
2. Schedule hours, including: due date, line, schedule quantity, schedule hours, line hours scheduled, and line hours available.
3. Schedule status, including: due date, line, start date, schedule quantity, open quantity, status, and last transaction flag.
4. Additional schedule information, including: due date, line, schedule quantity, schedule group, reference, and alternate routing.
5. Carry forward information.

Use the views to identify which schedule you want to work with.

**What information you need:** None. From this list of schedules, you can identify which one you want.

**What reports are printed:** None.

**What forms you need:** None.

The panels used with this option are listed below.

### Work with Item/Warehouse Schedules panels

Use these panels when you want to review schedules for a particular item/warehouse combination.

#### Specify Item/Warehouse Schedules to Work With—AMQWIS00

To select the schedules for which you want to view information, enter the item number and warehouse ID on this panel.

#### Work with Item/Warehouse Schedules—AMQWIS01

This panel shows you a list of all schedules for the item/warehouse combination you entered.

- Enter **5** in the **Option** field next to the appropriate schedule number to see more information about a particular schedule for this item/warehouse combination. See “Display Schedule Detail—AMQDSO01”.
- Enter **20** in the **Option** field to view a list of component materials for a schedule for this item/warehouse combination. See “Work with Schedule Materials—AMQWSM01”.
- Enter **30** in the **Option** field to view a list of operations for schedule for this item/warehouse combination. See “Work with Schedule Operations—AMQWSR01”.
- Enter **40** in the **Option** field to view a list of component allocations for a schedule for this item/warehouse combination. See “Work with Schedule Allocations—AMQWSA01”.

- Enter **50** in the **Option** field to view a list of additional operation descriptions for a schedule for this item/warehouse combination. See “Work with Schedule Descriptions–AMQWSD01”.

### **Change Defaults–AMQWIS02**

To see schedule configuration information first on the Work with Item/Warehouse Schedules panel, enter **1** in the **First view** field. To see schedule hours information first, enter **2**. To see schedule status information first, enter **3**. To see additional schedule information first, enter **4**. To see carry forward information first, enter **5**.

### **Subset Item/Warehouse Schedules List–AMQWIS00**

To narrow the list of item/warehouse schedules shown on the Work with Item/Warehouse Schedules panel, enter the values that you want to use to select item/warehouse schedule records. You can select item/warehouse schedules by the following fields: due date, production line, planner, schedule number, status, schedule group, reference, planner, job number, and reference number. The appropriate selection values appear to the right of each field. Remember to use **F8 (Forward)** to see the rest of the fields.



---

## Option 4. Work with Line Schedules (AMQM70)

You can see a list of schedules for a particular line. There is more information than can fit on a single panel. Unless you change the sequence, you see views in this order:

1. Schedule item information, including: item number, item description, warehouse, due date, and schedule number.
2. Schedule configuration, including: item number, warehouse, due date, schedule quantity, S-number, and planner.
3. Schedule hours, including: item number, warehouse, due date, schedule quantity, schedule hours, line hours scheduled, and line hours available.
4. Additional schedule information, including: item number, warehouse, due date, schedule quantity, schedule group, alternate routing, and reference.
5. Schedule status, including: item number, warehouse, due date, start date, schedule quantity, open quantity, status, and last transaction flag.
6. Carry forward information.

Use the views to identify which schedule you want to work with.

**What information you need:** None. From this list of schedules, you can identify which one you want.

**What reports are printed:** None.

**What forms you need:** None.

The panels used with this option are listed below.

### Work with Line Schedules panels

Use these panels when you want to review schedules for a particular production line.

#### Specify Line Schedules to Work With—AMQWLS00

To select the schedules for which you want to view information, enter the production line on this panel.

#### Work with Line Schedules—AMQWLS01

This panel shows you a list of all schedules for the production line you entered.

- Enter **5** in the **Option** field next to the appropriate schedule number to see more information about a particular schedule for this production line.
- Enter **20** in the **Option** field to view a list of component materials for a schedule for this production line.
- Enter **30** in the **Option** field to view a list of operations for schedule for this production line.
- Enter **40** in the **Option** field to view a list of component allocations for a schedule for this production line.
- Enter **50** in the **Option** field to view a list of additional operation descriptions for a schedule for this production line.

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## Change Defaults–AMQWLS02

To see schedule item information first on the Work with Line Schedules panel, enter **1** in the **First view** field. To see schedule configuration information first, enter **2**. To see schedule hours information first, enter **3**. To see schedule status information first, enter **4**. To see additional schedule information first, enter **5**. To see carry forward information first, enter **6**.

## Subset Line Schedules List–AMQSLS00

To narrow the list of line schedules shown on the Work with Line Schedules panel, enter the values that you want to use to select line schedule records. You can select line schedules by the following fields: item number, item description, warehouse, due date, schedule number, planner, status, schedule group, and reference number. The appropriate selection values appear to the right of each field. Remember to use **F8 (Forward)** to see the rest of the fields.

---

## Option 5. Work with Planner Schedules (AMQM70)

You can see a list of schedules for a particular planner. There is more information than can fit on a single panel. Unless you change the sequence, you see views in this order:

1. Schedule item information, including: item number, item description, warehouse, line, and due date.
2. Schedule configuration, including: item number, warehouse, line, due date, S-number, and schedule number.
3. Schedule hours, including: item number, warehouse, line, due date, schedule quantity, schedule hours, line hours scheduled, line hours available, and alternate routing.
4. Schedule status, including: item number, warehouse, line, due date, schedule quantity, open quantity, status, and last transaction flag.
5. Additional schedule information, including: item number, warehouse, line, due date, schedule quantity, schedule group, carry forward option, and reference.

Use the views to identify which schedule you want to work with.

**What information you need:** None. From this list of schedules, you can identify which one you want.

**What reports are printed:** None.

**What forms you need:** None.

The panels used with this option are listed below.

### Work with Planner Schedules panels

Use these panels when you want to review schedules for a particular planner.

#### Specify Planner Schedules to Work With—AMQWPS00

To select the schedules for which you want to view information, enter the planner on this panel.

#### Work with Planner Schedules—AMQWPS01

This panel shows you a list of all schedules for the planner you entered.

- Enter **5** in the **Option** field next to the appropriate schedule number to see more information about a particular schedule for this planner.
- Enter **20** in the **Option** field to view a list of component materials for a schedule for this planner.
- Enter **30** in the **Option** field to view a list of operations for schedule for this planner.
- Enter **40** in the **Option** field to view a list of component allocations for a schedule for this planner.
- Enter **50** in the **Option** field to view a list of additional operation descriptions for a schedule for this planner.

## Change Defaults–AMQWPS02

To see schedule item information first on the Work with Planner Schedules panel, enter **1** in the **First view** field. To see schedule configuration information first, enter **2**. To see schedule hours information first, enter **3**. To see schedule status information first, enter **4**. To see additional schedule information first, enter **5**.

## Subset Planner Schedules List–AMQSPS00

To narrow the list of planner schedules shown on the Work with Planner Schedules panel, enter the values that you want to use to select planner schedule records. You can select planner schedules by the following fields: item number, item description, item warehouse, production line, due date, schedule number, status, schedule group, and reference number. The appropriate selection values appear to the right of each field. Remember to use **F8 (Forward)** to see the rest of the fields.

---

## Option 6. Work with Schedule Operations (AMQM70)

You can see a list of operations for a particular schedule. There is more information than can fit on a single panel. Unless you change the sequence, you see views in this order:

1. Operation overview, including: operation sequence number, operation sequence description, production facility ID, and active/inactive flag.
2. Operation quantities, including: operation sequence number, reporting point, quantity scheduled, quantity received, quantity scrapped, and yield.
3. Operation dates, including: operation sequence number, scheduled start date, actual start date, and scheduled completion date.
4. Operation hours, including: operation sequence number, standard setup, backflush setup, standard machine, backflush machine, standard labor, and backflush labor.

Use the views to identify which operation for a schedule you want to work with.

**What information you need:** The schedule number whose schedule operations you want to see.

**What reports are printed:** None.

**What forms you need:** None.

The panels used with this option are listed below.

### Work with Schedule Operations panels

Use these panels when you want to review schedule operation information.

#### Specify Schedule Operations to Work With—AMQWSR00

To select the schedule for which you want to view operations, enter the schedule number on this panel.

#### Work with Schedule Operations—AMQWSR01

This panel shows you a list of operations for a particular schedule.

- Enter **5** in the **Option** field next to the appropriate operation number to see information about this operation.
- Enter **20** in the **Option** field to view a list of component materials for a particular operation.
- Enter **50** in the **Option** field to view a list of additional operation descriptions for a particular schedule.

#### Change Defaults—AMQWSR02

To see operation overview information first on the Work with Schedule Operations panel, enter **1** in the **First view** field. To see operation quantities information first, enter **2**. To see operation dates information first, enter **3**. To see operation hours first, enter **4**.

## Subset Schedule Operations List–AMQSSR00

To narrow the list of schedule operations shown on the Work with Schedule Operations panel, enter the values that you want to use to select schedule operation records. You can select schedule operations by the following fields: operation sequence number, operation description, production facility, and scheduled completion date. The appropriate selection values appear to the right of each field.

## Specify Schedule Operation to Display–AMQDSR00

To select the schedule operation detail you want to see, enter the schedule number and operation sequence number on this panel. You only see this panel if you call this function from a command line on another work with list.

## Display Schedule Operation Detail–AMQDSR01

This panel shows you detailed information for the schedule operation you selected. Information for the selected schedule operation appears on this panel but on different pages and in the following categories:

- Operation characteristics
- Operation quantity and date summary
- Operation standards
- Period performance
- To-date performance
- Operation costs

To find specific information in a schedule operation record, page forward to the category of information you want.

## Change Defaults–AMQDSR02

To change the order in which you see pages of information on the Display Schedule Operation Detail panel, enter the sequence of pages you want to see.

## Specify Schedule Operation Materials to Work With–AMQWOM00

To select the schedule for which you want to view operation materials, enter the schedule number and operation sequence number on this panel. You only see this panel if you call this function from a command line on another work with list.

## Work with Schedule Operation Materials–AMQWOM01

This panel shows you a list of operation materials for a particular schedule.

- Enter **5** in the *Option* field next to the appropriate operation number to see more information about materials for a particular schedule.
- Enter **40** in the *Option* field to view a list of component allocations for a particular schedule.

## **Change Defaults–AMQWOM02**

To see material description information first on the Work with Schedule Operation Materials panel, enter **1** in the **First view** field. To see material location/date information first, enter **2**. To see material quantities information first, enter **3**.

## **Subset Schedule Operation Materials List–AMQSOM00**

To narrow the list of schedule operation materials shown on the Work with Schedule Operation Materials panel, enter the values that you want to use to select schedule operation material records. You can select schedule operation materials by the following fields: component item number, item description, line location, and required date.

## **Specify Schedule Operation Descriptions to Work With—AMQWOD00**

To select the schedule for which you want to view operation sequence descriptions, enter the schedule number and operation sequence number on this panel. You only see this panel if you call this function from a command line on another work with list.

## **Subset Schedule Operation Descriptions List–AMQSOD00**

To narrow the list of schedule operation descriptions shown on the Work with Schedule Operation Descriptions panel, enter the values that you want to use to select schedule operation description records. You can select schedule operation descriptions by the following fields: operation description sequence number, and operation sequence description.

---

## Option 7. Work with Schedule Materials (AMQM70)

You can see a list of component items used in a particular schedule. There is more information than can fit on a single panel. Unless you change the sequence, you see views in this order:

1. Material description, including: component item number, component item description, user sequence number, active/inactive flag, and item type.
2. Material location/date information, including: component item number, unit of measure, floor stock code, supply location, line location, required date, and date last issued.
3. Material quantities, including: component item number, quantity required, quantity replenished, quantity issued, and quantity scrapped.
4. Operation information, including: component item number, operation where first used, production facility, and operation status.
5. Cost information, including: component item number, standard cost, and issue cost.

Use the views to identify which component item you want to work with.

**What information you need:** The schedule number whose schedule materials you want to see.

**What reports are printed:** None.

**What forms you need:** None.

The panels used with this option are listed below.

### Work with Schedule Materials panels

Use these panels when you want to review schedule material information.

#### Specify Schedule Materials to Work With—AMQWSM00

To select the schedule material for which you want to view information, enter the schedule number on this panel.

#### Work with Schedule Materials—AMQWSM01

This panel shows you a list of all schedule materials.

- Enter **5** in the **Option** field next to the appropriate schedule number to see more information about a component item for a schedule.
- Enter **40** in the **Option** field to view a list of allocations for a particular component.

#### Change Defaults—AMQWSM02

To see material description information first on the Work with Schedule Materials panel, enter **1** in the **First view** field. To see material location/date information first, enter **2**. To see material quantities information first, enter **3**. To see operation information first, enter **4**. To see cost information first, enter **5**.



## Subset Schedule Materials List–AMQSSM00

To narrow the list of schedule materials shown on the Work with Schedule Materials panel, enter the values that you want to use to select schedule material records. You can select schedule materials by the following fields: component item number, item description, item warehouse, line location, operation where used, production facility, and required date. The appropriate selection values appear to the right of each field.

## Specify Schedule Material to Display–AMQDSM00

To select the schedule material detail you want to see, enter the schedule number, component item number, component warehouse ID, user sequence number, and sequence number on this panel. You only see this panel if you call this function from a command line on another work with list.

## Display Schedule Material Detail–AMQDSM01

This panel shows you detailed information for the schedule material you selected. Information for the selected schedule material appears on this panel but on different pages and in the following categories:

- Material overview
- Quantity summary
- Quantity activity
- Cost summary.

To find specific information in a schedule material record, page forward to the category of information you want.

## Change Defaults–AMQDSM02

To change the order in which you see pages of information on the Display Schedule Material Detail panel, enter the sequence of pages you want to see.

## Specify Schedule Material Allocations to Work With–AMQWMA00

To select the schedule for which you want to view component allocations, enter the schedule number and component item number on this panel. You only see this panel if you call this function from a command line on another work with list.

## Work with Schedule Material Allocations–AMQWMA01

This panel shows you a list of component allocations for a particular schedule.

Enter **5** in the **Option** field next to the appropriate schedule number to see more information about a material allocation for a particular component.

## Change Defaults–AMQWMA02

To see allocation information first on the Work with Schedule Material Allocations panel, enter **1** in the **First view** field.

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## **Subset Schedule Material Allocations List–AMQSMA00**

To narrow the list of schedule material allocations shown on the Work with Schedule Material Allocations panel, enter the values that you want to use to select schedule material allocation records. You can select schedule material allocations by the following fields: location, batch/lot, and FIFO date.

---

## Option 8. Work with Schedule Allocations (AMQM70)

You can see a list of component allocations for a particular schedule. There is more information than can fit on a single panel. Unless you change the sequence, you see views in this order:

1. Allocation information, including: component item number, component item description, location, and allocation quantity.
2. Item information, including: component item number, allocation quantity, location, batch/lot, and FIFO date.

Use the views to identify which component allocation you want to work with.

**What information you need:** The schedule number whose schedule allocations you want to see.

**What reports are printed:** None.

**What forms you need:** None.

The panels used with this option are listed below.

### Work with Schedule Allocations panels

Use these panels when you want to review schedule allocation information.

#### Specify Schedule Allocations to Work With—AMQWSA00

To select the schedule allocation for which you want to view information, enter the schedule number on this panel.

#### Work with Schedule Allocations—AMQWSA01

This panel shows you a list of component allocations for the schedule you specified.

Enter **5** in the **Option** field next to the appropriate schedule number to see more information about a component allocation for a schedule.

#### Change Defaults—AMQWSA02

To see allocation information first on the Work with Schedule Allocations panel, enter **1** in the **First view** field. To see item information first, enter **2**.

#### Subset Schedule Allocations List—AMQSSA00

To narrow the list of schedule allocations shown on the Work with Schedule Allocations panel, enter the values that you want to use to select schedule allocation records. You can select schedule allocations by the following fields: component item, item description, line location, batch/lot, and FIFO date. The appropriate selection values appear to the right of each field.

## **Specify Discrete Allocation to Display–AMIDDA00**

To select the discrete allocation detail you want to see, enter item number, warehouse ID, warehouse location, batch/lot number, FIFO date, order number, item sequence number, and release number on this panel. You only see this panel if you call this function from a command line on another work with list.

## **Display Discrete Allocation Detail–AMIDDA01**

This panel shows you detailed information for the discrete allocation you selected. Information for the selected discrete allocation appears on this panel but on different pages and in the following categories:

- Manufacturing order allocation detail
- Schedule allocation detail

To find specific information in a schedule description record, page forward to the category of information you want.

## **Change Defaults–AMIDDA02**

To change the order in which you see pages of information on the Display Discrete Allocation Detail panel, enter the sequence of pages you want to see.

---

## Option 9. Work with Schedule Descriptions (AMQM70)

You can see a list of additional operation descriptions by operation for a schedule. Use the following information to identify which sequence number you want to work with: operation sequence number, operation description sequence number, and operation description.

**What information you need:** The schedule number whose schedule descriptions you want to see.

**What reports are printed:** None.

**What forms you need:** None.

The panels used with this option are listed below.

### Work with Schedule Descriptions panels

Use these panels when you want to review schedule description information.

#### Specify Schedule Descriptions to Work With—AMQWSD00

To select the schedule for which you want to view additional operation descriptions, enter the schedule number on this panel.

#### Work with Schedule Descriptions—AMQWSD01

This panel shows you a list of operations for a particular schedule.

Enter **5** in the *Option* field next to the appropriate schedule number to see additional description information.

#### Change Defaults—AMQWSD02

To see operation descriptions first on the Work with Schedule Descriptions panel, enter **1** in the *First view* field.

#### Subset Schedule Descriptions List—AMQSSD00

To narrow the list of schedule descriptions shown on the Work with Schedule Descriptions panel, enter the values that you want to use to select schedule description records. You can select schedule descriptions by the following fields: operation sequence number, operation description sequence number, and operation description. The appropriate selection values appear to the right of each field.

#### Specify Schedule Description to Display—AMQDSD00

To select the schedule description detail you want to see, enter the schedule number on this panel. You only see this panel if you call this function from a command line on another work with list.

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### **Display Schedule Description Detail–AMQDSD01**

This panel shows you detailed information for the schedule description you selected.

### **Change Defaults–AMQDSD02**

The Display Schedule Description Detail panel has only one page.

---

## Option 10. Work with Item/Line (AMQM70)

You can see a list of item/line definitions by warehouse. You can review, create, and maintain information about items that are scheduled on specific production lines. The types of information maintained include run characteristics about a finished item as well as the operational steps and component usage.

There is more information that can fit on a single panel. Unless you change the sequence, you see views in this order:

1. General information
2. Production information
3. Schedule lot sizing factors

Use the views to identify which item/line definitions you want to work with.

**What information you need:** The warehouse number whose item/line definitions you want to work with.

**What reports are printed:** Item/Line Maintenance Edit List (AMQCIL)  
Component/Line Maintenance Edit List (AMQCCL).

**What forms you need:** None.

The panels used with this option are listed below.

### Work with Item/Line Definitions panels

Use these panels when you want to review, create, or maintain item/line definitions information. Use the Help key when you are working online for more information.

#### Work with Item/Line Definitions—AMQWIL01

This panel shows you a list of item definitions by line for a given warehouse. You can narrow the list of item/line definitions shown on the panel by using **F17=Subset**. (It is active on the panel although it does not appear until you use **F24=More keys**.)

- Enter **1** in the **Option** field on the first blank line. The Create Item/Line Definitions panel (AMQAIL01) appears.
- Enter **2** in the **Option** field next to the appropriate item to change this item. The Change Item/Line Definitions panel (AMQCIL01) appears.
- Enter **4** in the **Option** field next to the appropriate item to delete this item. The Confirm delete of Item/Line Definitions panel (AMQRIL01) appears.
- Enter **5** in the **Option** field next to the appropriate item to display detailed information for this item. The Display Item/Line Definitions panel (AMQDIL01) appears.
- Enter **15** in the **Option** field next to the appropriate item to display item detail information for this item. The Display Item Detail panel appears.
- Enter **16** in the **Option** field next to the appropriate item to display item warehouse information for this item. The Display Item Warehouse panel appears.
- Enter **20** in the **Option** field next to the appropriate item to go to the Work With Component/Line Definitions panel (AMQWCL01).

### Subset Item/Line Definitions–AMQSIL00

To narrow the list of item/line definitions shown on the Work with Item/Line Definitions panel, enter the values that you want to use to select item/line definition records. You can select item/line definitions by the following fields: finished item, production line, rate designator, and record status. The appropriate selection values appear to the right of each field.

### Create Item/Line Definition–AMQAIL01

Use this panel to create a new item/line definition. Enter the information for this definition.

### Change Item/Line Definition–AMQCIL01

Use this panel to change an item/line definition. Enter the information that you want to change for this definition.

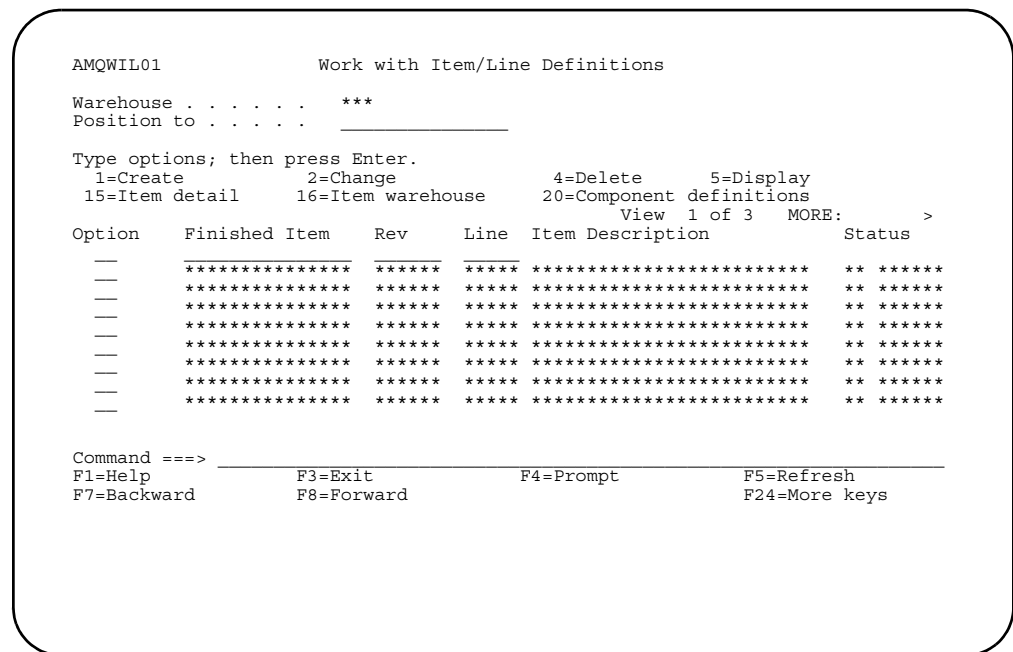
### Confirm Delete of Item/Line Definitions–AMQRIL01

Use this panel to delete one or more item/line definitions. Press **Enter** to confirm your choices for delete.

### Display Item/Line Definition–AMQDIL01

Use this panel to see detailed information for this item/line definition. After reviewing the details, press **Enter** to return to the Work With Item/Line Definitions panel.

## AMQWIL01—Work with Item/Line Definitions





```

AMQWIL01                Work with Item/Line Definitions
Warehouse . . . . . MPA
Position to . . . . . _____

Type options; then press Enter.
  1=Create      2=Change      4=Delete      5=Display
 15=Item detail 16=Item warehouse 20=Component definitions
                                           View 2 of 3 MORE: < >
Option Finished Item  Rev  Line Changeover Flow time P/
C   Item Rate
-----
****  ---  *****
*   ---  *****
****  ---  *****
****  ---  *****
****  ---  *****
****  ---  *****
****  ---  *****
****  ---  *****
****  ---  *****
****  ---  *****

Command ==>> _____
F1=Help      F3=Exit      F4=Prompt      F5=Refresh
F7=Backward  F8=Forward
F24=More keys
  
```

```

AMQWIL01                Work with Item/Line Definitions
Warehouse . . . . . ***
Position to . . . . . _____

Type options; then press Enter.
  1=Create      2=Change      4=Delete      5=Display
 15=Item detail 16=Item warehouse 20=Component definitions
                                           View 3 of 3 MORE: <
Option Finished Item  Rev  Line Schedule Lot  Schedule Min Schedule Max
-----
****  ---  *****
****  ---  *****
****  ---  *****
****  ---  *****

Command ==>> _____
F1=Help      F3=Exit      F4=Prompt      F5=Refresh
F7=Backward  F8=Forward
F24=More keys
  
```

**What to do**

To work with an item/line definition, type an option number in the option field and press **Enter**.

**Function keys**

**F1=Help**

Shows information about this panel. Pressing **F1** or pressing the **help** key shows you the same information.

**F3=Exit**

Ignores any options or changes you typed on the current panel, ends the current task, and returns to the panel where you started.

**F7=Backward**

Shows the previous set of entries for the list. You can press **F7** when you see More: - in the upper right part of the panel.

**F8=Forward**

Shows the next set of entries for the list. You can press **F8** when you see More: + in the upper right part of the panel.

**F24=More keys**

Shows additional function keys you can use on this panel.

## AMQAIL01—Create Item/Line Definition

```
AMQAIL01                Create Item/Line Definition
Warehouse . . . . . aA3  aaaaaaaaaaaaaaaaaaaaaaaaaaaaaA30 Site: ***
Finished item . . . . aaaaaaaaaaaaaA15 aaaaaaaaaaaaaaaaaaaaaaaaaaaaaA30
Revision . . . . . aaaaA6 Effective from nn/nn/nn to nn/nn/nn
Production line . . . . aaaaA5 aaaaaaaaaaaaaaaaaaaaaaaaaaaaaaaaaA40
To select a page, type page and press Enter, or press Enter to continue.
                                                                    Page 1 of 2

Production information
Changeover time . . . . . nn.n
Flow time . . . . . nnn.nnnnn
Item rate designator . . . . n      C=Cycle time, P=Pieces/hour
Item rate . . . . . nn,nnn.nnnn
Overlap code . . . . . n      0=No, 1=Yes
First schedule start option . . n      1=Changeover, 2=Flow, 3=Cycle
Default receipt location . . . . aaaaaA7
Default line location . . . . . aaaaaA7
Phantom component's operation . n      1=Inherit phantom operation
                                         2=Assume first operation
                                         3=Retain component operation
                                         4=Force operation review

F1=Help           F3=Exit           F5=Refresh        F11=Job Status
F7=Backward      F8=Forward       F12=Cancel       F13=Select Item Process
```

```
AMQAIL01                Create Item/Line Definition
Warehouse . . . . . aA3  aaaaaaaaaaaaaaaaaaaaaaaaaA30 Site: ***
Finished item . . . . aaaaaaaaaaaaaA15 aaaaaaaaaaaaaaaaaaaaaaaaaA30
Revision . . . . . aaaaA6 Effective from nn/nn/nn to nn/nn/nn
Production line . . . aaaaA5 aaaaaaaaaaaaaaaaaaaaaaaaaAAAA40
To select a page, type page and press Enter, or press Enter to continue.
                                                                    Page 2 of 2

Schedule lot sizing factors
Lot size . . . . . n,nnn,nnn.nnn
Minimum quantity . . . . . n,nnn,nnn.nnn
Maximum quantity . . . . . n,nnn,nnn.nnn
Quantity per container . . . . . n,nnn,nnn.nnn

Item process information
Site . . . . : *** BOM ID . . : *****
Routing ID . : ***** Version . . : *****
Alt Rtg sel code A2

Maintenance information
Date last maintained . . . . : **/**/**
Maintained by . . . . . : *****

F1=Help      F3=Exit      F5=Refresh      F11=Job Status
F7=Backward  F8=Forward   F12=Cancel     F13=Select Item Process
```

### What to do

To create an item/line definition, type in the information you need and press **Enter**.

### Function keys

#### F1=Help

Shows information about this panel. Pressing **F1** or pressing the **help** key shows you the same information.

#### F3=Exit

Ignores any options or changes you typed on the current panel, ends the current task, and returns to the panel where you started.

#### F5=Refresh

Resets the panel with the original defaults.

#### F7=Backward

Shows the previous set of entries for the list. You can press **F7** when you see More: - in the upper right part of the panel.

#### F8=Forward

Shows the next set of entries for the list. You can press **F8** when you see More: + in the upper right part of the panel.

#### F11=Job status

Shows a list of your current system and job information. You can see the status of your current job, including: system ID, date, job number, and job name; your ID and your workstation ID; the default output queue and output queue library; and the XA environment.

#### F12=Cancel

Ignores any options or changes you typed on the current panel, and returns to the previous panel. Processes any other options you typed on the previous panel.

### **F13=Select Item Process**

Causes panel AMVTIP01 to appear so you can select an item process. This function key appears only if EPDM is activated.

### **Fields**

**Warehouse.** ID of the warehouse where this item is manufactured.

**Site.** This field appears only if EPDM is activated. ID of the site associated with this warehouse.

**Finished item.** Number of the finished item.

**Revision.** This field appears only if EPDM is activated. ID of the revision associated with this item.

**Effective from/to.** This field appears only if EPDM is activated. The dates this revision is effective.

**Production line.** Production line where finished item is scheduled.

**Changeover time.** Amount of time needed to set up the production line to begin producing the first item in the schedule.

**Flow time.** Elapsed time (in hours) required to produce one unit of a scheduled item on a continuously-operating production line.

**Item rate designator.** Code indicating the contents of the item rate field:

- C** Item rate is expressed as cycle time between pieces.
- P** Item rate is expressed as pieces per hour.

**Item rate.** Rate at which items are produced on the production line, stated in either pieces per hour or cycle time (time between pieces coming off the line).

**Overlap code.** Code specifying if this schedule can overlap with the preceding schedule (that is, run at the same time as the schedule running before it).

**First schedule start option.** Code used to determine where in the production cycle the first schedule of the day is positioned.

- 1** This day's production will begin with the Changeover Time for this schedule.
- 2** This day's production will begin with the Flow Time for this schedule. (Changeover will be scheduled on the previous day.)
- 3** This day's production will begin with the Cycle Time for the item. (Changeover and Flow Time will be scheduled on the previous day.) This is the default value.

**Default receipt location.** The location to be used as the default for receiving.

**Default line location.** Identifier of the location at the production line where component items are to be delivered by the replenishment system.

**Phantom component's operation.** When a finished item (grandfather) has a phantom item (father) as one of its components (son), the components of the phantom can be used as components of the finished item (that is, the sons can become direct descendants of the grandfather). This code specifies how the first operation where-used is assigned to the components of a phantom when component/line definitions are created.

**Note:** Changes you make apply only to future records created for components of phantoms.

**Lot size.** The target quantity, in pieces, for schedules created through lot sizing. This value must be a multiple of the standard container quantity (quantity per container).

**Minimum quantity.** The least allowable quantity, in pieces, for a schedule created by lot sizing. This value must be a multiple of the standard container quantity (quantity per container).

**Maximum quantity.** The greatest allowable quantity, in pieces, for a schedule created by lot sizing. The value must be a multiple of the standard container quantity (quantity per container).

**Quantity per container.** The greatest allowable quantity, in pieces, for a schedule created by lot sizing. The value must be a multiple of the standard container quantity (quantity per container).

**Site.** This field appears if EPDM is activated. The identifier of the site associated with this item.

**BOM ID.** This field appears if EPDM is activated. The identifier of the bill of material associated with this item process.

**Routing ID.** This field appears if EPDM is activated. The item number whose routing is used for this item.

**Routing version.** This field appears if EPDM is activated. The version number of the routing.

**Alt Rtg select code.** A user-defined code that identifies which additional operations you added to the routing. A default of blank indicates that you added only base operations (added no additional operations).

**Date last maintained.** Date someone last maintained this record.

**Maintained by.** User ID of the person who last maintained this record.

## Work with Component/Line Definitions panels

Use these panels when you want to review or change component/line definitions information.

There is more information that can fit on a single panel. Unless you change the sequence, you see views in this order:

1. General information
2. Component information
3. Operation information

4. Engineering information
5. Parent information.

Use the views to identify which component/line definitions you want to work with.

All of the panels have Help available online, so only the Change Component/Line Definitions panel (AMQCCL01) and the Mass Change panel (AMQCCL02) are illustrated here. Use the **Help** key when you are working online for more information.

## Work with Component/Line Definitions–AMQWCL01

This panel shows you a list of components by line for the given warehouse. You can narrow the list of item/line definitions shown on the panel by using **F17=Subset**. (It is active on the panels although it does not appear until you use **F24=More keys**.)

- Enter **2** in the **Option** field next to the appropriate component to change this component. The Change Component/Line Definitions panel (AMQCCL01) appears.
- Enter **7** in the **Option** field next to the appropriate components to cause a mass change of operation where used and line location for these components. The Mass Change panel (AMQCCL02) appears.
- Enter **15** in the **Option** field next to the appropriate component to display item detail information for this component. The Display Item Detail panel appears.
- Enter **16** in the **Option** field next to the appropriate component to display item warehouse information for this component. The Display Item Warehouse panel appears.

## Subset Component/Line Definitions–AMQSCL00

To narrow the list of component/line definitions shown on the Work with Component/Line Definitions panel, enter the values that you want to use to select component/line definition records. You can select component/line definitions by the following fields: routing operation, facility ID, component item, item type, line location, reporting point, relative low level, and record status. The appropriate selection values appear to the right of each field.

## Change Component Line Item Definition–AMQCCL01

Use this panel to change a component/line definition. Enter the information that you want to change for this definition.

## Mass Change–AMQCCL02

Use this panel to cause a mass change of operation where used and line location for these components in the CMPLIN file. (No update occurs in the PDM or EPDM bills of material file.) Enter the values and press **Enter**.

## AMQWCL01—Work with Component/Line Definitions

```

AMQWCL01          Work with Component/Line Definitions
Warehouse . . . . . ***                *****
Finished item . . . . **
Production line . . . ***** *****
Routing select num.          S-number . . . .
Effectivity date .          **/**/**
Position to . . . . . _____

Type options; then press Enter.
  2=Change    7=Mass change    15=Item detail    16=Item Warehouse
View 1 of 5  MORE: >

Option  Oper  Facility  Component      Seq  Supply  Line Loc.  Status
-----
_      ****  *****  ***           ****           ****      **  *****
_      ****  *****  ***           ****           ****      **  *****
_      ****  *****  ***           ****           ****      **  *****

Command ==>> _____
F1=Help          F3=Exit          F4=Prompt          F5=Refresh
F7=Backward     F8=Forward
F24=More keys
  
```

```

AMQWCL01          Work with Component/Line Definitions
Warehouse . . . . . ***                *****
Finished item . . . . **
Production line . . . ***** *****
Routing select num.          S-number . . . .
Effectivity date .          **/**/**
Position to . . . . . _____

Type options; then press Enter.
  2=Change    7=Mass change    15=Item detail    16=Item Warehouse
View 2 of 5  MORE: < >

Option  Oper  Component item  Component description      Type  Level
-----
_      ****  ***           *****                    *    **
_      ****  ***           *****                    *    **
_      ****  ***           *****                    *    **

Command ==>> _____
F1=Help          F3=Exit          F4=Prompt          F5=Refresh
F7=Backward     F8=Forward
F24=More keys
  
```

```

AMQWCL01          Work with Component/
Line Definitions

Warehouse . . . . . ***                *****

Finished item . . . . . **
Production line . . . . . ***** *****
Routing select num.          S-number . . . . .
Effectivity date . . . . . **/**/**
Position to . . . . . _____

Type options; then press Enter.

2=Change      7=Mass change      15=Item detail      16=Item Warehouse

View 3 of 5  MORE: <  >

Option  Oper  Operation Description R/
P  Setup  TBC  Labor  Machine
-----
  ***  *****  *      .**      .**      .**
  ---  ***  *****  *      .**      .**      .**
  ---  ***  *****  *      .**      .**      .**
  
```

```

AMQWCL01          Work with Component/
Line Definitions

Warehouse . . . . . ***                *****

Finished item . . . . . **
Production line . . . . . ***** *****
Routing select num.          S-number . . . . .
Effectivity date . . . . . **/**/**
Position to . . . . . _____

Type options; then press Enter.

2=Change      7=Mass change      15=Item detail      16=Item Warehouse

View 4 of 5  MORE: <  >

Option  Oper  Component      Seq  Effectivity Dates  Drawing
-----
  ---  ***  *****      ****
  ---  ***  *****      ****
  ---  ***  *****      ****
  
```



```

AMQWCL01          Work with Component/Line Definitions
Warehouse . . . . . ***          *****
Finished item . . . . . **
Production line . . . . . ***** *****
Routing select num.          S-number . . . . .
Effectivity date .          **/**/**
Position to . . . . . _____

Type options; then press Enter.
  2=Change      7=Mass change      15=Item detail      16=Item Warehouse
View 5 of 5  MORE: <

Option   Oper   Parent item      Parent description      Type
-----
  ---     ****   **              *****                *
  ---     ****   **              *****                *
  ---     ****   **              *****                *
Command ==>>> _____

F1=Help      F3=Exit      F4=Prompt      F5=Refresh
F7=Backward  F8=Forward
  
```

**What to do**

To work with a component/line definition, type an option number in the option field and press **Enter**.

**Function keys**

**F1=Help**

Shows information about this panel. Pressing **F1** or pressing the **help** key shows you the same information.

**F3=Exit**

Ignores any options or changes you typed on the current panel, ends the current task, and returns to the panel where you started.

**F7=Backward**

Shows the previous set of entries for the list. You can press **F7** when you see More: - in the upper right part of the panel.

**F8=Forward**

Shows the next set of entries for the list. You can press **F8** when you see More: + in the upper right part of the panel.

**F24=More keys**

Shows additional function keys you can use on this panel.

## AMQCCL01—Change Component/Line Definition

```
AMQCCL01          Change Component Line Item Definition
Warehouse . . . . : *A3 *****A30
Finished item . . : *****A15 *****A30
Production line . : ***A5 *****A40
Component item . . : *****A15 *****A30
User sequence . . : **A4
Operation facility ID ***A5 *****A40

To select a page, type page and press Enter, or press Enter to continue.
                                                    Page 1 of 1

Production information
Operation where used . . . . . aaaA5
Line location . . . . . aaaaaA7

Maintenance information
Date last maintained . . . . : **/**/**
Maintained by . . . . . : *****

F1=Help          F3=Exit          F5=Refresh          F11=Job Status
F7=Backward      F8=Forward       F12=Cancel
```

### What to do

To change a component/line definition, type in the information you need and press **Enter**. To update information about operation where used and line location for all components, use the Mass Change panel.

### Function keys

#### F1=Help

Shows information about this panel. Pressing **F1** or pressing the **help** key shows you the same information.

#### F3=Exit

Ignores any options or changes you typed on the current panel, ends the current task, and returns to the panel where you started.

#### F5=Refresh

Resets the panel with the original values before you made any changes.

#### F7=Backward

Shows the previous set of entries for the list. You can press **F7** when you see More: - in the upper right part of the panel.

#### F8=Forward

Shows the next set of entries for the list. You can press **F8** when you see More: + in the upper right part of the panel.

#### F11=Job status

Shows a list of your current system and job information.

You can see the status of your current job, including: system ID, date, job number, and job name; your ID and your workstation ID; the default output queue and output queue library; and the XA environment.

### **F12=Cancel**

Ignores any options or changes you typed on the current panel, and returns to the previous panel. Processes any other options you typed on the previous panel.

### **Fields**

**Warehouse.** ID of the warehouse where this item is manufactured.

**Finished item.** Number of the finished item.

**Production line.** Production line where finished item is scheduled.

**Component item.** Item number of the component.

**User sequence.** Number you assign that uniquely identifies the component within the bill of material for the order or schedule.

**Operation facility ID.** ID that identifies the production facility within a department responsible for performing the operation.

**Operation where used.** Code to identify the individual operation where the component is used.

**Line location.** Location on the production line where the component is normally delivered or used.

**Date last maintained.** Date someone last maintained this record.

**Maintained by.** User ID of the person who last maintained this record.

## AMQCCL02—Mass Change (Component/Line Definition)

```
.....  
: AMQCCL02                Mass Change                               :  
:                                                                    :  
: Enter values and press Enter to update all components selected for :  
: Mass Change.                                                    :  
:                                                                    :  
:   Operation where used . . . . .   aaaA5   *SAME = Do not change :  
:   Line location . . . . .         aaaaaA7   *SAME = Do not change :  
:                                                                    :  
:                                                                    :  
:   F1=Help   F3=Exit   F5=Refresh   F12=Cancel                   :  
:                                                                    :  
:.....
```

### Function keys

#### F1=Help

Shows information about this panel. Pressing **F1** or pressing the **help** key shows you the same information.

#### F3=Exit

Ignores any options or changes you typed on the current panel, ends the current task, and returns to the panel where you started.

#### F5=Refresh

Resets the panel with the original values before you made any changes.

#### F12=Cancel

Ignores any options or changes you typed on the current panel, and returns to the previous panel. Processes any other options you typed on the previous panel.

### Fields

**Operation where used.** Code to identify the individual operation where the component is used.

**Line location.** Location on the production line where the component is normally delivered or used.

---

## Option 11. Work with Location/Components (AMQM70)

You can see a list of location/component definitions by location by warehouse.

There is more information that can fit on a single panel. Unless you change the sequence, you see views in this order:

1. Replenishment controls
2. Supply location data.

Use the views to identify which component/line definitions you want to work with.

**What information you need:** The warehouse number whose component location descriptions you want to work with.

**What reports are printed:** Location/Component Maintenance List (AMQCLC).

**What forms you need:** None.

The panels used with this option are listed below.

### Work With Location/Component panels

Use these panels when you want to review, create, or maintain location/component definitions information. All of the panels have Help available online, so only the Create Location/Component Definitions panel (AMQALC01) is illustrated here. Use the Help key when you are working online for more information.

#### Work with Location Components–AMQWLC01

This panel shows you a list of components for each line location in this warehouse. You can narrow the list of location/component definitions shown on the panel by using **F17=Subset**. (It is active on the panel although it does not appear until you use **F24=More keys**.)

- Enter **1** in the **Option** field on the first blank line. The Create Location/Component panel (AMQALC01) appears.
- Enter **2** in the **Option** field next to the appropriate component item to change this component item. The Change Location/Component panel (AMQCLC01) appears.
- Enter **4** in the **Option** field next to the appropriate component item to delete this component item. The Confirm Delete - Location/Component panel (AMQRLC01) appears.
- Enter **5** in the **Option** field next to the appropriate component item to display detailed information for this component item. The Display Location/Component panel (AMQDLC01) appears.
- Enter **7** in the **Option** field next to the appropriate component item to set the validation required flag off for this component item. The Validate Location/Component panel (AMQVLC01) appears.
- Enter **15** in the **Option** field next to the appropriate component item to display component item detail information for this component item. The Display Item Detail panel appears.
- Enter **16** in the **Option** field next to the appropriate component item to display component item warehouse information for this component item. The Display Item Warehouse panel appears.

## **Subset Location/Components–AMQCSL00**

To narrow the list of location/component definitions shown on the Work with Location/Component Definitions panel, enter the values that you want to use to select location/component definition records. You can select location/component definitions by the following fields: line location, component item, validation required, auto replenish, replenishment basis, use excess flag, and override supply location. The appropriate selection values appear to the right of each field.

## **Create Location/Component–AMQALC01**

Use this panel to create a new location/component definition. Enter the information for this definition.

## **Change Location/Component–AMQCLC01**

Use this panel to change a location/component definition. Enter the information that you want to change for this definition.

## **Display Location/Component–AMQDLC01**

Use this panel to see detailed information for this location/component definition. After reviewing the details, press **Enter** to return to the Work With Location Components panel.

## **Confirm Delete - Location Component–AMQRLC01**

Use this panel to delete a location/component definition. Press **Enter** to confirm your choices for delete.

## **Validate Location Component–AMQVLC01**

Use this panel to confirm your choices for those component items for which you want to set the validation required flag off. Press **Enter**.

## AMQWLC01—Work with Location Components

```
AMQWLC01                Work with Location Components
Warehouse . . . . . *** *****
Position to . . . . . _____

Type options; then press Enter.
1=Create          2=Change          4=Delete          5=Display
7=Validate        15=Item Detail      16=Item Warehouse

View 1 of 2  MORE: >

Option  Line      Component item  Description      Validation
Location                                     Required
-----
*****
*****
*****

Command ==> _____
F1=Help      F3=Exit      F4=Prompt      F5=Refresh
F7=Backward  F8=Forward
```

```

AMQWLC01                Work with Location Components
Warehouse . . . . . MPA
Position to . . . . . _____

Type options; then press Enter.
 1=Create          2=Change          4=Delete          5=Display
 7=Validate        15=Item Detail       16=Item Warehouse

Option Location  Component item  Auto  Repln  View 2 of 2  MORE: <
                - Supply Location -
                Override   Default
-----
*****
*****
*****

Command ==> _____
F1=Help          F3=Exit          F4=Prompt        F5=Refresh
F7=Backward      F8=Forward

```

**Function keys**

**F1=Help**

Shows information about this panel. Using **F1** or pressing the **help** key shows you the same information.

**F3=Exit**

Ignores any options or changes you typed on the current panel, ends the current task, and returns to the panel where you started.

**F5=Refresh**

Resets the panel with the original values before you made any changes.

**F7=Backward**

Shows the previous set of entries for the list. You can use **F7** when you see More: - in the upper right part of the panel.

**F8=Forward**

Shows the next set of entries for the list. You can press **F8** when you see More: + in the upper right part of the panel.

**F24=More keys**

Shows additional function keys you can use on this panel.



## AMQALC01—Create Location/Component Definition

```

AMQALC01          Create Location/Component Definition
Warehouse . . . . . *a3 *****a30
Location . . . . . *****a7
Component item . . . *****a15 *****a30

To select a page, type page and press Enter, or press Enter to continue.
                                                    Page 1 of 2
Replenishment basis . . . . . n          0=Schedule, 1=Location
Auto replenish . . . . . n          0=No, 1=Yes
Supply location override . . . . . aaaaaA7 Default: aaaaaA7

Replenishments          Total pieces      Containers      Pieces
Standard Quantity . . . . . n,nnn,nnn.nnn n,nnn,nnn.nnn nnn
Usage trigger (Auto replenish) . . . n,nnn,nnn.nnn n,nnn,nnn.nnn nnn
Minimum . . . . . n,nnn,nnn.nnn n,nnn,nnn.nnn nnn
Location maximum . . . . . n,nnn,nnn.nnn n,nnn,nnn.nnn nnn
Quantity per container . . . . . : *,**,**.***
Limit the run-out quantity . . . . . n          0=No, 1=Yes
Use excess pipeline inventory . . . . . n          0=No, 1=Yes
Validation required . . . . . n          0=No, 1=Yes
F1=Help          F3=Exit          F5=Refresh          F11=Job status
F7=Backward      F8=Forward          F12=Cancel

```

```

AMQALC01          Create Location/Component Definition
Warehouse . . . . . *a3 *****a30
Location . . . . . *****a7
Component item . . . *****a15 *****a30

To select a page, type page and press Enter, or press Enter to continue.
                                                    Page 2 of 2
Maintenance audit details
Date last maintained . . . . . : **/**/**
Last maintained by . . . . . : *****

F1=Help          F3=Exit          F5=Refresh          F11=Job Status
F7=Backward      F8=Forward          F12=Cancel

```

### What to do

To create a location/component definition, type in the information you need and press **Enter**.

## Function keys

### F1=Help

Shows information about this panel. Pressing **F1** or pressing the **help** key shows you the same information.

### F3=Exit

Ignores any options or changes you typed on the current panel, ends the current task, and returns to the panel where you started.

### F5=Refresh

Resets the panel with the original defaults.

### F7=Backward

Shows the previous set of entries for the list. You can press **F7** when you see More: - in the upper right part of the panel.

### F8=Forward

Shows the next set of entries for the list. You can press **F8** when you see More: + in the upper right part of the panel.

### F12=Cancel

Ignores any options or changes you typed on the current panel, and returns to the previous panel. Processes any other options you typed on the previous panel.

## Fields

**Warehouse.** ID of the warehouse where this item is manufactured.

**Location.** Identifier of the location at the production line where component items are to be delivered by the replenishment system.

**Component item.** Item number of the component.

**Replenishment basis.** This code determines whether the replenishment requirements for this location/component are grouped across all schedules, or whether the replenishment requirements are maintained by specific schedules. Inventory will be allocated to a schedule or to a location based on this code:

- 0** Schedule based replenishment. Replenishment records for this component item will maintain their unique identity to a specific schedule.
- 1** Location based replenishment. Replenishment records will be accumulated and summarized across all schedules for this component item at this line location for a specific required date.

**Auto replenish.** This code determines whether replenishments will be generated automatically when a pick list is run.

- 0** Replenishment records will not be generated automatically for this component item at this location.
- 1** Replenishment records will be generated automatically for this component item at this location.

**Supply location override.** If specified, this location will be replenished from the default location of supply for this component item at this line location.

**Standard (replenishment) quantity.** The standard container multiple assigned to the replenishment requests generated for this component item at this line location. This quantity is used for all replenishments except the last replenishment for a schedule (which is controlled by the value entered in the Run-out code field).

Replenishment needs less than this quantity are rounded up to this value.

Replenishment needs greater than this quantity are rounded up to the next multiple of this quantity.

For example, if this value is set at quantity=2, and the quantity needed for a schedule is calculated to be 7, the replenishment quantity calculated will be 8, assuming the Run-out code is not set to limit the issue of the component to only the amount needed.

**Usage trigger (auto replenish).** The amount of a component item that must be consumed before an automatic replenishment will be generated for this component item at this line location. This quantity is only effective when Auto Replenish is set to 1=Yes.

**Replenishment minimum.** The minimum amount of a component item that will be ordered by a replenishment that is generated for this component at this line location.

**Location maximum.** The quantity of an item stored in a full standard container.

**Quantity per container.** Standard number of components packaged in a container. Value comes from the Item Balance record.

**Limit the run-out quantity.** One of the following codes is used to indicate how this component is to be replenished to complete a schedule:

- 0** Supply the standard replenishment quantity of this component even though the entire quantity is not needed to complete schedules within the pick list horizon.
- 1** Limit the supply of this component to only the quantity needed to complete the schedules.

**Use excess pipeline inventory.** This code determines whether excess allocated inventory can be allocated to other schedules. Excess material occurs because of minimum and multiple constraints that are applied to replenishment requests, or when material is issued in containers that hold more than what is needed at a line location. This excess material can be allocated, even before it is transferred, when the replenishments for the next schedule are calculated, if you use code 1.

- 0** The material that is in excess of the quantity required at a line location is not used by the replenishment system until the quantity is received at the line by a (CL) transaction. This is the default.
- 1** The material that is in excess of the quantity required at a line location can be allocated when the replenishment requests for the next schedule are calculated.

**Validation required.** One of the following codes:

- 0** No, validation of the standard replenishment quantities and replenishment parameters is not required.
- 1** Yes, validation of the standard replenishment quantities and replenishment parameters is required.

If this flag is on, the standard replenishment quantities and replenishment parameters contained in this record should be visually inspected and approved. This validation is required because this record may have been created with default values during Item/Line and Component/Line file maintenance. Use option 2=Change on the Work With Location Component Definitions panel to set the quantities and parameters as you want them. You can set the validation flag off at the same time. Use option 7=Validate on the Work With Location Component Definitions panel to turn off the flag if the default values are acceptable to you.

The validation required flag is for your use only. The setting of the flag does not influence the use of this record. This record is considered active in all repetitive processes, regardless of the setting of the flag. It allows schedules to be released even if the flag is on.

**Date last maintained.** Date someone last maintained this record.

**Maintained by.** User ID of the person who last maintained this record.

---

## Option 12. Work with Component Status (AMQM70)

You can see a list of component items by warehouse by location.

**What information you need:** The warehouse number whose component status you want to see.

**What reports are printed:** None.

**What forms you need:** None.

The panels used with this option are listed below.

### Work With Component Status panels

Use these panels when you want to review component status information. You can narrow the list of item/line definitions shown on the panel by using **F17=Subset**. (It is active on the panel although it does not appear until you use **F24=More keys**.) All of the panels have Help available online, so none of the panels are illustrated here. Use the **Help** key when you are working online for more information.

#### Subset Component Status—AMQCSL00

To narrow the list of component status information shown on the Work with Component Status panel, enter the values that you want to use to select component status records. You can select component status information by the following fields: line location, component item, required date, schedule number, user sequence, and sequence number. The appropriate selection values appear to the right of each field.

#### Work with Component Status—AMQWCS01

This panel shows you a list of components for each line location in a specific warehouse. You can choose one of the following options to act on individual list entries:

- Enter **5** in the **Option** field next to the appropriate component item to display detailed information for this component item. The Display Component Status panel (AMQDCS01) appears.
- Enter **15** in the **Option** field next to the appropriate component item to display Item Master information for this component item. The Display Item Detail panel appears.
- Enter **16** in the **Option** field next to the appropriate component item to display Item Balance information for this component item. The Display Item Warehouse panel appears.
- Enter **20** to see Location/Component information about this component item. The Display Location/Component panel appears.

#### Display Component Status—AMQDCS01

Use this panel to see detailed information for this component. After reviewing the details, press **Enter** to return to the Work With Component Status panel.

## Chapter 10. Report descriptions

This section contains samples of reports produced by the REP application, in alphabetical order by report name.

The reports pertaining to features and options or product costing are not available unless you select those functions and files during application tailoring.

Some of the sample reports shown in this section have multiple-line headers showing all variations of headers that could appear under that report title. The actual headers that print will vary based on the options you choose.

Table 10-1. (Page 1 of 2) List of reports, sorted by report ID

ID	Report	See page
AMI2T	Item Balance File List	10-30
AMI7A	Item Balance File Maintenance Edit List	10-43
AMIQK	Batch/Lot Numbers	10-5
AMIXK	Location Detail	10-78
AMQ231	Schedule Performance By Line	10-147
AMQ23,	-by Item	10-145
AMQ233	-by Planner	10-151
AMQ2H	Item Balance Audit	10-29
AMQ2J	Item/Line Audit—Item/Line to Routing Hours Comparison	10-50
AMQ2L	Location Audit	10-77
AMQ2M1	Released Schedules - by Line	10-123
AMQ2M2	- by Item	
AMQ2M3	- by Planner	
AMQ2M4	- by Schedule	
AMQ2M5	Released Schedules Errors	10-130
AMQ2N1	Production Schedules By Line	10-99
AMQ2N2	- by item	10-97
AMQ2N3	- by Planner	10-101
AMQ2N4	- by Schedule Group	10-103
AMQ2N5	- by Schedule Number	10-105
AMQ2P1	Item/Line Process by Line in Units and Hours	10-68
AMQ2P2	- by Line as Costs	10-65
AMQ2P3	- by Item in Units and Hours	10-62
AMQ2P4	- by Item as Costs	10-59
AMQ2P5	- by Planner in Units and Hours	10-74
AMQ2P6	- by Planner as Costs	10-71
AMQ2Q1	Item/Line	10-52
AMQ2Q2		
AMQ361	Transaction Register—Posted Transactions	10-153
AMQ362	- Transaction Totals	10-156
AMQ3M1	Enter Transactions from Offline Files—Edit List	10-15
AMQ3M2	- Edit List Totals	10-18

Table 10-1. (Page 2 of 2) List of reports, sorted by report ID

AMQ3N1	Enter Transactions from Offline Files—Update and Error List	10-20
AMQ3N2	- Update and Error List Totals	10-23
AMQ3R1	Component Return List	10-6
AMQ3R2		
AMQ3S	Prime Production Line Audit	10-86
AMQ3T1	Pick List	10-83
AMQ3T2		
AMQ3U1	Container Labels—Single	10-12
AMQ3U2	- Double	10-10
AMQ42	Maintain Customer Manufacturing Dates Audit	10-82
AMQ471	Extract Schedule Requirements—Error List	10-27
AMQ472	- Totals	10-28
AMQ4E1	Purge Schedules Audit	10-107
AMQ4E2	- Totals	10-109
AMQ4E3	- Schedules not Purged due to Unapplied IP Transactions	10-112
AMQ4E4	- Schedules not Purged due to Pending Pick List Allocations	10-110
AMQ4E5	- Schedules not Purged due to Pending Transactions	10-111
AMQ4H1	Schedule Packet	10-140
AMQ4H2	- Summary List	10-143
AMQ4J	Production Reporting List	10-95
AMQ4N1	Release Schedules Audit	10-114
AMQ4N2	- Totals	10-115
AMQ4N3	Prime Production Line Audit	10-88
AMQ4Q	Release Schedules—Item Shortage	10-116
AMQ4S1	Recalculate Schedules Audit	10-113
AMQ4W	Release Schedules—Schedules Shortage	10-119
AMQ5B1	Released Schedule Maintenance Edit List	10-133
AMQ5B2	- Totals	10-138
AMQCCL	Component/Line Maintenance Edit List	10-8
AMQCFMOP	Enter and Maintain Schedules—Carry Forward Audit	10-14
AMQCIL	Item/Line Maintenance Edit List	10-56
AMQCLC	Location/Component Maintenance Edit List	10-79
AMQESLOP	Excess Stock at Line Location	10-25
AMQX1	Product Structure Maintenance Edit List—Item/Line	10-89
AMVQ20	Work in Process Totals Sheet	10-160
AMVT7	Production Facility Maintenance	10-90
AMVTC	Variable Capacity File Maintenance	10-158

Table 10-2. (Page 1 of 2) List of reports, sorted by report name

Report	ID	See page
Batch/Lot Numbers	AMIQK	10-5
Component Return List	AMQ3R1 AMQ3R2	10-6
Component/Line Maintenance Edit List	AMQCCL	10-8
Container Labels—Single	AMQ3U1	10-12
- Double	AMQ3U2	10-10
Enter and Maintain Schedules—Carry Forward Audit	AMQCFMOP	10-14
Enter Transactions from Offline Files—Edit List	AMQ3M1	10-15
- Edit List Totals	AMQ3M2	10-18
- Update and Error List	AMQ3N1	10-20
- Update and Error List Totals	AMQ3N2	10-23
Excess Stock at Line Location	AMQESL0P	10-25
Extract Schedule Requirements—Error List	AMQ471	10-27
- Totals	AMQ472	10-28
Item Balance Audit	AMQ2H	10-29
Item Balance File List	AMI2T	10-30
Item Balance File Maintenance Edit List	AMI7A	10-43
Item/Line	AMQ2Q1 AMQ2Q2	10-52
Item/Line Audit—Item/Line to Routing Hours Comparison	AMQ2J	10-50
Item/Line Maintenance Edit List	AMQCIL	10-56
Item/Line Process by Item as Costs	AMQ2P4	10-59
- by Item in Units and Hours	AMQ2P3	10-62
- by Line as Costs	AMQ2P2	10-65
- by Line in Units and Hours	AMQ2P1	10-68
- by Planner as Costs	AMQ2P6	10-71
- By Planner in Units and Hours	AMQ2P5	10-74
Location Audit	AMQ2L	10-77
Location Detail	AMIXK	10-78
Location/Component Maintenance Edit List	AMQCLC	10-79
Maintain Customer Manufacturing Dates Audit	AMQ42	10-82
Pick List	AMQ3T1 AMQ3T2	10-83
Prime Production Line Audit	AMQ3S AMQ4N3	10-86 10-88
Product Structure Maintenance Edit List—Item/Line	AMQX1	10-89
Production Facility Maintenance	AMVT7	10-90
Production Reporting List	AMQ4J	10-95
Production Schedules By Item	AMQ2N2	10-97
- by Line	AMQ2N1	10-99
- by Planner	AMQ2N3	10-101
- by Schedule Group	AMQ2N4	10-103
- by Schedule Number	AMQ2N5	10-105



Table 10-2. (Page 2 of 2) List of reports, sorted by report name

Report	ID	See page
Purge Schedules Audit	AMQ4E1	10-107
- Totals	AMQ4E2	10-109
- Schedules not purged due to Pending Pick List Allocations	AMQ4E4	10-112
- Schedules not purged due to Pending Transactions	AMQ4E5	10-110
- Schedules not purged due to Unapplied IP Transactions	AMQ4E3	10-111
Recalculate Schedules Audit	AMQ4S1	10-113
Release Schedules Audit	AMQ4N1	10-114
- Totals	AMQ4N2	10-115
Release Schedules—Item Shortage	AMQ4Q	10-116
- Schedules Shortage	AMQ4@	10-119
Released Schedules - by Line	AMQ2M1	10-123
- by Item	AMQ2M2	
- by Planner	AMQ2M3	
- by Schedule	AMQ2M4	
- Errors	AMQ2M5	10-130
Released Schedule Maintenance Edit List	AMQ5B1	10-133
- Totals	AMQ5B2	10-138
Schedule Packet	AMQ4H1	10-140
- by Item	AMQ232	
- by Line	AMQ231	
- by Planner	AMQ233	
- by Summary List	AMQ4H2	10-143
Transaction Register—Posted Transactions	AMQ361	10-153
- Transaction Totals	AMQ362	10-156
Variable Capacity File Maintenance	AMVTC	10-158
Work in Process Totals Sheet	AMVQ20	10-160

## Batch/Lot Numbers (AMIQK)

GATEWAY MFG CO				BATCH/LOT NUMBERS				DATE 8/10/
**	TIME 16.00.16	PAGE	1	AMIQK				
ITEM	WH	LOCATION	QUANTITY	U/M	OLD BATCH/LOT	NEW BATCH/		
LOT	FIFO DATE	REASON						
-----								
**	200223	ATL	A1AA2E	49.000	CS	BL20	BL30	8/29/
	000006							
GATEWAY MFG CO				BATCH/LOT NUMBERS				DATE 8/10/
**	TIME 16.00.16	PAGE	2	AMIQK				
	SESSION	STATUS	RECORDS ADDED	RECORDS CHANGED	LOCATION QUANTITY FILE	TRANSACTION HISTORY FILE		
					1	1		
					1			
					*** END OF PRINT ***			

To print this report, use option 2 on the Location Control menu (AMIM79).

### Fields

**ITEM.** The item number.

**WH.** The warehouse code.

**LOCATION.** The stock location code.

**QUANTITY.** The item quantity.

**U/M.** The stocking unit of measure.

**OLD BATCH/LOT.** The batch/lot number that was changed.

**NEW BATCH/LOT.** The new batch or lot number.

**FIFO DATE.** If FIFO control is not active, this field shows the original transaction date.

**REASON.** The user-defined code that indicates the reason for the batch/lot number change.

### SESSION STATUS.

**RECORDS ADDED.** The number of records added to the Transaction History file during the session.

**RECORDS CHANGED.** The number of records changed' in the Location Quantity file during the session.

## Component Return List (AMQ3R1 and AMQ3R2)

NORTHCREEK IND		COMPONENT RETURN				DATE 8/28/**	TIME 12:51:01	PAGE 1	AMQ3R1
		BY LINE LOCATION				OR			
		BY SUPPLY LOCATION							
REF	COMPONENT	SEQ	UM	WH	LINE LOC	RETURN CNTRS	QUANTITY PIECES	CNTR DESC	
					SPL LOC	BATCH/LOT	FIFO	TURNAROUND	
SCH NBR	SCH DATE	SCH ITEM			PRD LIN				
1 MJIT103		EA 1			MDL1W1		4.000		
POWER STROBE					A1B111				
S000948	8/29/**	BULBS							[barcode is printed here]
SCH NBR	SCH DATE	SCH ITEM			PRD LIN				
2 MJIT210		EA 1			MDL1W1		4.000		
UPPER FRONT PANEL					A1B121				
S000958	8/29/**	HANDLES							[barcode is printed here]

NORTHCREEK IND		COMPONENT RETURN				DATE 8/28/					
** TIME 12:52:28		PAGE 1	AMQ3R2	BY SUPPLY LOCATION				OR			
		BY LINE LOCATION									
REF	COMPONENT	SEQ	UM	WH	LINE LOC	RETURN CNTRS	QUANTITY PIECES	CNTR DESC	SPL LOC	BATCH/	
LOT	FIFO	TURNAROUND									
SCH NBR	SCH DATE	SCH ITEM	EA		PRD LIN						
1 MJIT103		EA 1			MDL1W1	1	19.000		A1B1111	8/21/	
200596827					MDLA1						
S000977	8/24/**	1								[barcode is printed here]	
2 MJIT210		EA 1			MDL1W1	8	.000		A1B121	SAMPLELOT 8/21/	
200554571					MDLA1						
S000977	8/24/**	1								[barcode is printed here]	

The Component Return List shows the components to be returned to the store. The report can be printed on either 14-7/8 x 11 or 8-1/2 x 11 paper depending on the format selected.

The report prints with the supply location listed first, if you selected the Component Return List in that sequence. If you selected the Supply Location sequence, the Supply Location appears first, then the Line Location. If you select both Line and Supply Location sequence, the Component Return List will print out one copy of each.

This report is printed when you select option 4, Component Return List, on the Material Management menu (AMQM30), then type Y in the Print Component Return List field on display AMQ3Q1.

### Fields

**REF.** A sequenced number assigned by the system that identifies a specific line number on a component return list.

**COMPONENT.** The component (with description) to be returned to stock.

**SEQ.** The user-defined sequence number used to uniquely identify the component and show its position in the bill of material.

**UM.** The component unit of measure.

**WH.** The warehouse from which the components are issued or the finished items received (manufactured).

**LINE LOC.** The location at the production line where the component is delivered.

**RETURN QUANTITY.** CNTRS: The return quantity expressed in containers.

PIECES: The return quantity expressed in pieces.

**CNTR DESC.** The user-defined description of the container.

**SPL LOC.** The location to which the component is to be returned.

**BATCH/LOT.** The batch/lot number assigned to an item lot. This field contains valid data only if you selected the Inventory Management install/tailor option to use batch/lot control.

**FIFO.** The date an item/lot was received into inventory. This field contains valid data only if you selected the Inventory Management install/tailor option to use FIFO date control.

**TURNAROUND.** The turnaround number of the component.

**SCH NBR.** The number assigned to this production schedule.

**SCH DATE.** The date that the item's schedule is due to be completed.

**SCH ITEM.** The item for which the production schedule was generated.

**PRD LIN.** The production line on which the scheduled item is manufactured.

## Component/Line Maintenance Edit List (AMQCCL)

```

NORTHCREEK IND          COMPONENT/LINE MAINTENANCE EDIT LIST      DATE 16/06/
** TIME 14.01.21  PAGE   1  AMQCCL                                OPER          UPDATE #183

WAREHOUSE ID            ATL  ATLANTA WAREHOUSE
FINISHED ITEM           LTDRWUT5  LATERAL 5 DRAWER CABINET UNIT
PRODUCTION LINE         PLN1A  FEEDER LINE A - EXTERIORS
COMPONENT ITEM          GLDDCKNBS  GOLD DECORATOR KNOBS
USER SEQUENCE
*** ADD ***

                                NEW VALUE
OPERATION WHERE USED    0030
LINE LOCATION
DATE LAST MAINTAINED    **/06/16
MAINTAINED BY           JORDAN
WAREHOUSE ID            ATL  ATLANTA WAREHOUSE
FINISHED ITEM           LTDRWUT5  LATERAL 5 DRAWER CABINET UNIT
PRODUCTION LINE         PLN1A  FEEDER LINE A - EXTERIORS
COMPONENT ITEM          WDSCR1  1' WOOD SCREWS
USER SEQUENCE
*** ADD ***

                                NEW VALUE
OPERATION WHERE USED    0030
LINE LOCATION
DATE LAST MAINTAINED    **/06/16
MAINTAINED BY           JORDAN
WAREHOUSE ID            ATL  ATLANTA WAREHOUSE
FINISHED ITEM           LTDRWUT5  LATERAL 5 DRAWER CABINET UNIT
PRODUCTION LINE         PLN1A  FEEDER LINE A - EXTERIORS
COMPONENT ITEM          WLNSTN  WALNUT STAIN
USER SEQUENCE
*** ADD ***

                                NEW VALUE
OPERATION WHERE USED    0010
LINE LOCATION
DATE LAST MAINTAINED    **/06/16
MAINTAINED BY           JORDAN
WAREHOUSE ID            ATL  ATLANTA WAREHOUSE
FINISHED ITEM           LTDRWUT5  LATERAL 5 DRAWER CABINET UNIT
PRODUCTION LINE         PLN1A  FEEDER LINE A - EXTERIORS
COMPONENT ITEM          WLNSTN  WALNUT STAIN
USER SEQUENCE
*** CHANGE ***

                                OLD VALUE          NEW VALUE
LINE LOCATION                                FLNE10
DATE LAST MAINTAINED                          **/06/16
MAINTAINED BY                                  JORDAN
    
```

### Fields

**Warehouse.** Code defined by your company that identifies the warehouse in which this item is currently stocked.

**Component item.** Item number of the component.

**User sequence.** Number you assign that uniquely identifies the component within the bill of material for the order or schedule.

**Operation facility ID.** ID that identifies the production facility within a department responsible for performing the operation.

**Operation where used.** Code to identify the individual operation in an order.

**Line location.** Location on the production line where the component is normally delivered or used.

***Date last maintained.*** Date someone last maintained this record.

***Maintained by.*** User ID of the person who last maintained this record.

## Container Labels–Double (AMQ3U2)

PICK LIST	105	REF	1	PICK LIST	105
REF	1				
DLV TO:		LOC	FLNE10	DLV TO:	
LOC	FLNE10				
CMP	METSDPND73			CMP	METSDPND73
	METAL 7' X 3'				METAL 7' X 3'
SIDE	PANELS				
BATCH/LOT		FIFO	8/28/**	BATCH/LOT	
FIFO	8/28/**				
PICK QTY	10.000			PICK QTY	
10.000					
CONTAINERS	1	PIECES	.000	CONTAINERS	1
PIECES	.000				
RETURN TO:	WH 1	LOCATION	A1B211	RETURN TO:	WH 1
LOCATION	A1B211				
		TURNAROUND	200548687		TURN
AROUND	200548687				
		[Barcode is printed here]			[Barcode is printed here]

Container Labels show information about components used on a particular schedule. This information can be printed on a label to be put on the container or a card to be placed in the container. There is a one-up format label (AMQ3U1) and a two-up format label (AMQ3U2).

Container Labels are printed when you select option 3, Container Labels, on the Material Management menu (AMQM30).

### Fields

**PICK LIST.** The identification number assigned to each pick list.

**REF.** A sequenced number assigned by the system that identifies a specific line number on a pick list.

**SCHED NUMBER.** The number assigned to this production schedule.

**SCHED ITEM.** The item for which the production schedule was generated.

**DLV TO.**

**LINE.** The production line to which the container is to be delivered.

**LOC.** The location to which the container is to be delivered.

**COMPONENT.** The component (with description) that is to be delivered in the container.

**SEQ.** The user-defined sequence number used to uniquely identify the component and show its position in the bill of material.

**BATCH/LOT.** The batch/lot number assigned to an item lot. This field contains valid data only if you selected the Inventory Management install/tailor option to use batch/lot control.

**FIFO.** The date an item/lot was received into inventory. This field contains valid data only if you selected the Inventory Management install/tailor option to use FIFO date control.

**PICK QTY.** The quantity of the component in the container.

**SCHED DATE.** The date when the item's scheduled is due to be completed.

**CONTAINERS.** The number of containers for which the labels are being printed.

**PIECES.** The number of pieces in a partial container.

**RETURN TO.**

**WH.** The warehouse to which the material is to be returned.

**LOCATION.** The location in the warehouse to which the material is to be returned.

**TURNAROUND.** The turnaround number of the component.



## Container Labels—Single (AMQ3U1)

```

PICK LIST      106  REF FLNE10

DLV TO:                               LOC FLNE10
CMP METEDPLNL71
METAL 7' X 1' END PANEL

BATCH/LOT                               FIFO      8/28/**

PICK QTY      10.000
CONTAINERS    1          PIECES      .000

RETURN TO:  WH 1  LOCATION A1B211

                                TURNAROUND 200546842
                                [barcode is printed here]
    
```

Container Labels show information about components used on a particular schedule. This information can be printed on a label to be put on the container or a card to be placed in the container. There is a one-up format label (AMQ3U1) and a two-up format label (AMQ3U2).

Container Labels are printed when you select option 3, Container Labels, on the Material Management menu (AMQM30).

### Fields

**PICK LIST.** The identification number assigned to each pick list.

**REF.** A sequenced number assigned by the system that identifies a specific line number on a pick list.

**SCHED NUMBER.** The number assigned to this production schedule.

**SCHED ITEM.** The item for which the production schedule was generated.

#### DLV TO.

**LINE.** The production line to which the container is to be delivered.

**LOC.** The location to which the container is to be delivered.

**CMP.** The component that is to be delivered in the container.

**SEQ.** The user-defined sequence number used to uniquely identify the component and show its position in the bill of material.

**BATCH/LOT.** The batch/lot number assigned to an item lot. This field contains valid data only if you selected the Inventory Management install/tailor option to use batch/lot control.

**FIFO.** The date an item/lot was received into inventory. This field contains valid data only if you selected the Inventory Management install/tailor option to use FIFO date control.

**PICK QTY.** The quantity of the component in the container.

**SCHED DATE.** The date when the item's schedule is due to be completed

**CONTAINERS.** The number of containers for which the labels are being printed.

**PIECES.** The number of pieces in a partial container.

**RETURN TO.**

**WH.** The warehouse to which the material is to be returned.

**LOCATION.** The location in the warehouse to which the material is to be returned.

**TURNAROUND.** The turnaround number of the component.

## Enter and Maintain Schedules–Carry Forward Audit (AMQCFMOP)

NORTHCREEK IND.		ENTER AND MAINTAIN SCHEDULES		DATE *****	TIME *****	PAGE	
1	AMQCFMOP	CARRY FORWARD AUDIT					
DATE	WH	LINE	ITEM	CARRY FWD QUANTITY	SCHEDULE QUANTITY	ACCTNG CLASS	
*****	1	ASBM1	933	INDUSTRIAL BUCKET 12"	30.000	30.000	MEL
		S-NUMBER					

The Enter and Maintain Schedules–Carry Forward Audit report is generated when the carry forward function is processed. The report provides an audit trail of schedules updated with a carry forward quantity.

This report is printed when you select option 4, Enter and Maintain Schedules, on the Schedule Management menu (AMQM40).

### Fields

**DATE.** The date for which the data is shown.

**WH.** The warehouse from which components are issued or the finished items are received (manufactured).

**LINE.** The production line for which the data is shown.

**ITEM.** The item and description for which the data is shown.

**CARRY FWD QUANTITY.** The calculated carry forward quantity. (Schedule quantity minus quantity completed from previous day.)

**SCHEDULE QUANTITY.** The quantity of the item scheduled for production on this date.

**ACCTNG CLASS.** Class, defined by your company, to group or classify orders for accounting purposes.

**S-NUMBER.** The features and options code for the item. This field only appears if you chose feature/options support during PDM/EPDM tailoring.

## Enter Transactions from Offline Files–Edit List (AMQ3M1)

```

NORTHCREEK IND          ENTER TRANSACTIONS FROM OFFLINE FILES          DATE 8/31/
** TIME 19:02:58 PAGE   1 AMQ3M1
                                EDIT LIST
BATCH 26

      TR
TRAN QTY ---
REC NBR CD LINE SCHED ITEM S-
NUMBER      DATE  NUMBER WH COMPONENT      SEQ  DATE  CNTRS  PIECES SPL LOC

BATCH/LOT  FIFO  LINE LOC OPER SHIFT STATUS CREW PRTY RWK PICK REF-
NBR REASON REFERENCE TIME TURNAROUND CNL LAST TR
** 3 100.000 BL14287
G5RV 08/26/** XCL1WX 0010 3 337 Y Y 018-
7332 001000 APPROVAL1 1215 20053503 Y Y

AM-9176 NO TRANSACTIONS AVAILABLE FOR PROCESSING
    
```

This report shows the transactions with severe errors that were entered through offline entry, or shows all transactions that were entered, depending on how you responded to display AXVOL1. All errors for each transaction are shown immediately below the transaction. Severe errors are:

- Non-numeric data exists in numeric fields
- Transaction code not given
- Both record types do not exist in file RPTRN1(128)
- Turnaround number not MOD10 validity check.

This report is printed when you select option 6, Enter Transactions from Offline Files, on the Material Management menu (AMQM30).

### Fields

**REC NBR.** The number assigned to each offline transaction record.

**TR CD.** The code of the transaction:

```

RLL Replenishment by Location
RLS Replenishment by Schedule
CL Component Transfer to Line
CN Component Return to Stores
IP Planned Manufacturing Issue
RM Schedule Receipts
RO Operation Reporting
SM Schedule Scrap
SC Component Scrap
PS Production Status
    
```

**LINE.** The production line on which the scheduled item is to be manufactured.

**SCHED ITEM.** The item for which the production schedule is generated.

**S-NUMBER.** The features and options code for the scheduled item. This field only appears if you selected the PDM/EPDM install/tailor option to use feature and option numbers.

**SCHED DATE.** The date when the item's schedule is due to be completed.

**SCHED NUMBER.** The number assigned to this production schedule.

**WH.** The warehouse from which the components are to be issued or the finished items received (manufactured).

**COMPONENT.** The component used in the production of the scheduled item.

**SEQ.** The user-defined sequence number used to uniquely identify the component and show its position in the bill of material.

**TRAN DATE.** The date the transaction occurred.

**TRAN QTY.**

**CNTRS.** The transaction quantity expressed in containers.

**PIECES.** The number of pieces in a partial container used at a location.

**SPL LOC.** The location that supplies materials to line delivery locations.

**BATCH/LOT.** The batch/lot number assigned to an item lot. This field contains valid date only if you selected the Inventory Management install/tailor option to use batch/lot control.

**FIFO.** The date an item/lot was received into inventory. This field contains valid date only if you selected the Inventory Management install/tailor option to use FIFO date control.

**LINE LOC.** The location at the production line where the component is delivered.

**OPER.** The operation number for the scheduled item where the component is used.

**SHIFT.** The production period when the transaction occurred.

**STATUS.** The status of a replenishment operation.

**CREW.** The user-defined code to identify the production crew.

**PRTY.** The priority code for components.

**Y** Specifies those components immediately needed at its line location.

**N** Indicates those components that can be sent to the line location within the normal replenishment cycle.

**RWK.** This code identifies a rework operation.

**PICK.** The identification number assigned to each pick list.

**REF-NBR.** A sequential number assigned by the system that identifies a specific line number on a pick list.

**REASON.** The user-defined transaction reason code.

**REFERENCE.** The user-defined code used to provide additional information.

**TIME.** The time that the offline transaction occurred.

**RSP (RESUPPLY) .** The resupply code that indicates if the material is to be resupplied at the line location:

- 0** No, the material is not to be resupplied at the line location.
- 1** Yes, the material is to be resupplied at the line location.

**CNL.** The cancel replenishment code that indicates if a replenishment record is to be deleted.

**LAST TR.** Y in this field indicates a transaction is the last transaction for this pick list. N indicates it is not.

## Enter Transactions from Offline Files—Edit List Totals (AMQ3M2)

NORTHCREEK IND		ENTER TRANSACTIONS FROM OFFLINE FILES		DATE 8/29/	
**	TIME 17:02:58	PAGE 1	AMQ3M2		
EDIT LIST TOTALS					
BATCH 26					
TRANSACTION TYPES	TRANSACTION CODE	NUMBER OF TRANSACTIONS	---- TOTAL QUANTITY ----		
REPLENISHMENTS	RL	9	CNTRS	PIECES	
			24	6.000	
ACCEPTED TOTALS		9	24	6.000	
SCHEDULE SCRAP	SM	22	10	200.000	
ERROR TOTALS		22	10	200.000	
TOTALS					
RECEIVED		9	24	6.000	
ACCEPTED		9	24	6.000	
ERROR		22	10	200.000	

The total quantity (expressed in containers and pieces) and totals per transaction are printed for all received, accepted, and error transactions that were entered through offline entry. The number of offline transactions performed is also shown.

This report is printed when you select option 6, Enter Transaction from Offline Files, on the Material Management menu (AMQM30).

### Fields

**TRANSACTION TYPES.** The description of the type of offline transactions performed.

**TRANSACTION CODE.** The code for the pending backflush transactions:

**RLL** Replenishment by Location  
**RLS** Replenishment by Schedule  
**CL** Component Transfer to Line  
**CN** Component Return to Stores  
**RM** Schedule Receipts  
**RO** Operation Reporting  
**SM** Schedule Scrap  
**SC** Component Scrap  
**PS** Production Status

**NUMBER OF TRANSACTIONS.** The number of offline transactions performed.

### TOTAL QUANTITY.

**CNTRS.** The total offline transactions quantity expressed in containers.

**PIECES.** The total offline transactions quantity expressed in pieces.

**ACCEPTED TOTALS.** The total number of posted transactions, and the total quantity expressed in containers or pieces.

***ERROR TOTALS.*** The total number of transactions, and the total quantity that is in error.

***TOTALS.***

***RECEIVED.*** The total number of transactions, and the total quantity that has been received.

***ACCEPTED.*** The total number of transactions, and the total quantity that has been posted.

***ERROR.*** The total number of transactions, and the total quantity in error.



## Enter Transactions from Offline Files—Update and Error List (AMQ3N1)

NORTHCREEK IND		ENTER TRANSACTIONS FROM OFFLINE FILES				DATE 8/31/								
**	TIME 16:53:47	PAGE	1	AMQ3N1	UPDATE AND ERROR LIST									
BATCH 25														
TR	SCHED	---	QUANTITY	---	TRAN	---	LOCATION	---	OLD/					
NEW BALANCE	-----													
CD	WH	LINE	SCHED	ITEM	DATE	CNTRS	PIECES	DATE	LINE	SUPPLY	TIME	CREW	ONHAND	ALLO
CATED	AVAILABLE													
SCHED	SHIFT	ST	OPER BATCH/LOT		FIFO	REASON	REFERENCE							
S-NUMBER	COMPONENT		SEQ											
CL 1	PLN1E	METDR73	08/29/**	3	100.000	08/31/								
** XLCLIWX	A3B111	1210 337	.000		.000	.000								
S000027	2				0010	G5RV							.000	
.000		.000												
PX060411														
CL 1	PLN1E	METDR73	08/30/**	3	100.000	08/31/								
** XLCLIWX	A3B111	1211 337	.000		.000	.000								
S000027	2				0020	G7SB							.000	
.000		.000												
WL140604														
CL 1	PLN1E	METDR73	08/31/**	3	100.000	08/31/								
** XLCLIW1	A3B111	1213 337	.000		.000	.000-								
S000027	2				0010	G4AH							.000	
.000		.000-												
HF180604														
AM-9176 NO TRANSACTIONS AVAILABLE FOR PROCESSING														

This report shows all posted and non-posted transactions. Non-posted error transactions are those that were found to be in error while attempting to update master files. Error messages are shown for those transactions. The last page of the report is the totals page. Totals per transaction are printed for all posted and error transactions.

This report is printed when you select option 6, Enter Transactions from Offline Files, on the Material Management menu (AMQM30), and any of the transactions processed did not contain any severe errors as listed on AMQ3M1.

### Fields

**TR CD.** The code of the transaction:

- RLL** Replenishment by Location
- RLS** Replenishment by Schedule
- CL** Component Transfer to Line
- CN** Component Return to Stores
- IP** Planned Manufacturing Issue
- RM** Schedule Receipts
- RO** Operation Reporting
- SM** Schedule Scrap
- SC** Component Scrap
- PS** Production Status

**WH.** The warehouse from which the components are to be issued or the finished items received (manufactured).

**LINE.** The production line on which the scheduled item is to be manufactured.

**SCHED ITEM.** The item (with description) for which the production schedule is generated.

**SCHED DATE.** The date when the item's schedule is due to be completed.

**QUANTITY.**

**CNTRS.** The transaction quantity expressed in units.

**PIECES.** The transaction quantity expressed in pieces.

**TRAN DATE.** The date that the transaction occurred.

**LOCATION.**

**LINE.** The location at the production line where the component is delivered.

**SUPPLY.** The location that supplies materials to line delivery locations.

**TIME.** The time the transaction occurred.

**CREW.** The user-defined code which identifies the production crew.

**OLD/NEW BALANCE.**

**ONHAND.** The onhand quantity before and after the transaction.

**ALLOCATED.** The allocated quantity before and after the transaction.

**AVAILABLE.** The available quantity before and after the transaction.

**SCHED.** The number assigned to this production schedule.

**SHIFT.** The production period when the transaction occurred.

**ST.** The status of a replenishment operation.

**OPER.** The operation number for the scheduled item where the component is used.

**BATCH/LOT.** The batch/lot number assigned to an item lot. This field contains valid date only if you selected the Inventory Management install/tailor option to use batch/lot control.

**FIFO.** The date an item/lot was received into inventory. This field contains valid date only if you selected the Inventory Management install/tailor option to use FIFO date control.

**REASON.** The user-defined transaction reason code.

**REFERENCE.** The user-defined code used to provide additional information.

**RSP (RESUPPLY)** . The resupply code that indicates if the material is to be resupplied at the line location:

- 0** No, the material is not to be resupplied at the line location.
- 1** Yes, the material is to be resupplied at the line location.

**S-NUMBER.** The features and options code for the scheduled item. This field only appears if you selected the PDM/EPDM install/tailor option to use feature and option numbers.

**COMPONENT.** The component (with description) used in the production of the scheduled item.

**SEQ.** User-defined sequence number.

---

## Enter Transactions from Offline Files–Update and Error List Totals (AMQ3N2)

---

```

NORTHCREEK IND          ENTER TRANSACTIONS FROM OFFLINE FILES          DATE 8/29/
** TIME 16:53:47 PAGE    1 AMQ3N2
                                UPDATE AND ERROR LIST TOTALS
BATCH 25

TRANSACTION TYPES          TRANSACTION          NUMBER OF          ---- TOTAL QUANTITY ----
COMPONENT TRANSFER TO LINE CODE          TRANSACTIONS          CNTRS          PIECES
                        CL          19          48          186.000
    POSTED TOTALS          19          48          186.000
                                0          0          .000
    ERROR TOTALS          0          0          .000

TOTALS
    RECEIVED          19          48          186.000
    POSTED          19          48          186.000
    ERROR          0          0          .000
  
```

---

This report is the totals page. Totals per transaction are printed for all received, posted, and error transactions. The total quantity (expressed in containers and pieces) and number of offline transactions performed is also shown.

**Note:** If you typed **Y** in ERRORS ONLY LISTING? on the Copy Offline File (options) display (AXVOL1), only error records are printed. If you typed in **N**, all transactions are printed.

This report is printed when you select option 6, Enter Transactions from Offline Files, on the Material Management menu (AMQM30).

### Fields

**TRANSACTION TYPES.** The description of the offline transactions performed.

**TRANSACTION CODE.** The code of the transaction:

<b>RLL</b>	Replenishment by Location
<b>RLS</b>	Replenishment by Schedule
<b>CL</b>	Component Transfer to Line
<b>CN</b>	Component Return to Stores
<b>IP</b>	Planned Manufacturing Issue
<b>RM</b>	Schedule Receipts
<b>RO</b>	Operation Reporting
<b>SM</b>	Schedule Scrap
<b>SC</b>	Component Scrap
<b>PS</b>	Production Status

**NUMBER OF TRANSACTIONS.** The number of offline transactions performed.

**TOTAL QUANTITY.**

**CNTRS.** The total offline transactions quantity expressed in containers.

**PIECES.** The total offline transactions quantity expressed in pieces.

**POSTED TOTALS.** The total number of posted transactions, and the total quantity expressed in containers or pieces.

**ERROR TOTALS.** The total number of transactions, and the total quantity in error.

**TOTALS.**

**RECEIVED.** The total number of transactions, and the total quantity that has been received.

**POSTED.** The total number of transactions, and the total quantity that has been posted.

**ERROR.** The total number of transactions, and the total quantity that is in error.

## Excess Stock at Line Location (AMQESLOP)

NORTHCREEK IND GE 1 AMQESLOP		EXCESS STOCK AT LINE LOCATION				DATE *****	TIME *****	PA
WAREHOUSE DT1								
--- LOCATION ---								
LINE	SUPPLY	COMPONENT	CNTRS	PIECES	UM	FIFO DATE	QUANTITY PER BATCH LOT	CONT
L312		A3C	ON HAND	0	30.750	EA	*****	
1.000			ALLOCATED	0	18.250			
			EXCESS STOCK	0	12.500		RETURN QUANTITY	
<hr/>								
L312		A3FLOOR	ON HAND	0	133.334	EA	*****	
1.000			ALLOCATED	0	150.000			
			EXCESS STOCK	0	16.666-			
			RETURN QUANTITY					
<hr/>								
L811	33013	A8B	ON HAND	0	5.000	EA	*****	9,000
,000.000			ALLOCATED	0	8.000			
			EXCESS STOCK	0	3.000-			
			RETURN QUANTITY					

The Excess Stock by Line Location report shows unallocated material at the line location that can be returned or transferred to the supply location.

This report is printed when you select option 4, Component Return List, on the Material Management menu (AMQM30), and type Y in the Print Report for Excess Stock field on display AMQ3Q1.

### Fields

**WH.** The warehouse from which the components are issued or the finished items received (manufactured).

**LINE LOC.** The location at the production line where the component is delivered.

**SUPPLY LOC.** The location to which the component is to be returned.

**COMPONENT.** The component (with description) to be returned to stock.

**CNTRS (Containers).** The quantity of on hand, allocated, and excess stock, expressed in containers.

**PIECES.** The stock quantity, expressed in pieces

**UM.** The component unit of measure.

**FIFO DATE.** The date an item/lot was received into inventory. This field contains valid data only if you selected the Inventory Management install/tailor option to use FIFO date control.

**BATCH/LOT.** The batch/lot number assigned to an item lot. This field contains valid data only if you selected the Inventory Management install/tailor option to use batch/lot control.

**QUANTITY PER CONTAINER.** The quantity of stock per shipping container.

**RETURN QUANTITY.** A blank area to record the quantity to be returned to stock.

## Extract Schedule Requirements–Error List (AMQ471)

```
NORTHCREEK IND          EXTRACT SCHEDULE REQUIREMENTS          DATE  8/30/
** TIME 14:25:48  PAGE    1  AMQ471
                                ERROR LIST
```

```
REVIEW HORIZON END DATE  8/29/**
-----
```

ERRORS FROM SCHEDULE INTERFACE FILE

WH	ITEM	REQUIRED QTY	SCHED DATE	ERRORS
1	METDR73	5.000	08/29/**	E AM-
9018	SCHED NUMBER FORMAT NOT VALID			
	S-NUMBER			

```
-----
ERRORS FROM ITEM BALANCE FILE
```

WH	ITEM	ERRORS
1	PLA1K	AM-
9018	SCHED NUMBER FORMAT NOT VALID	

**Note:** The report shown here reflects a single warehouse environment. For a multiple warehouse environment, this report contains a section for each warehouse.

This report is printed when you select option 3, Extract Schedule Requirements, on the Schedule Management menu (AMQM40).

### Fields

**REVIEW HORIZON END DATE.** The upper limit for the extract function.

**ERRORS FROM.** The file in which the errors occurred.

**WH.** The warehouse for which the requirements are extracted.

**ITEM.** The scheduled item (with description) for which requirements are extracted.

**REQUIRED QTY.** The quantity of the item to be scheduled.

**SCHED DATE.** The date when the item’s schedule is due to be completed.

**ERRORS.** The system-generated error message.

**S-NUMBER.** The features and options code for the scheduled item. This field only appears if you selected the PDM/EPDM install/tailor option to use feature and option numbers.



---

## Extract Schedule Requirements–Totals (AMQ472)

---

NORTHCREEK IND			EXTRACT SCHEDULE REQUIREMENTS	DATE 08/29/
** TIME 14:44:25	PAGE 1	AMQ472		
			TOTALS	
	RECORDS	RECORDS		
	EXTRACTED	IN ERROR		
MRP	0	0		
COM	0	0		
SCHED INTERFACE	1,019	15		
ITEM BALANCE	0	0		
TOTALS	1,019	15		

---

This report prints the total records extracted and records in error for each source of the requirements extracted.

This report is printed when you select option 3, Extract Schedule Requirements, on the Schedule Management menu (AMQM40).

### Fields

**APPLICATION.** The application that is the source of the extract requirements.

**RECORDS EXTRACTED.** The number of schedule requirements records extracted.

**RECORDS IN ERROR.** The number of schedule requirements records that are in error.



## Item Balance File List (AMI2T)

PHAN IMPORTS		ITEM BALANCE FILE LIST				DATE 11/05/
** TIME 10.17.53	PAGE 1	AMI2T	ITEMS FROM 03424 TO 03424		OPER A1	
WAREHOUSE 1						
ITEM- 03424	WAREHOUSE- ATL	DESCRIPTION-	TREADLE ASSEMBLY		CLASS- 2001	STOCK LOC-
A10124A	VENDOR-					
PLANNER		QUANTITY ON-				
HAND 948.000	QTY SOLD PTD	.000	STD UNIT COST	.00000000		
ACTIVITY CODE	A ON-					
ORDER PROD QTY	.000	QTY SOLD YTD	.000	AVG UNIT COST	.00000000	
LEAD TIME CODE	M ON-					
ORDER PUR QTY	.000	QTY ISSUED MTD	.000	LAST UNIT COST	.00000000	
LEAD TIME M. STD 6.0	PICK LIST REQMENT	.000	QTY ISSUED YTD	.000	COST DEV. CODE	
LEAD TIME M. VAR .0	ALLOCATED QTY	.000	QTY RECEIVED MTD	.000	USAGE COST MTD	
LEAD TIME M. ADJ .00	BEGIN INVENTORY	948.000	QTY ADJ PTD	.000	USAGE COST YTD	
4,178.59						
LEAD TIME M. AVG 5.0	SAFETY STOCK	4.000	QTY USED MTD	.000	SALES COST MTD	
.00						
CMLT MFG .0	ORDER POINT	50.000	QTY USED YTD	865.000	SALES COST YTD	
.00						
LEAD TIME P. STD .0	FIXED ORDER QTY	.000	AVG PERIOD-END-			
BAL 555.33	SALES AMT PTD	.00				
LEAD TIME P. ADJ 0	REQ PLAN ACTIVITY	0	PHY ON-	0		
HAND AT COUNT .0	QUANTITY SOLD SINCE PLAN	0		0		
LEAD TIME P. AVG .0	CYCLE CNT ACTIVITY		AVG SALES/PERIOD	.00	SALES AMOUNT YTD	
CMLT MTL .0	CYCLE COUNT CODE	0	EST.ANNUAL USAGE	2,001.810	DATE LAST MAINT	
5/14/**						
FLOOR STOCK CODE	CYCLE CNT TRANS ACT	9	DATE OF LAST ISSUE	8/15/		
** DATE OF LAST SALE	0/00/00					
LEAD TIME P. VEN .0	CYCLE CNT COMPARE	100	DATE LAST AFFECT QTY OH	9/30/		
** DATE OF LAST USAGE	8/15/**					
LEAD TIME P. SAF .0	LAST PHY/CY INV DATE	7/29/**	PURCHASE U/			
M	EA INCLUDE INVENTORY BALANCE	1				
LEAD TIME P. REV .0	DATE FOR NEXT CY CNT	99/99/99	PUR U/			
M CNV 1.00000	MASTER SCHEDULE ITEM CODE	M				
SCHEDULE CONTROL 0	PRIMARY PRODUCTION LINE		SMOOTHING CODE		CONTAINER DESCRIPTIO	
N						
EXTRACT SRC CODE	STOCK CONFIGURATION CODE	1	SMOOTHING STARTDATE	0/00/		
00	QUANTITY PER CONTAINER	1.000				
CARRY FORWARD CODE 0	SCHEDULE GROUP		LOT SIZING CODE	1	COMBINE REQUIREMENTS	
CODE 0						
MASTER LVL ITEM CODE 0	MASTER LEVEL FCST CODE	2	MINIMUM QTY	10.000	AUTO RELEASE CODE	
ORDER POLICY CODE DE 1	NO OF PERIODS	0	MAXIMUM QTY	.000	CONTRACT REQUIRED CO	
MASTER LVL PRT CODE	DAYS/					
PERIOD	22 MULTIPLE QTY	.000	SHRINKAGE	000		
MAX # LINES/						
ITEM A FORECAST QTY	1500	MPS PLANNING SOURCE CODE		PRBRK CONV FACTOR		
.0000						
PERIOD INTERVAL CODE 0	FIRM TIME FENCE	0	DAYS SUPPLY	10	PLAN CUSTOMER ORDER	
CODE 4						
ITM ACTG CLS D03	AUTH TIME FENCE	0	DEMAND TIME FENCE		PLAN EXPECTED ORDER	
CODE A						
ITEM RESCHEDULE CODE 0	RESCHEDULE FROZEN ZONE	0	MIN DAYS TO RESCHEDULE	0	PLANNING PROFILE ID	
ABC						
FORECASTING CODE ANNER BS 0	RESOURCE NUMBER	123	RESOURCE PROFILE BUILD CODE	Y	PRODUCTION FAMILY PL	
BACKFLUSH CODE 0						
SELECTED 1					TOTAL NUMBER OF RECORDS	
			*** END OF PRINT ***			

To print this report, use option 2 on the File Listings menu (AMIM23) or option 1 on the REP File Listings menu (AMQM20).

### Fields

**ITEM.** The item number.

**PLANNER.** A code that identifies the person responsible for planning the replenishment for manufacturing or purchase items.

**ACTIVITY CODE.** Either of the following:

- A** Active
- S** Suspended

**LEAD TIME CODE.** A required code that indicates which lead time to use:

- M** Manufacturing lead time
- P** Purchasing lead time.

**LEAD TIME M. STD.** A numeric value that is the total lead time to manufacture one standard lot size of the item based on availability of components and the use of a single level bill of material. Standard manufacturing lead time includes fixed time factors (such as setup, move, and queue times) and quantity-dependent factors (such as run times to produce standard lots). See Chapter 2, "Managing Repetitive Production Management" for the relationship between the various lead times.

**LEAD TIME M. VAR.** A numeric value that is the portion of total manufacturing lead time dependent on the quantity produced. It is the run time for all operations that do not have a fixed length of time per lot. This value is used when computing quantity-based lead times in MRP. If a value is not in this field, MRP assumes that the quantity-based lead time calculations do not apply and that, regardless of the planned order quantity, the lead time will be the sum of the standard manufacturing lead time and the manufacturing lead time adjustment.

**LEAD TIME M. ADJ.** A numeric value that is the portion of the total lead time required for quantity-independent administrative activities such as review time or requisition processing time. This value is added to the standard manufacturing lead time to arrive at the total manufacturing lead time.

**LEAD TIME M. AVG.** A numeric value that is the weighted average number of working days between the release of a manufacturing order and its completed receipt to stock. This field is updated by the application, but may be changed using file maintenance.

**CMLT MFG.** A numeric value that is the composite lead time when all purchased items are assumed to be in stock. Cumulative manufacturing lead time ignores the effect of purchase lead times. This field is manually maintainable.

**LEAD TIME P. ST.** A numeric value that is the value for purchased items that is the actual vendor-quoted lead time. The total purchase lead time is the sum of this value and the purchase lead time adjustment.

**LEAD TIME P. ADJ.** A numeric value that represents dock-to-stock time. Total purchase lead time is the sum of purchase lead time adjustment and purchase lead time.

**LEAD TIME P. AV.** A numeric value that is the weighted average number of working days between purchase order start and completion. The average purchase lead time is calculated by the application. However, the field is manually maintainable.

**CMLT MTL.** A numeric value that is the amount of time necessary to produce a standard lot size of the item when starting with no materials on hand. It is the sum of the longest lead time for a purchased component, on the lowest level of the product structure, and the longest manufacturing or purchase lead time in the next higher assembly. Cumulative material lead time is the maximum amount of time required to

purchase the materials and manufacture an item. The application does not calculate this field; it is manually maintained.

**FLOOR STOCK CODE.** The floor stock number for this item. Valid codes are:

- blank** This item is not floor stock.
- C** This item is controlled floor stock.
- U** This item is uncontrolled floor stock.

**LEAD TIME P. VEN.** A numeric value that is the vendor-quoted number of days between the vendor's receipt of your order and delivery to your dock. This field appears only if Purchasing is installed and interfacing.

**LEAD TIME P. SAF.** A numeric value that is the number of days allocated for unexpected delays. This field appears only if Purchasing is installed and interfacing.

**LEAD TIME P. RE.** A numeric value that is the number of days between creation of the requisition and release of the order to the vendor. This field appears only if Purchasing is installed and interfacing.

**SCHEDULE CONTROL.** The item schedule control code. The code tells whether demand for the item is brought into REP when the requirements extract option is selected.

- N** The item is not schedule-controlled. This is the default.
- Y** The item is schedule-controlled.

**EXTRACT SRC CODE.** A code used to indicate to REP the single source of demand for the item. If you change this field, you may want to change the smoothing code.

- blank** No override. This is the default.
- 1** MRP, if it is installed and interfacing with REP.
- 2** COM, if it is installed and interfacing with REP.
- 3** Schedule Demand (interface) file.

**STOCK CONFIGURATION CODE.** A code used by KBC that indicates whether the item is stocked. Appears only if KBC is installed and interfacing.

**CARRY FORWARD CODE.** A code used to indicate whether the difference between quantity produced and demand quantity should be brought forward into the next day's schedule as unmet demand. This field is required if the **SCHEDULE CONTROL** field contains Y.

- N** Do not carry forward the difference between schedule and schedule receipt. This is the default.
- Y** Carry forward the difference between schedule and schedule receipt.

**MASTER LEVEL ITEM CODE (MLIC).** A code used by MRP (if installed and interfacing) to indicate if this item is a master level item and, if so, which requirements to use when planning orders. The codes are:

- blank** Not a master level item (MLI).
- M** Multiple source MLI. Both planner-entered (manual, held, and propagated) and generated requirements cause planned orders to be created for this item.
- S** Single source MLI. Only planner-entered requirements cause planned orders to be created.

**ORDER POLICY CODE (ORDP).** Code to identify the order policy to be used to plan replenishment orders for this item:

- A** Discrete order quantity
- B** Order point, order quantity
- C** Order point, order up to level
- D** Fixed quantity
- F** Part period balancing—standard cost
- G** Time periods of supply
- H** Discrete above a minimum quantity
- I** Part period balancing—current cost
- Z** User option.

If MRP or MPSP is active with IM, items with an order policy code of B or C are not planned.

**MASTER LVL PRT CODE (MLPC).** Code used by MRP to indicate whether this item prints on MRP's MLI reports during master level planning runs:

- blank** Always prints
- L** Prints only if this item's level was planned
- S** Does not print on MRP's MLI reports

**MAX # LINES/ITEM (MXLN).** A code used to indicate the maximum number of lines to be printed for this item on the MRP Requirements Planning Report and the MPSP Master Schedule Planning Report. The codes are:

- blank** One page per item
- A** All detail

**PERIOD INTERVAL CODE (PDIN).** A code used by MRP (if installed and interfacing) to indicate how requirements detail is presented on the Requirements Planning report. The codes are:

- 0** Print full detail.
- 1** Summarize according to the first set of print intervals.
- 2** Summarize according to the second set of print intervals.
- 3** Summarize according to the third set of print intervals.

This code corresponds to the print intervals defined on MRP Period Interval display, AMM120.

**ITM ACTG CLS.** Class, defined by your company, to group or classify items for accounting purposes.

**ITEM RESCHEDULE CODE.** Code used to indicate whether or not orders for the item (by item/warehouse) can be rescheduled automatically by the system.

- 0** Default to warehouse reschedule code. This is the default.
- 1** Cannot be rescheduled automatically
- 2** Can be scheduled out
- 3** Can be scheduled in
- 4** Can be scheduled both out and in

**FORECASTING CODE (FCSC).** The code used to control forecasting for this item in this warehouse. The available codes are:

- 0 Do not forecast this item.
- 1 Forecast but do not pass to MRP/MPSP.
- 2 Pass only forecast to MRP/MPSP.
- 3 Pass both forecast and requirement to MRP/MPSP.

**BACKFLUSH CODE (BFFL).** The code that identifies whether component backflushing is done using the component quantity adjusted for yield or the standard component quantity.

- 1 Use adjusted quantity per to backflush (default).
- 2 Use standard quantity per to backflush.

**WAREHOUSE.** Warehouse number, if one was selected.

**QUANTITY ON-HAND.** Quantity of the item received this period or month-to-date.

**ON-ORDER PROD QTY.** Quantity open on manufacturing orders.

**ON-ORDER PUR QTY.** Quantity open on purchasing orders.

**PICK LIST REQMENTS.** Customer order allocation quantity.

**ALLOCATED QUANTITY.** Quantity allocated to manufacturing orders.

**BEGIN INVENTORY.** The quantity of the item that was on hand at the beginning of the current period or month.

**SAFETY STOCK.** A numeric value giving the quantity you want to use as the minimum quantity on hand to deal with fluctuations in demand and deliveries. Quantity entered must be in terms of the stocking unit of measure. This field can be updated optionally by the Forecasting application if it is installed and interfacing.

**ORDER POINT.** A numeric value that will be used rather than the system-calculated order point. Quantity entered must be in terms of the stocking unit of measure. If this value is 0 (zero), the system calculates an order point whenever the reorder report is run and compares it to the item's availability. If the availability is less than the order point, an order will be suggested. Forecasting, if it is installed and interfacing, can optionally calculate this quantity each period.

**FIXED ORDER QTY.** A numeric value that will be used with Item Master order policy codes B, C, D, and H to recommend an order quantity. Quantity entered must be in terms of the stocking unit of measure.

**REQ PLAN ACTIVITY.** Indicates if activity for this item was generated by the order entry function as a signal for requirements planning.

- 0 No activity
- 1 Activity
- 2 Planning exception

**CYCLE CNT ACTIVITY.**

- 1 Item has been selected for physical count, but has not yet been counted
- blank Items not selected

**CYCLE COUNT CODE.** One of the following numeric values, used to determine the frequency of cycle counting:

- 0 No cycle count (default value)
- 1 Monthly
- 2 Quarterly
- 3 Semiannually
- 4 On demand (on date of next count; see below).

**CYCLE CNT TRANS ACT.** Number of transactions processed against this item since last physical count.

**CYCLE CNT COMPARE.** A numeric value used to determine frequency of cycle counting based on the number of transactions processed for this item since the last cycle count. The default value is 0 (zero), which means do not select for cycle counting on this basis. This field can be used in conjunction with the cycle count code. For example, if the cycle count code is 2 and the Transaction Compare value is 40, the item will be selected for cycle counting at least every three months, but may be selected earlier if 40 or more transactions are processed for the item before three months have passed.

**LAST PHY/CY INV DATE.** Used with cycle count codes 1, 2, and 3 to select items for cycle counting. This date is automatically updated by every count transaction.

**DATE FOR NEXT CY CNT.** A numeric value that is used with cycle count code 4 to select items for cycle counting. The default is 999999. The due date of replenishment orders is automatically placed into this field if it contains 999999, so that the item can be selected for cycle counting just prior to a receipt (when the quantity on hand is at its lowest point).

**PRIMARY PRODUCTION LINE.** The most frequently used production line. Entries are limited to active work center records flagged as production lines.

**SCHEDULE GROUP.** This is a user-defined code to group items together.

**MST LVL FCST CD.** The code used by MRP (if installed and interfacing) to indicate if the master level item is to be forecasted. This code applies only to forecasts propagated in MRP. The codes are:

- 0 Do not propagate forecast for this item.
- 1 Propagate forecast for this item.
- 2 Propagate requirements equal to forecast for this item.

**NO OF PERIODS.** The number of periods over which this item is to be forecasted in MRP. This field is used only if MRP is installed and interfacing, and applies only to forecasts generated in MRP.

**DAYS/PERIOD.** The number of days to be contained in each MRP forecast period. This field is used only if MRP is installed and interfacing, and applies only to forecasts generated in MRP.

**FORECAST QTY.** The forecast quantity per time period. This field is used by MRP (if installed and interfacing) to propagate forecast quantities when the Master Level Forecast Code is 1 or 2. It identifies the quantity of this item used in the forecast and ranges from 0 through 9,999,999. If FCST is installed and interfacing, this field should be zero. The default is zero.

**FIRM TIME FENCE.** The number of days during which orders can be placed and purchase can be committed. The number of days entered is added to the MRP



current date to establish this fence. The established time fence is used with the auto release function. This field is used for standard purchase orders and for requisitions.

**AUTH TIME FENCE (ATIM).** The number of days during which orders can be intended and payment for vendor raw materials can be committed. The number of days entered is added to the MRP current date to establish this fence. The established time fence is used with the auto release function. This field is used for standard purchase orders and for requisitions.

**RESCHEDULE FROZEN ZONE.** Number of days within which production schedules will not be rescheduled, by item/warehouse.

**RESOURCE NUMBER (RSCNO).** The user-defined number used by MPSP (if installed and interfacing) to identify this item as a critical resource.

**QTY SOLD MTD.** Quantity of the item sold this period or month-to-date.

**QTY SOLD YTD.** Quantity of the item sold this year.

**QTY ISSUED MTD.** Quantity of the item issued this period or month-to-date.

**QTY ISSUED YTD.** Quantity of the item issued this year.

**QTY RECEIVED MTD.** Quantity of the item received this period or month-to-date.

**QTY ADJ MTD.** Sum of the adjustments (changes) made to the quantity of the item this period or month.

**QTY USED MTD.** Quantity of the item used this period or month-to-date. This includes both items sold and items removed from stock but not sold.

**QTY USED YTD.** Quantity of the item used this year. This includes both items sold and items removed from stock but not sold.

**AVG PERIOD-END-BAL.** This average is recalculated during each period-end file update run. If no value is entered, the average is set equal to the first non-zero on hand period-end balance.

**PHY ON-HAND AT COUNT.** Quantity on hand at time item is selected for physical count.

**AVG SALES/PERIOD.** A numeric value with two decimal places. This average is recalculated during each period-end file update run. If no value is entered, the average is set equal to the first non-zero period-to-date sales.

**EST. ANNUAL USAGE.** This average is recalculated during each period-end file update run. If no value is entered, the average is set equal to the annualized value of the first non-zero period-to-date usage.

**DATE OF LAST ISSUE.** Date this component item was last issued for the manufacturing order.

**DATE LAST AFFECT QTY OH.** Automatically updated by every transaction that changes the quantity on hand.

**PURCHASE U/M.** An alphanumeric value that can be used for items purchased at a different unit of measure than is used for issuing and stocking. For example, wire may be purchased in coils but issued in units of length, such as meters. This field is used with the unit of measure conversion factor when printing the Reorder Report and the Purchase Order Status Report and can be used in purchase receipt transactions.

**PUR U/M CNV.** A numeric value with two decimal places that is used to convert quantities from purchase unit of measure to issuing and stocking unit of measure. For example, if wire that is issued in meters is purchased by the coil with each coil containing 250 meters, then the unit of measure conversion factor is 250.00. If bolts are issued individually but purchased by the box with each box containing 75 bolts, then enter 75.00 for the unit of measure conversion factor. The default value is 1.00.

**SMOOTHING CODE.** A code used to indicate whether the MRP demand smoothing algorithm is used to spread production evenly for the net demand and how it should be applied. This code can be overridden by the smoothing start date. It only appears if the **SCHEDULE CONTROL** field contains Y.

- blank** No smoothing. This is the default.  
**1** Use the system date, plus one work day.  
**2** Use the first net demand date.

If you update the smoothing code, the requirements planning modification flag (RPFLD) is set to 1.

**SMOOTHING START DATE.** A code used to indicate when demand smoothing begins for an item and warehouse combination. It only appears if the SCHEDULE CONTROL field contains Y.

**LOT SIZING CODE.** A code used to indicate whether an item can have multiple schedules per day (lots) automatically created within REP.

- Y** Lot size for this item.  
**N** Do not lot size for this item. This is the default.

**MINIMUM QTY.** The minimum order quantity of the item. Any planned order generated by MRP and MPSP that is for a quantity less than the minimum indicated is increased to this minimum number. This field is used only by MRP and MPSP (if installed and interfacing).

**MAXIMUM QTY.** The maximum planned order quantity. If the planned order quantity generated by MRP or MPSP exceeds this maximum, an exception is created to notify the planner, who may want to adjust the order quantity. This field is used only by MRP and MPSP (if installed and interfacing).

**MULTIPLE QTY.** The factor used by MRP and MPSP (if installed and interfacing) to increase a planned order to a multiple of this quantity. For example, if the planned order was originally for a quantity of 16 and the multiple quantity factor was 20, the planned order would be increased to 20. If the original quantity was 35, the planned order would be increased to 40. This field is used only by MRP and MPSP (if installed and interfacing).

**MPS PLANNING SOURCE CODE.** The code used by MPSP (if installed and interfacing) to indicate the kind of demand used for generating the master production schedule for this item. The codes are:

- blank** Not used in MPS planning  
**B** Blended demand (the greater of forecasted demand or customer orders)  
**C** Customer orders only  
**D** Blended demand, do not combine customer orders  
**E** Customer orders only, not combined  
**F** Forecasts only  
**M** Manually entered firm planned orders  
**P** Item production plan

Codes D and E correspond to B and C except the demand records are kept separately by customer order. Codes B and C combine customer orders for the same item into a single demand quantity. Codes D and E facilitate the tracking of source of demand information by customer order.

**DAYS SUPPLY.** The number of days of supply that one order provides.

If MPSP is installed and interfacing, and the item is a master scheduled item with a MPS planning source code of P (production plan), this code sets the intervals for ordering this item. The codes are:

- 1 Once a week
- 2 Two times per production planning period
- 3 One time per production planning period
- 4 One time per work day.

This field is used only by MRP and MPSP (if installed and interfacing) if the order policy code is G for this item.

**DEMAND TIME FENCE (DMDFN).** The number of days that are used by MPSP (if installed and interfacing) as a frozen planning zone in the MPSP master production schedule for this item. During this period, blended demand does not include forecasts until the periods after the fence date, and only customer orders are considered as demand. Any changes to the production schedule during the frozen period should be avoided because they can seriously affect production schedules. This number of days can equal the final assembly lead time (FALT) for this item. The system uses this number to calculate the demand time fence date in the master production schedule for this item.

**MIN DAYS TO RESCHEDULE.** Specifies the minimum number of days that an order can move in order for it to be rescheduled automatically by the system.

**RESOURCE PROFILE BUILD CODE (RSCBF).** The code used by MPSP (if installed and interfacing) to indicate which items or production families can have resource profiles generated. The available codes are:

- Y Build profile
- N Do not build profile.

**STD UNIT COST.** A numeric value with four decimal places. The default value is the unit cost default field in the Item Master file record. This field is also referred to as standard cost and can be changed by a Standard Cost Replace transaction (CS).

**AVG UNIT COST.** A numeric value with four decimal places. The default value is the unit cost default field in the Item Master file record. This field is calculated for each costed receipt transaction and cost adjustment transaction.

**LAST UNIT COST.** A numeric value with four decimal places. The default value is the unit cost default field in the Item Master file record. This field is calculated for each costed receipt transaction and cost adjustment transaction.

**COST DEV. CODE.** Used to determine when the new unit cost of an item varies significantly from its previous cost. It is set during transaction processing and reset during stock status update.

- 0 Cost within limits
- 1 Cost exceeds limits

**USAGE COST MTD.** The period or month-to-date usage cost for this item. This includes both the cost of items sold and the cost of items removed from stock but not sold.

**USAGE COST YTD.** The year-to-date usage cost for this item. This includes both the cost of items sold and the cost of items removed from stock but not sold.

**SALES COST MTD.** The period or month-to-date sales cost for the item.

**SALES COST YTD.** The year-to-date sales cost for the item.

**SALES AMT PTD.** The period or month-to-date amount of sales for the item.

**QUANTITY SOLD SINCE PLAN.** The total quantity sold for a particular item as of the last planning run.

**SALES AMOUNT YTD.** The year-to-date amount of sales for the item.

**DATE LAST MAINTAINED.** The date this Item Master record was last maintained. This field appears on Change, Delete and Set Defaults displays.

**DATE OF LAST SALE.** Automatically updated by every Sales Shipment transaction (SA).

**DATE OF LAST USAGE.** Automatically updated by every issue and sales transaction.

**INCLUDE INVENTORY BALANCE.** The values for this field are:

- 1 Yes. Include inventory balance of this item/warehouse in MRP planning runs.
- 0 No. Do not include inventory balance of this item/warehouse in MRP planning runs.

**MASTER SCHEDULE ITEM CODE (MSCOD).** The code used by MPSP (if installed and interfacing) to indicate if this item is a master scheduled item. If the code is M, MPSP plans orders for the item and ignores any requirements generated or entered for it in MRP. MRP uses the orders created by MPSP during the MRP planning run, based on a run-time option in MRP. The available codes are:

- blank** Not a master scheduled item
- M** Master scheduled item
- P** Production family

If the code is blank, FCST (if installed and interfacing) loads requirements for master level item codes M and S to MRP. If the code is M, FCST loads requirements for master level items to MPSP.

If the code is M, all item type codes are valid, except for F (Feature) or 0 (Phantom). If the code is P, the only valid master level item code is blank and the only valid item type code is 0 (Phantom). Refer to display AMVT02 for a definition of the item type codes.

**CONTAINER DESCRIPTION.** A user-defined code or abbreviation that describes the container in which items are moved to and from the production line.

**QUANTITY PER CONTAINER.** The number of items that fit in the container used for priming the production line. This field is required if the **SCHEDULE CONTROL** field value is Y. The default is 1.

**COMBINE REQUIREMENTS CODE.** The code used by MRP (if installed and interfacing) to indicate if requirements for this item are to be combined during the MRP Requirements Planning run. You are not able to use the pegged-to-requirements function for any items that have combined requirements.

The four combine interval sizes and the five price break literals are defined on MRP Period Interval display, AMM120. Codes 5 through 9 (price break literals) combine requirements according to the fourth period interval.

The price break literals refer to the price break unit of measure constants printed on the MRP Purchase Planning report. The codes are:

- 0 Do not combine requirements
- 1 Combine interval 1
- 2 Combine interval 2
- 3 Combine interval 3
- 4 Combine interval 4
- 5 Price break literal 5
- 6 Price break literal 6
- 7 Price break literal 7
- 8 Price break literal 8
- 9 Price break literal 9.

**AUTO RELEASE CODE.** A code used to define the conditions under which purchase orders or requisitions for this item can be automatically released. The codes are:

- 0 Do not automatically release requisitions or purchase orders.
- 1 Automatically release requisitions without generating a purchase order.
- 2 Automatically release held single purchase orders if the planned order is within the FIRM horizon. The hold from print code must be manually removed in Purchasing before the purchase order is available for printing.
- 3 Automatically release single purchase orders if the planned order is within the FIRM horizon. The purchase orders are available for automatic selection during the purchase order print process. No manual intervention is required.
- 4 Automatically release held blanket purchase orders if the planned order is within the FIRM or AUTHORIZED horizon. The hold from print code must be manually removed in Purchasing before the purchase order is available for printing.
- 5 Automatically release blanket purchase orders if the planned order is within the FIRM or AUTHORIZED horizon. The purchase orders are available for automatic selection during the purchase order print process.
- 6 Held fixed blanket required; must exist if the planned order is within the FIRM or AUTHORIZED horizon. The hold from print code must be manually removed in Purchasing before the purchase order is available for printing.
- 7 Fixed blanket required; must exist if the planned order is within the FIRM or AUTHORIZED horizon. The purchase orders are available for automatic selection during the purchase order print process.

**CONTRACT REQUIRED CODE.** A code to indicate whether a contract is required to auto release items in this warehouse. This code serves as an override to the value set up on the Planning Run Executions Options display (AMM151), which is at the warehouse level.

- 0 Default to value of this field at warehouse level.
- 1 Contract required, This is the default
- 2 No contract is required. If an expired contract is present, an error message is issued, and auto release does not occur.
- 3 No contract is required. If an expired contract is present, a warning message is issued, and auto release occurs.
- 4 No contract is required. Any contracts are ignored.

**SHRINKAGE.** The value used by MRP and MPSP (if installed and interfacing) as a multiplier to adjust gross requirements not covered by on-hand quantity to reflect expected material losses.

**PRBRK CONV FACTOR.** The factor used by MRP (if installed and interfacing) to convert planning units to purchase units. The factor is described by the price break literal assigned to this item (see "COMBINE REQUIREMENTS CODE").

**PLAN CUSTOMER ORDER CODE (CTPO).** The codes for this field are:

- 1 Create planned orders equal to all customer orders that fall after the MRP current date.
- 2 Create planned orders for all orders that fall after the release date.
- 3 Create planned orders for all orders that fall after the review date.
- 4 Do not create any planned orders.
- 5 Create planned orders equal to all customer orders that fall after MRP start date.

**PLAN EXPECTED ORDER CODE (ETPO).** The codes for this field are:

- 0 Do not use expected customer orders in planning.
- A Use only type A (Make) expected customer orders in planning.
- B Use type A (Make) and type B (Buy) expected customer orders in planning.
- C Use type A (Make), type B (Buy), and type C (Firm) expected customer orders in planning.
- D Use type A (Make), type B (Buy), type C (Firm), and type D (Plan) expected customer orders in planning.

**PLANNING PROFILE ID.** The user-defined purchase planning profile identifier that was created in MRP for this vendor or item/warehouse. This is used to support the ANSI 830 Planning Schedule (EDIFACT DELFOR) transaction with EC, but you can use it without EC to simply print planning schedules.

**PRODUCTION FAMILY PLANNER (PFPLN).** The user-defined number you have assigned that identifies the person responsible for planning the replenishment strategy for these production families.

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## Item Balance File Maintenance Edit List (AMI7A)



BELLAMY BICYCLES		ITEM BALANCE FILE MAINTENANCE EDIT LIST				DATE	5/14/		
**	TIME 11.32.17	PAGE	1	AMI7A					
	UPDATE# 159					OPER	A1		
ITEM	03424	WAREHOUSE	ATL	INVENTORY	TREADLE ASSEMBLY	PLANNER	902	CHANGE	
	***** BEFORE *****					CLASS	20	STOCK LOC	A1
04	VENDOR								
ACTIVITY CODE	A	QUANTITY ON HAND		948.000	ON-				
ORDER PROD QTY		.000	USAGE COST PTD			.00			
FLOOR STOCK CODE		SAFETY STOCK		4.000	ON-				
ORDER PUR QTY		.000	SALES COST PTD			.00			
LEAD TIME CODE	M	ORDER POINT		.000	ALLOCATED QTY		.000	SALES AMT	PTD
	.00								
LEAD TIME MFG STD	6.0	FIXED ORDER QTY		.000	PICK LIST REQMENTS		.000	USAGE COST	YTD
	4,178.59								
LEAD TIME MFG VAR	.0	PURCHASE U/							
M	EA	BEGINNING INV		170.000	SALES COST YTD		7,716.00		
LEAD TIME MFG ADJ	1.0	U/							
M CONV		1.00000	QTY SOLD PTD		.000	SALES AMT YTD			.00
LEAD TIME MFG AVG	5.0	DATE LAST AFFECT QTYOH	9/30/**	QTY ISSUED PTD		.000	AVG SALES/		
PERIOD	.00								
CMLT MFG	.0	DATE OF LAST SALE	0/00/**	QTY RECEIVED		.000	AVG PRD-END-		
BAL	555.33								
LEAD TIME PUR VEN	.0	DATE OF LAST USAGE	8/15/						
** QTY ADJ PTD		.000	EST. ANNUAL USAGE		2,001.81				
LEAD TIME PUR SAF	.0	DATE LAST ACTIV ISSUED	8/15/						
** QTY USED PTD		.000	STANDARD COST		.000000000				
LEAD TIME PUR REV	.0	DATE NEXT CYCLE CNT	99/99/99	QTY SOLD YTD		.000			
LEAD TIME PUR STD	.0	CYCLE COUNT CODE		0	QTY ISSUED YTD	865.000	DATE LAST MAINT		
	9/30/**								
LEAD TIME PUR ADJ	0	CYCLE CNT COMPARE	1,000,000	QTY USED YTD		865.000	INCLUDE INVENTORY BALA		
NCE	1								
LEAD TIME PUR AVG		CMLT MTL		FORECAST QTY		1500	MASTER LEVEL ITEM CODE		
		MPS PLANNING SOURCE CODE		MINIMUM QTY		10.000	ORDER POLICY CODE		
E	S	DAYS SUPPLY		10	MAXIMUM QTY	20.000	MASTER LEVEL PRINT COD		
ITEM		MST LVL FCST CD		2	MULTIPLE QTY	20.000	MAX # LINES/		
	A								
	0	NO OF PERIODS		02	SHRINKAGE	.000	PERIOD INTERVAL CODE		
		DAYS/							
PERIODS	30	PRBRK CONV FACTOR		.0000	COMBINE REQUIREMENTS CODE		0		
ITM ACTG CLS	D03	FIRM TIME FENCE		000	AUTO RELEASE CODE	0	PLAN CUSTOMER ORDER CO		
DE	4								
ITEM RESCHEDULE CODE	0	AUTH TIME FENCE		1	RESCHEDULE FROZEN ZONE	0	MIN DAYS TO RESCHEDULE		
	0								
SCHEDULE CONTROL	N	LOT SIZING CODE		N	SMOOTHING CODE		PRIMARY PRODUCTION LIN		
E	PLPL1								
EXTRACT SOURCE CODE					CONTAINER DESCRIPTION				
CARRY FORWARD CODE	0	SCHEDULE GROUP			QTY PER CONTAINER				
ITEM	03424	WAREHOUSE	ATL	INVENTORY	TREADLE ASSEMBLY	PLANNER	12902	CHANGE	
	***** AFTER *****					CLASS	2001	STOCK LOC	A101
24A	VENDOR								
ACTIVITY CODE	A	QUANTITY ON HAND		948.000	ON-				
ORDER PROD QTY		USAGE COST PTD				.00			
FLOOR STOCK CODE		SAFETY STOCK		4.000	ON-				
ORDER PUR QTY		.000	SALES COST PTD			.00			
LEAD TIME CODE	M	ORDER POINT		50.000	ALLOCATED QTY		.000	SALES AMT	PTD
	.00								
LEAD TIME MFG STD	6.0	FIXED ORDER QTY		.000	PICK LIST REQMENTS		.000	USAGE COST	YTD
	4,178.59								
LEAD TIME MFG VAR	.0	PURCHASE U/							
M	EA	BEGINNING INV		948.000	SALES COST YTD		.00		
LEAD TIME MFG ADJ	1.0	U/							
M CONV		1.00000	QTY SOLD PTD		.000	SALES AMT YTD			350.00
LEAD TIME MFG AVG	5.0	DATE LAST AFFECT QTYOH	9/30/**	QTY ISSUED PTD		.000	AVG SALES/		
MONTH	16.88								
LEAD TIME MFG CUM	.0	DATE OF LAST SALE	0/00/**	QTY RECEIVED		.000	AVG PRD-END-		
BAL	555.33								
LEAD TIME PUR VEN	.0	DATE OF LAST USAGE	8/15/						
** QTY ADJ PTD		.000	EST. ANNUAL USAGE		2,001.81				
LEAD TIME PUR SAF	.0	DATE LAST ACTIV ISSUED	8/15/						
** QTY USED PTD		.000	STANDARD COST		.000000000				
LEAD TIME PUR REV	.0	DATE NEXT CYCLE CNT	99/99/99	QTY SOLD YTD		.000			
LEAD TIME PUR STD	.0	CYCLE COUNT CODE		0	QTY ISSUED YTD	865.000	DATE LAST MAINT		
	9/30/**								
LEAD TIME PUR ADJ	0	CYCLE CNT COMPARE	1,000,000	QTY USED YTD		865.000	INCLUDE INVENTORY BALA		
NCE	1								
LEAD TIME PUR AVG		MATERIAL CMLT		FORECAST QTY		1500	MASTER LEVEL ITEM CODE		
		MPS PLANNING SOURCE CODE		MINIMUM QTY		10.000	ORDER POLICY CODE		
E	S	DAYS SUPPLY		10	MAXIMUM QTY	20.000	MASTER LEVEL PRINT COD		
ITEM		MST LVL FCST CD		2	MULTIPLE QTY	20.000	MAX # LINES/		
	A								
	0	NO OF PERIODS		02	SHRINKAGE	.000	PERIOD INTERVAL CODE		
		DAYS/							
PERIODS	30	PRBRK CONV FACTOR		.0000	COMBINE REQUIREMENTS CODE		0		
ITM ACTG CLS	D03	FIRM TIME FENCE		000	AUTO RELEASE CODE	0	PLAN CUSTOMER ORDER CO		
DE	4								
ITEM RESCHEDULE CODE	0	AUTH TIME FENCE		1	RESCHEDULE FROZEN ZONE	0	MIN DAYS TO RESCHEDULE		
	0								
SCHEDULE CONTROL	N	LOT SIZING CODE		N	SMOOTHING CODE		PRIMARY PRODUCTION LIN		
E	PLPL1								
EXTRACT SOURCE CODE					CONTAINER DESCRIPTION				
CARRY FORWARD CODE	0	SCHEDULE GROUP			QTY PER CONTAINER				

---

```
EFL SYSTEM TEST          ITEM BALANCE FILE MAINTENANCE EDIT LIST    DATE  5/14/
**  TIME 11.32.17  PAGE    2  AMI7A                                OPER A1
      UPDATE# 159
      NUMBER OF ADDED RECORDS                2
      NUMBER OF CHANGED RECORDS              1
      NUMBER OF DELETED RECORDS              0
      NUMBER OF SUSPENDED RECORDS            0
      NUMBER OF REACTIVATED RECORDS          0
```

\*\*\* END OF PRINT \*\*\*

---

The edit list is an audit trail of maintenance activity for added new or previously deleted records, changed fields in existing records, deleted existing records, suspended active records, and reactivated suspended records. The report shows all fields before and after maintenance for the CHANGE function. For a description of the fields on this report, see "Item Balance File List (AMI2T)".

Item/Line (AMQ2Q1 and AMQ2Q2)

```

NORTHCREEK IND                ITEM/LINE                DATE 8/28/
** TIME 15:23:12 PAGE      1  AMQ2Q1

                                FOR WAREHOUSE 1
                                ALTERNATE ROUTING CODE
                                -OR-
                                ALTERNATE ROUTING CODE BASE ONLY
                                EC EFFECTIVITY DATE 6/21/**

LINE MDLIS MODEL 100 SYSTEM MAIN LINE  ITEM RATE  120.000 P/
C P DESIGNATION PRIMARY START OPT 3 OVERLAP N
ITEM MDL100S MODEL 100 SYSTEM SCHEDULE GROUP S-NUMBER DEFAULT ALT RTG CODE
CARRY FWD Y STOCK LOC MDL1W1 ENG DRAW CHANGEOVER HOURS .1 FLOW TIME .192
LOT 50.000 MIN 10.000 MAX 100.000

WORK ---- HOURS ---- I - CONTAINER --- LOCATIONS --
--- EFFECTIVE --- REL
OPER CTR LABOR MACHINE TBC COMPONENT LVL SEQ FE OP QUANTITY PER T QTY PER DESC SUPPLY LINE
FROM TO
0010 MDL01 250.00 .00 M MJIT103 1.000 4 100.000 A1B212 MDL1W1
MJIT202 .003 4 100.000 A1B112 MDL1W1
MJIT203 4.000 4 100.000 A1B121 MDL1W1
MJIT204 1.000 4 100.000 A1B122 MDL1W1
MJIT205 .500 4 100.000 A1B132 MDL1W1
0010 MDL01 250.00 .00 M MJIT601 1.000 4 100.000 A1B112 MDL1W1
0010 MDL01 250.00 .00 M MJIT210 1.000 4 100.000 A1B212 MDL1W1
MJIT211 12.000 4 100.000 A1B212 MDL1W1
E AM-9015 COMPONENT DELIVERY LOCATION NOT FOUND
E AM-XXXX LOCATION COMPONENT CONTROL NOT FOUND
    
```

```

NORTHCREEK IND                ITEM/LINE                DATE 8/28/
** TIME 13:23:45 PAGE      1  AMQ2Q2

                                FOR WAREHOUSE 1
                                ITEM MDL100S
                                -OR-
                                S-NUMBER
                                ALTERNATE ROUTING CODE
                                -OR-
                                DEFAULT ALTERNATE ROUTING CODES USED
                                EC EFFECTIVITY DATE 1/01/**

ITEM MDL100S MODEL 100 SYSTEM SCHEDULE GROUP S-
NUMBER DEFAULT ALT RTG CODE
LINE MDLIS MODEL 100 SYSTEM MAIN LINE ITEM RATE  120.000 P/
C P DESIGNATION PRIMARY START OPT 3 OVERLAP N
CARRY FWD Y STOCK LOC MDL1W1 ENG DRAW DEFAULT MAX CONTAINERS 2 CHANGEOVER HOURS .1
FLOW TIME .192

WORK ---- HOURS ---- I ---- CONTAINER ---- -- LOCATIONS --
--- EFFECTIVE --- SEQ FE OP QUANTITY PER T MAX QTY PER DESC SUPPLY LINE
FROM TO
0010 MDL01 250.00 .00 M MJIT103 1.000 4 16 100.000 A1B212 MDL1W1
MJIT202 .003 4 2 100.000 A1B112 MDL1W1
MJIT203 4.000 4 32 100.000 A1B121 MDL1W1
MJIT204 1.000 4 8 100.000 A1B122 MDL1W1
MJIT205 .500 4 32 100.000 A1B132 MDL1W1
0010 MDL01 250.00 .00 M MJIT601 1.000 4 192 100.000 A1B112 MDL1W1
0010 MDL01 250.00 .00 M MJIT210 1.000 4 8 100.000 A1B212 MDL1W1
MJIT211 12.000 4 16 100.000 A1B212 MDL1W1
E AM-9015 COMPONENT DELIVERY LOCATION NOT FOUND
    
```

The Item/Line reports (AMQ2Q1 and AMQ2Q2) show material and labor information for an item/line combination. The printing sequence is by line or item, S-number for an

item if feature/options are supported, EC effectivity date, and an alternate routing code.

These reports are printed when you select option 6, Item/Line, on the Reports menu (AMQM20) and EPDM is not activated.

## Fields

**ALTERNATE ROUTING CODE.** The alternate routing code selected.

**ITEM.** The finished item (with description) to be produced for this schedule.

**SCHEDULE GROUP.** A user-defined code used to sequence schedules. It can also identify items

**S-NUMBER.** The features and option code for the item. This field only appears if you chose feature/options support during PDM/EPDM tailoring.

**DEFAULT ALT RTG CODE.** A user-defined code that identifies which additional operations you added to the routing.

**LINE.** The production line (with description) on which the item is produced.

**ITEM RATE.** Either pieces per hour or cycle time for the production line/end item combination, indicated by the P/C Code field.

**P/C.** Flag indicating the contents of the Item Rate field:

**blank** Value for any manufacturing order in MOMAST.

**C** Item Rate is expressed as time between pieces (cycle time).

**P** Item Rate is expressed as pieces per hour.

**DESIGNATION.** The production line designation, primary or alternate, for this item.

**START OPT.** For the first schedule of the day, this code will determine how the start time and date will be adjusted.

**1** This day's production will begin with the Changeover Time for this schedule.

**2** This day's production will begin with the Flow Time for this schedule (Changeover will be scheduled on the previous day).

**3** This day's production will begin with the Cycle Time for the item (Changeover and Flow Time will be scheduled on the previous day). This is the default value.

**OVERLAP.** The code that determines if a schedule can be overlapped with another schedule for this item/line combination.

**Y** Schedule can be overlapped

**N** Schedule cannot be overlapped

**CARRY FWD (Y,N).** This code determines whether to carry over a quantity.

**Y** Carry quantity over

**N** Do not carry quantity over

**STOCK LOCATION.** The default location where the finished item is received.

**ENG DRAW.** The unique engineering drawing number assigned to an end product or item.

**PHANTOM COMPONENT'S OPER.** If this finished item has components that are phantoms, this code specifies for these components of the phantoms how the first operation where-used is to be assigned for these components.

**CHANGEOVER HOURS.** The time necessary to change from one production run to another.

**FLOW TIME.** The elapsed time (in hours) required to produce one unit of a scheduled item on a continuously operating production line.

**OPER.** The operation sequence number that identifies an operation detail record within a manufacturing order.

**DESCRIPTION.** The description that identifies this operation.

**FAC ID (Facility ID).** The grouping of workers or machines used to perform the operation.

**HOURS.**

**LABOR.** The labor time (in hours) required to run one unit of the item in production.

**MACHINE.** The machine time (in hours) required to produce one unit of the item.

**TBC.** This code indicates the relationship between standard operation run unit time and expected operation quantities. The code is used to determine standard operation run labor hours, and run machine hours:

<b>Blank</b>	Hours per unit
<b>C</b>	Cost per piece (outside operations)
<b>H</b>	Hours per lot size
<b>P</b>	Pieces per hour
<b>M</b>	Minutes per piece
<b>1</b>	Hours per 10 units
<b>2</b>	Hours per 100 units
<b>3</b>	Hours per 1000 units
<b>4</b>	Hours per 10000 units

**COMPONENT.** The material used in the production of the scheduled item.

**SEQ.** The user-defined sequence number used to uniquely identify the component.

**FE.** The user-assigned number to identify a feature.

**OP.** Option number for a feature.

**QUANTITY PER.** The quantity of a component used in one parent assembly.

**IT.** Code that best describes the type of item:

- 0** Phantom
- 1** Assembly or subassembly
- 2** Fabricated item
- 3** Raw material
- 4** Purchased item
- 9** User option
- F** Feature
- K** Kit

**LOCATIONS.**

**SUPPLY.** The location that supplies parts to line delivery locations.

**LINE.** The location on the production line where the component is normally delivered.

**EFFECTIVE.**

**FROM.** The date from which this product structure relationship is effective.

**TO.** The date to which this product structure relationship is effective.

**Messages.** This field contains any error messages or warnings.

## Item/Line Audit—Item/Line to Routing Hours Comparison (AMQ2J)

NORTHCREEK IND		ITEM/LINE AUDIT										DATE 9/02/
**	TIME 15.28.24	PAGE 1	AMQ2J	ITEM/LINE TO ROUTING HOURS COMPARISON								
				ALLOWABLE	VARIANCE	PERCENT	.10					
SCHED	ITEM/	LINE/	ALT/	OPER	OPER	ITEM-LINE	ROUTING	VARIANCE				
COMPONENT/	SCHEDULE/	LOCTN	FIRST	WHERE	CHANGEOVER/	SETUP/	SETUP/	SETUP/	ERRORS/WARNINGS			
WH PARENT ITEM	USER SEQ	USED	USED	FLOW TIME	RUN-UNIT	RUN-UNIT	RUN-UNIT	ERRORS/WARNINGS				
ATL BACCFEX	PLN1A				1.0		.0	999.99	W	AM-		
9079	CHANGEOVER HOURS	EXCEED	VARIANCE	PERCENT								
					2.50000		.000	999.99	E	AM-		
9105	FLOW TIME HOURS	EXCEED	VARIANCE	PERCENT								
ATL BACCFEX	PLN1F				.0		.0	.00				
					1.00000		.000	999.99	E	AM-		
9105	FLOW TIME HOURS	EXCEED	VARIANCE	PERCENT								
ATL BACCFEX	PLN1F				.0		.0	.00				
	BLALMSTR106				.00000		.000	.00	E	AM-		
9379	LINE LOCATION	DOES NOT	EXIST IN	WHS								
ATL BACTFEX	PLN1A				.0		.0	.00				
					2.50000		.000	999.99	E	AM-		
9105	FLOW TIME HOURS	EXCEED	VARIANCE	PERCENT								

The Item Line Audit report provides an audit function to test the validity of key data in the Item/Line, Component/Line, and Manufacturing Order Routing master files. Run this report periodically to verify the integrity of these files. This report only prints discrepancies between changeover and flow time hours in the Item/Line file and calculated unit setup and run hours in the Routing file.

This report is printed when you select option 9, Item/Line Audit, on the Reports menu (AMQM20).

### Fields

**WH.** The warehouse stock location for the item. The warehouse prints only if the record is in error.

**SCHED ITEM.** The number of the finished item to be produced for this schedule.

**COMPONENT.** The number assigned to the material used in the production of the finished item.

**PARENT ITEM.** The item number for the parent item.

**LINE.** The production line for the scheduled item.

**SCHEDULE.** The number assigned to this production schedule.

**USER SEQ.** User sequence number (1, or 2, according to install/tailor options).

**ALT (Alt rtg code).** The number that designates the alternate routing for this operation.

**LOCTN (Location).** The location on the production line where the component is normally delivered.

**OPER FIRST USED.** The operation sequence number that identifies the operation where the component is used.

**OPER WHERE USED.** The operation sequence number that identifies the operation where the component is used.

**ITEM-LINE CHANGEOVER.** The time necessary to change from one production run to another. This is specified in the Item Line file.

**FLOW TIME.** The elapsed time (in hours) required to produce one unit of a scheduled item on a continuously operating production line. This is specified in the Item Line File.

**ROUTING.** Values accumulated from the routing operations specified in the Routing file for the Item/Line based on the Prime Load Code of the production facility specified in each routing operation.

<b>Prime Load Code</b>	<b>Definition</b>
<b>0</b>	No hours accumulated
<b>1</b>	Run machine hours
<b>2</b>	Setup labor hours divided by setup crew size
<b>3</b>	(Setup labor hours divided by setup crew size) plus machine hours
<b>4</b>	Run labor hours
<b>5</b>	(Setup labor hours divided by setup crew size) plus run labor hours

**SETUP.** An accumulation of standard setup times specified for each routing operation.

**RUN-UNIT.** An accumulation of calculated run-unit hours based on run-unit hours (factored by time basis code) specified in the routing operation.

#### **VARIANCE.**

**SETUP.** Calculated variance between the changeover hours and sum of the unit setup hours.

**RUN-UNIT.** Calculated variance between the flow time hours and sum of the calculated run hours per unit.

**ERRORS/WARNINGS.** Error messages and warnings for the referenced item.



Item/Line (AMQ2Q1 and AMQ2Q2)

```

NORTHCREEK IND
** TIME 15:23:12 PAGE 1 AMQ2Q1
ITEM/LINE DATE 8/28/
FOR WAREHOUSE 1
ALTERNATE ROUTING CODE
-OR-
ALTERNATE ROUTING CODE BASE ONLY
EC EFFECTIVITY DATE 6/21/**

LINE MDLIS MODEL 100 SYSTEM MAIN LINE ITEM RATE 120.000 P/
C P DESIGNATION PRIMARY START OPT 3 OVERLAP N
ITEM MDL100S MODEL 100 SYSTEM SCHEDULE GROUP S-NUMBER DEFAULT ALT RTG CODE
CARRY FWD Y STOCK LOC MDL1W1 ENG DRAW CHANGEOVER HOURS .1 FLOW TIME .192
LOT 50.000 MIN 10.000 MAX 100.000

WORK ---- HOURS ---- I - CONTAINER --- LOCATIONS --
--- EFFECTIVE ---
OPER CTR LABOR MACHINE TBC COMPONENT LVL SEQ FE OP QUANTITY PER T QTY PER DESC SUPPLY LINE
FROM TO
0010 MDL01 250.00 .00 M MJIT103 1.000 4 100.000 A1B212 MDL1W1
MJIT202 .003 4 100.000 A1B112 MDL1W1
MJIT203 4.000 4 100.000 A1B121 MDL1W1
MJIT204 1.000 4 100.000 A1B122 MDL1W1
MJIT205 .500 4 100.000 A1B132 MDL1W1
0010 MDL01 250.00 .00 M MJIT601 1.000 4 100.000 A1B112 MDL1W1
0010 MDL01 250.00 .00 M MJIT210 1.000 4 100.000 A1B212 MDL1W1
MJIT211 12.000 4 100.000 A1B212 MDL1W1
E AM-9015 COMPONENT DELIVERY LOCATION NOT FOUND
E AM-XXXX LOCATION COMPONENT CONTROL NOT FOUND
    
```

```

NORTHCREEK IND
** TIME 13:23:45 PAGE 1 AMQ2Q2
ITEM/LINE DATE 8/28/
FOR WAREHOUSE 1
ITEM MDL100S
-OR-
ITEM S-NUMBER
ALTERNATE ROUTING CODE
-OR-
DEFAULT ALTERNATE ROUTING CODES USED
EC EFFECTIVITY DATE 1/01/**

SITE DT1 REVISION ITEM PROCESS: EFFECTIVE FROM xx/xx/xx TO xx/xx/xx BOM ID
PRIMARY EFFECTIVE FROM xx/xx/xx TO xx/xx/xx ROUTING ID VERSION

ITEM MDL100S MODEL 100 SYSTEM SCHEDULE GROUP S-
NUMBER DEFAULT ALT RTG CODE
LINE MDLIS MODEL 100 SYSTEM MAIN LINE ITEM RATE 120.000 P/
C P DESIGNATION PRIMARY START OPT 3 OVERLAP N
CARRY FWD Y
STOCK LOC MDL1W1 DEF REC LOC ENG DRAW DEFAULT MAX CONTAINERS 2 CHANGEOVER HOURS
.1 FLOW TIME .192

WORK ---- HOURS ---- I ---- CONTAINER ---- -- LOCATIONS --
--- EFFECTIVE ---
OPER CTR LABOR MACHINE TBC COMPONENT SEQ FE OP QUANTITY PER T MAX QTY PER DESC SUPPLY LINE
FROM TO
0010 MDL01 250.00 .00 M MJIT103 1.000 4 16 100.000 A1B212 MDL1W1
MJIT202 .003 4 2 100.000 A1B112 MDL1W1
MJIT203 4.000 4 32 100.000 A1B121 MDL1W1
MJIT204 1.000 4 8 100.000 A1B122 MDL1W1
MJIT205 .500 4 32 100.000 A1B132 MDL1W1
0010 MDL01 250.00 .00 M MJIT601 1.000 4 192 100.000 A1B112 MDL1W1
0010 MDL01 250.00 .00 M MJIT210 1.000 4 8 100.000 A1B212 MDL1W1
MJIT211 12.000 4 16 100.000 A1B212 MDL1W1
E AM-9015 COMPONENT DELIVERY LOCATION NOT FOUND
    
```

The Item/Line reports (AMQ2Q1 and AMQ2Q2) show material and labor information for an item/line combination. The printing sequence is by line or item, S-Number for

an item if feature/options are supported, EC effectivity date, and an alternate routing code.

These reports are printed when you select option 6, Item/Line, on the Reports menu (AMQM20) and EPDM is activated.

## Fields

**ALTERNATE ROUTING CODE.** The alternate routing code selected.

The next six fields appear only if EPDM is activated:

**SITE.** The site identifier selected.

**REVISION.** The revision identifier.

**ITEM PROCESS.** The effective dates of the associated item process.

**BOM ID.** The bill of material number.

**ROUTING ID.** The routing number.

**VERSION.** The version number of the routing.

**ITEM.** The finished item (with description) to be produced for this schedule.

**SCHEDULE GROUP.** A user-defined code used to sequence schedules. It can also identify items that have similar manufacturing characteristics.

**S-NUMBER.** The features and option code for the item. This field appears only if you chose feature/options support during PDM/EPDM tailoring.

**DEFAULT ALT RTG CODE.** A user-defined code that identifies which additional operations you added to the routing.

**LINE.** The production line (with description) on which the item is produced.

**ITEM RATE.** Either pieces per hour or cycle time for the production line/end item combination, indicated by the P/C Code field.

**P/C.** Flag indicating the contents of the Item Rate field:

**blank** Value for any manufacturing order in MOMAST.

**C** Item Rate is expressed as time between pieces (cycle time).

**P** Item Rate is expressed as pieces per hour.

**DESIGNATION.** The production line designation, primary or alternate, for this item.

**START OPT.** For the first schedule of the day, this code will determine how the start time and date will be adjusted.

**1** This day's production will begin with the Changeover Time for this schedule.

**2** This day's production will begin with the Flow Time for this schedule (Changeover will be scheduled on the previous day).

- 3** This day's production will begin with the Cycle Time for the item (Changeover and Flow Time will be scheduled on the previous day). This is the default value.

**OVERLAP.** The code that determines if a schedule can be overlapped with another schedule for this item/line combination.

- Y** Schedule can be overlapped  
**N** Schedule cannot be overlapped

**CARRY FWD (Y,N).** This code determines whether to carry over a quantity.

- Y** Carry quantity over  
**N** Do not carry quantity over

**STOCK LOCATION.** The default location where the finished item is received.

**ENG DRAW.** The unique engineering drawing number assigned to an end product or item.

If this finished item has components that are phantoms, this code specifies for these components of the phantoms how the first operation where-used is to be assigned for these components.

**PHANTOM COMPONENT'S OPER.** The operation sequence number that identifies an operation detail record within a manufacturing order.

**CHANGEOVER HOURS.** The time necessary to change from one production run to another.

**FLOW TIME.** The elapsed time (in hours) required to produce one unit of a scheduled item on a continuously operating production line.

**DESCRIPTION.** The description that identifies this operation.

**FAC ID (Facility ID).** The grouping of workers or machines used to perform the operation.

### **HOURS.**

**LABOR.** The labor time (in hours) required to run one unit of the item in production.

**MACHINE.** The machine time (in hours) required to produce one unit of the item.

**TBC.** This code indicates the relationship between standard operation run unit time and expected operation quantities. The code is used to determine standard operation run labor hours, and run machine hours:

- blank** Hours per unit  
**C** Cost per piece (outside operations)  
**H** Hours per lot size  
**P** Pieces per hour  
**M** Minutes per piece  
**1** Hours per 10 units  
**2** Hours per 100 units  
**3** Hours per 1000 units

**4** Hours per 10000 units

**COMPONENT.** The material used in the production of the scheduled item.

**SEQ.** The user-defined sequence number used to uniquely identify the component.

**FE.** The user-assigned number to identify a feature.

**OP.** Number for a feature.

**QUANTITY PER.** The quantity of a component used in one parent assembly.

**IT.** Code that best describes the type of item:

<b>0</b>	Phantom
<b>1</b>	Assembly or subassembly
<b>2</b>	Fabricated item
<b>3</b>	Raw material
<b>4</b>	Purchased item
<b>9</b>	User option
<b>F</b>	Feature
<b>K</b>	Kit

**LOCATIONS.**

**SUPPLY.** The location that supplies parts to line delivery locations.

**LINE.** The location on the production line where the component is normally delivered.

**EFFECTIVE.**

**FROM.** The date from which this product structure relationship is effective.

**TO.** The date to which this product structure relationship is effective.

**Messages.** This field contains any error messages or warnings.

## Item/Line Maintenance Edit List (AMQCIL)

```

NORTHCREEK IND                ITEM/LINE MAINTENANCE EDIT LIST    DATE **/**/
** TIME **.**.**.** PAGE **** AMQCIL                                OPER ***      UPDATE #***

WAREHOUSE      *A3 *****A30                                (Example of added r
ecord)
FINISHED ITEM  *****A15 *****A30
PRODUCTION LINE ***A5 *****A40

*** ADD ***

CHANGEOVER TIME          NEW VALUE
FLOW TIME                **.*
ITEM RATE DESIGNATOR     **.*
ITEM RATE                *****
OVERLAP CODE             *
DEFAULT RECEIPT LOCATION *****
DEFAULT ALT RTG SELECT CODE **
FIRST SCHEDULE START OPTION *
DEFAULT LINE LOCATION    *****
PHANTOM COMPONENT'S OPERATION *
SCHEDULE LOT SIZE       *,***,***.***
SCHEDULE MINIMUM QUANTITY *,***,***.***
SCHEDULE MAXIMUM QUANTITY *,***,***.***
REVISION                *****
ROUTING ID              *****
VERSION                 *****
BOM ID                  *****
DATE LAST MAINTAINED   **/**/**
MAINTAINED BY          *****

WAREHOUSE      *A3 *****A30                                (Example of changed
record)
FINISHED ITEM  *****A15 *****A30
PRODUCTION LINE ***A5 *****A40

*** CHANGE ***

CHANGEOVER TIME          OLD VALUE      NEW VALUE
FLOW TIME                **.*          **.*
ITEM RATE DESIGNATOR     **.*          **.*
ITEM RATE                *****        *****
OVERLAP CODE             *              *
DEFAULT ALT RTG SELECT CODE **              **
FIRST SCHEDULE START OPTION *              *
DEFAULT STOCK LOCATION    *****        *****
PHANTOM COMPONENT'S OPERATION *              *
SCHEDULE LOT SIZE       *,***,***.***    *,***,***.***
SCHEDULE MINIMUM QUANTITY *,***,***.***    *,***,***.***
SCHEDULE MAXIMUM QUANTITY *,***,***.***    *,***,***.***
DATE LAST MAINTAINED   **/**/**      **/**/**
MAINTAINED BY          *****        *****

TOTAL ADDS          ****
TOTAL CHANGES     ****
TOTAL DELETES      ****

*** END OF REPORT ***

```

### Fields

**Warehouse.** Code defined by your company that identifies the warehouse in which this item is currently stocked.

**Finished item.** Number of the finished item.

**Production line.** Production line in which the item is scheduled.

**Changeover time.** Amount of time needed to set up the production line to begin producing the first item in the schedule.

**Flow time.** Elapsed time (in hours) required to produce one unit of a scheduled item on a continuously-operating production line.

**Item rate designator.** Code indicating the contents of the item rate field:

- C Item rate is expressed as cycle time between pieces.
- P Item rate is expressed as pieces per hour.

**Item rate.** Rate at which items are produced on the production line, stated in either pieces per hour or cycle time (time between pieces coming off the line).

**Overlap code.** Code specifying if this schedule can overlap with the preceding schedule (that is, run at the same time as the schedule running before it).

**Default receipt location.** The location used as the default for receiving items.

**Default line location.** Identifier of the location at the production line where component items are to be delivered by the replenishment system.

**Default Alt Rtg select code.** A user-defined code that identifies which additional operations you added to the routing. A default of blank indicates that you added only base operations (added no additional operations).

**First schedule start option.** Code used to determine where in the production cycle the first schedule of the day is positioned.

- 1 This day's production will begin with the Changeover Time for this schedule.
- 2 This day's production will begin with the Flow Time for this schedule. (Changeover will be scheduled on the previous day.)
- 3 This day's production will begin with the Cycle Time for the item. (Changeover and Flow Time will be scheduled on the previous day.) This is the default value.

**Default line location.** Identifier of the location at the production line where component items are to be delivered by the replenishment system.

**Phantom component's operation.** When a finished item (grandfather) has a phantom item (father) as one of its components (son), the components of the phantom can be used as components of the finished item (that is, the sons can become direct descendants of the grandfather). This code specifies how the first operation where-used is assigned to the components of a phantom when component/line definitions are created.

**Note:** Changes you make apply only to future records created for components of phantoms.

**Schedule lot size.** The target quantity, in pieces, for schedules created through lot sizing. This value must be a multiple of the standard container quantity (quantity per container).

**Schedule minimum quantity.** The least allowable quantity, in pieces, for a schedule created by lot sizing. This value must be a multiple of the standard container quantity (quantity per container).

**Schedule maximum quantity.** The greatest allowable quantity, in pieces, for a schedule created by lot sizing. The value must be a multiple of the standard container quantity (quantity per container).

**Revision.** This field appears only if EPDM is activated. The revision identifier associated with this item process.

**Routing ID.** This field appears only if EPDM is activated. The item number whose routing is used for this item.

**Version.** This field appears only if EPDM is activated. The version number of the routing.

**BOM ID.** This field appears only if EPDM is activated. The identifier of the bill of material associated with this item process.

**Date last maintained.** Date someone last maintained this record.

**Maintained by.** User ID of the person who last maintained this record.

## Item/Line Process by Item-as Costs (AMQ2P4)

NORTHCREEK IND		ITEM/LINE PROCESS BY ITEM			DATE 8/28/	
**	TIME 13:36:59	PAGE 1	AMQ2P4			
AS COSTS FOR ALL WAREHOUSES FROM CLRT177 TO CLRT177 SCHED DATES FROM FIRST TO LAST						
WH 1 ITEM CLRT177 WALL CLOCK LINE PLCL1 CLOCK PRODUCTION LINE ONE						
TOTAL ITEMS (UNITS) SCHEDULED		1,900.000	COMPLETED	.000	VARIANCE	1,900.000
-----						
MATERIAL COSTS						
		OPER			MATERIAL CONSUMED (COSTS)	
COMPONENT	SEQ	ACTUAL	UM W/	VARIANCE		
U LINE LOC	STANDARD		SCRAP			
BK3HPCK	3" BLACK HANDS PACK		PK 0101 XCL1W9X		.00	
	.00					
0				.00		.0
BK9HPCK	9" BLACK HANDS PACK		PK 0101 XCL1W9X		.00	
	.00					
0				.00		.0
BL3HPCK	3" BLUE CK DS PACK		PK 0101 XCL1W9X		.00	
	.00					
0				.00		.0
0	TOTAL MATERIAL CONSUMED (COSTS)				.00	.0
					.00	
	.00					
-----						
OPERATION COSTS						
OPER	PER UNIT	SETUP LABOR	RUN LABOR	STANDARD COSTS	MACHINE	T
OTAL				OVERHEAD		
0011 PAINT HARDWARE		.00		.00		
.00						
WORK CTR PLW01 YIELD	.0		.00		.00	
.0000						
COMPLETE	.000					
SCRAP	.000					
0012 PAINT HARDBOARD		.00		.00		
.00						
WORK CTR PL201 YIELD	.0		.00		.00	
.0000						
COMPLETE	.000					
SCRAP	.000					
TOTAL OPERATING COSTS		.00		.00		
.00			.00		.00	
OPERATION COSTS PER UNIT		.0000		.0000		
.0000			.0000		.0000	



---

NORTHCREEK IND  
 \*\* TIME 13:36:59 PAGE 1 AMQ2P4

ITEM/LINE PROCESS SUMMARY BY ITEM DATE 8/28/

AS COSTS  
 FOR ALL WAREHOUSES  
 FROM CLRT177 TO CLRT177  
 SCHED DATES FROM FIRST TO LAST

DATE LAST	SCHEDULED	COMPLETED	VARIANCE
WH 1 MAINTAINED ITEM CLRT177 08/29/**	1,900.000	.000	1,900.000

----- STANDARD COSTS -----

MATERIAL CONSUMED (COSTS)	SETUP	LABOR	SCRAP	RUN LABOR	OVERHEAD	MACHINE	TOTAL	STANDARD	ACTUA
L	0	0	0	0	0	0	0	0	0

-----

\*\* GRAND TOTALS FOR ITEMS FROM CLRT177 TO CLRT177

----- STANDARD COSTS -----

MATERIAL CONSUMED (COSTS)	SETUP	LABOR	SCRAP	RUN LABOR	OVERHEAD	MACHINE	TOTAL	STANDARD	ACTUA
L	0	0	0	0	0	0	0	0	0

---

This report is printed when you select option 5, Item/Line Process, on the Reports menu (AMQM20).

The report options as selected on display AMQ2E1 include warehouse; by line, by item, or by planner; material and labor (as units and hours or costs); and schedule date.

**Fields**

**WH.** The warehouse from which the components are issued or the finished items received (manufactured).

**ITEM.** The finished item (with description) to be produced for this schedule.

**LINE.** The production line (with description) on which the item is produced.

**TOTAL ITEMS (UNITS) SCHEDULED.** Total number of items scheduled for production.

**COMPLETED.** Total number of items produced.

**VARIANCE.** Difference between the total number of items scheduled for production and the total number of items produced.

**COMPONENT.** The material (with description after SEQ) used in the production of the scheduled item.

**SEQ.** The user-defined sequence number used to uniquely identify the component.

**UM.** The unit of measure in which the item quantity is expressed.

**OPER W/U.** The operation sequence number that identifies the operation where the component is used.

**LINE LOC.** The location on the production line to which the specified component is delivered.

**MATERIAL CONSUMED (COSTS).**

**STANDARD.** Costs of standard units consumed.

**ACTUAL.** Costs of actual units consumed.

**SCRAP.** Number of units scrapped.

**VARIANCE.** Difference between standard material consumed and actual material consumed.

**TOTAL MATERIAL CONSUMED (COSTS).** Sum of actual units consumed and number of units scrapped.

**OPER.** The operation sequence number (with description) that identifies a new operation detail record.

**WORK CTR.** The grouping of workers or machines used to perform the operation.

**YIELD.** The percentage of Total Quantity Complete of the Total Quantity Consumed.

**COMPLETE.** Total quantity received (RM transaction has been performed).

**SCRAP.** Total quantity scrapped.

**STANDARD COSTS.**

**SETUP LABOR.** The labor costs required to setup one unit of the item for production.

**RUN LABOR.** The labor costs required to run one unit of the item in production.

**OVERHEAD.** Machine content standard overhead costs.

**MACHINE.** The actual machine costs total to date.

**TOTAL.** Sum of standard costs.

**PER UNIT.** The actual machine costs per unit.

**TOTAL OPERATING COSTS.** Column totals for standard costs.

**OPERATION COSTS PER UNIT.** Column totals for standard costs per unit.

## Item/Line Process by Item-in Units and Hours (AMQ2P3)

NORTHCREEK IND		ITEM/LINE PROCESS BY ITEM			DATE 8/29/	
**	TIME 13:36:24	PAGE 1	AMQ2P3			
IN UNITS AND HOURS FOR WAREHOUSE 1 FROM CLRT177 TO CLRT177 SCHED DATES FROM 08/29/** TO 08/29/**						
WH 1 ITEM CLRT177 WALL CLOCK LINE PLCL1 CLOCK PRODUCTION LINE ONE						
TOTAL ITEMS (UNITS) SCHEDULED		1,900.000	COMPLETED	.000	VARIANCE	1,900.000
-----						
MATERIAL PIECES CONSUMED						
			OPER		MATERIAL CONSUMED (UNITS)	
COMPONENT	SEQ	ACTUAL	UM W/ SCRAP	VARIANCE		
U LINE LOC	STANDARD					
BK3HPCK	3" BLACK HANDS PACK		PK 0101	XCL1W9	.000	.000 .00
0	.000					
BK9HPCK	9" BLACK HANDS PACK		PK 0101	XCL1W9	.000	.000 .00
0	.000					
BL3HPCK	3" BLUE CK PACK		PK 0101	XCL1W9	.000	.000 .00
0	.000					
TOTAL MATERIAL CONSUMED (UNITS)					.000	.000 .00
0						.000
		.000	-----			
OPERATION HOURS						
OPER		SETUP LABOR	RUN LABOR	STANDARD HOURS MACHINE	TOTAL	PER PIE
CE						
0011	PAINT HARDWARE	.00	0.00	.00	.0000	.00
00						
WORK CTR	PLW01 YIELD .0					
COMPLETE	.000					
SCRAP	.000					
0012	PAINT HARDBOARD	.00	0.00	.00	.0000	.00
00						
WORK CTR	PL201 YIELD .0					
COMPLETE	.000					
SCRAP	.000					
TOTAL OPERATION HOURS		.00	.00	.00	.00	
OPERATION HOURS PER UNIT		.0000	.0000	.0000	.0000	

---

NORTHCREEK IND  
 \*\* TIME 13:36:24 PAGE 1 AMQ2P3

ITEM/LINE PROCESS SUMMARY BY ITEM DATE 8/28/

IN UNITS AND HOURS  
 FOR WAREHOUSE 1  
 FROM CLRT177 TO CLRT177  
 SCHED DATES FROM FIRST TO LAST

DATE LAST		SCHEDULED	COMPLETED	VARIANCE
WH 1	MAINTAINED ITEM CLRT177 08/29/**	1,900.000	.000	1,900.000
STANDARD HOURS				
MATERIAL CONSUMED (U				
NITS)				
SETUP LABOR	RUN LABOR	MACHINE	TOTAL	STANDARD
SCRAP				ACTUAL
.00	.00	.00	.00	7,725.000
.000				

---

\*\* GRAND TOTALS FOR ITEMS FROM CLRT177 TO CLRT177

SETUP LABOR	RUN LABOR	MACHINE	TOTAL
.00	.00	.00	.00

---

This report is printed when you select option 5, Item/Line Process, on the Reports menu (AMQM20).

The report options as selected on display AMQ2E1 include warehouse; by line, by item, or by planner; material and labor (as units and hours or costs); and schedule date.

**Fields**

**WH.** The warehouse from which the components are issued or the finished items received (manufactured).

**ITEM.** The finished item (with description) to be produced for this schedule.

**LINE.** The production line (with description) on which the item is produced.

**TOTAL ITEMS (UNITS) SCHEDULED.** Total number of items scheduled for production.

**COMPLETED.** Total number of items produced.

**VARIANCE.** Difference between the total number of items scheduled for production and the total number of items produced.

**COMPONENT.** The material used in the production of the scheduled item.

**SEQ.** The user-defined sequence number used to uniquely identify the component.

**Description.** The description of the component.

**UM.** The unit of measure in which the item quantity is expressed.

**OPER W/U.** The operation sequence number that identifies the operation where the component is used.

**LINE LOC.** The location on the production line to which the specified component is delivered.

**MATERIAL CONSUMED (UNITS).**

**STANDARD.** Standard units required.

**ACTUAL.** Actual units consumed.

**SCRAP.** Number of units scrapped.

**VARIANCE.** Difference between standard material consumed and actual material consumed.

**TOTAL MATERIAL CONSUMED (UNITS).** Sum of actual units consumed and number of units scrapped.

**OPER.** The operation sequence number (with description) that identifies a new operation detail record.

**WORK CTR.** The grouping of workers or machines used to perform the operation.

**YIELD.** Operation yield expressed as a percentage.

**COMPLETE.** Total quantity received (RM transaction has been performed).

**SCRAP.** Total quantity scrapped.

**STANDARD HOURS.**

**SETUP LABOR.** The labor hours required to setup one unit of the item for production.

**RUN LABOR.** The labor hours required to run one unit of the item in production.

**MACHINE.** The actual machine hours total to date.

**TOTAL.** Sum of standard hours.

**PER PIECE.** The actual machine hours per piece.

**TOTAL OPERATION HOURS.** Column totals for standard hours.

**OPERATION HOURS PER UNIT.** Column totals for standard hours per unit.

## Item/Line Process by Line-as Costs (AMQ2P2)

NORTHCREEK IND		ITEM/LINE PROCESS BY LINE				DATE 8/28/	
**	TIME 13:35:42	PAGE 1	AMQ2P2				
AS COSTS FOR ALL WAREHOUSES FROM PLCL1 TO LAST SCHED DATES FROM FIRST TO LAST							
LINE PLCL1 CLOCK PRODUCTION LINE ONE							
WH 1	ITEM CLRT177	WALL CLOCK					
TOTAL ITEMS (UNITS)	SCHEDULED	1,900.000	COMPLETED	.000	VARIANCE	1,900.000	
-----							
MATERIAL COSTS							
MATERIAL CONSUMED (COSTS) -----				OPER -----			
COMPONENT	SEQ	ACTUAL	UM W/	VARIANCE			
U LINE LOC	STANDARD	EXTERNAL ADJUSTMENT HOUSING	EA 0081	XCL1W8			
ANHOB10		.00				.00	
0						.00	.0
ANHOB11	2-1/						
3	EXTERNAL ADJ CONNECT ROD	EA 0081	XCL1W8		.00	.00	.0
0						.00	.0
AN00B10	EXTERNAL ADJUSTMENT KNOB		EA 0081	XCL1W8		.00	
		.00				.00	.0
0						.00	.0
TOTAL MATERIAL CONSUMED (COSTS)						.00	.0
0						.00	
-----							
OPERATION COSTS							
				----- STANDARD COSTS -----			
OPER		SETUP LABOR	RUN LABOR	OVERHEAD	MACHINE	T	
OTAL	PER UNIT						
0011	PAINT HARDWARE	.00		.00			
.00							
WORK CTR	PLW01 YIELD	.0	.00		.00		
	.0000						
COMPLETE		.000					
SCRAP		.000					
OPER		SETUP LABOR	RUN LABOR	OVERHEAD	MACHINE	T	
OTAL	PER UNIT						
0012	PAINT HARDBOARD	.00		.00			
.00							
WORK CTR	PL201 YIELD	.0	.00		.00		
	.0000						
COMPLETE		.000					
SCRAP		.000					
TOTAL OPERATING COSTS		.00		.00			
.00			.00		.00		
OPERATION COSTS PER UNIT		.0000		.0000			
0000			.0000		.0000		

---

NORTHCREEK IND  
 \*\* TIME 13:35:42 PAGE 1 AMQ2P2

ITEM/LINE PROCESS SUMMARY BY LINE DATE 8/28/

AS COSTS  
 FOR WAREHOUSE 1  
 FROM PLCL1 TO LAST  
 SCHED DATES FROM FIRST TO LAST

LINE PLCL1 CLOCK PRODUCTION LINE ONE

STANDARD COSTS						MATERIAL CONSUMED (C		
OSTS)	SETUP	LABOR	RUN LABOR	OVERHEAD	MACHINE	TOTAL	STANDARD	ACTUA
L		SCRAP						
		0		0		0	0	
		0						
0			0		0			

-----

\*\* GRAND TOTALS FOR LINES FROM PLC1 TO LAST

STANDARD COSTS						MATERIAL CONSUMED (C		
OSTS)	SETUP	LABOR	RUN LABOR	OVERHEAD	MACHINE	TOTAL	STANDARD	ACTUA
L		SCRAP						
		0		0		0	0	
		0						
0			0		0			

---

This report is printed when you select option 5, Item/Line Process, on the Reports menu (AMQM20).

The report options as selected on display AMQ2E1 include warehouse; by line, by item, or by planner; material and labor (as units and hours or costs); and schedule date.

**Fields**

**LINE.** The production line (with description) on which the item is produced.

**WH.** The warehouse from which the components are issued or the finished items received (manufactured).

**ITEM.** The finished item (with description) to be produced for this schedule.

**TOTAL ITEMS (UNITS) SCHEDULED.** Total number of items scheduled for production.

**COMPLETED.** Total number of items produced.

**VARIANCE.** Difference between the total number of items scheduled for production and the total number of items produced.

**COMPONENT.** The material used in the production of the scheduled item.

**SEQ.** The user-defined sequence number used to uniquely identify the component.

**Description.** The description of the component.

**UM.** The unit of measure in which the item quantity is expressed.

**OPER W/U.** The operation sequence number that identifies the operation where the component is used.

**LINE LOC.** The location on the production line to which the specified component is delivered.

**MATERIAL CONSUMED (COSTS).**

**STANDARD.** Costs of standard units required.

**ACTUAL.** Costs of actual units consumed.

**SCRAP.** Number of units scrapped.

**VARIANCE.** Difference between standard material consumed and actual material consumed.

**TOTAL MATERIAL CONSUMED (COSTS).** Sum of actual units consumed and number of units scrapped.

**OPER.** The operation sequence number (with description) that identifies a new operation detail record.

**WORK CTR.** The grouping of workers or machines used to perform the operation.

**YIELD.** Operation yield expressed as a percentage.

**COMPLETE.** Total quantity received (RM transaction has been performed).

**SCRAP.** Total quantity scrapped.

**STANDARD COSTS.**

**SETUP LABOR.** The labor costs required to setup one unit of the item for production.

**RUN LABOR.** The labor costs required to run one unit of the item in production.

**OVERHEAD.** Machine content standard overhead costs.

**MACHINE.** The actual machine costs total to date.

**TOTAL.** Sum of standard costs.

**PER UNIT.** The actual machine costs per unit.

**TOTAL OPERATING COSTS.** Column totals for standard costs.

**OPERATION COSTS PER UNIT.** Column totals for standard costs per unit.



### Item/Line Process by Line in Units and Hours (AMQ2P1)

NORTHCREEK IND		ITEM/LINE PROCESS BY LINE				DATE 8/28/	
**	TIME 13:35:05	PAGE	1	AMQ2P1			
				IN UNITS AND HOURS			
				FOR WAREHOUSE 1			
				FROM PLCL1 TO LAST			
				SCHED DATES FROM FIRST	TO LAST		
LINE PLCL1 CLOCK PRODUCTION LINE ONE							
WH 1	ITEM CLRT177	WALL CLOCK					
TOTAL ITEMS (UNITS) SCHEDULED	1,900.000	COMPLETED	.000	VARIANCE	1,900.000		
-----							
MATERIAL PIECES CONSUMED							
MATERIAL CONSUMED (UNITS) -----				OPER -----			
COMPONENT	SEQ			UM W/			
U LINE LOC	STANDARD	ACTUAL	SCRAP	VARIANCE			
0 PEALMND	6.000	ALMOND TERRA COTTA PAINT	GL 0011	XCL1W1	.000	6.000	.00
0 PEROSED	6.000	ROSE DUST ENAMEL SPRAY PAINT	GL 0011	XCL1W1	.000	9.000	.00
0 PESHELL	10.000	SHELL ENAMEL SPRAY PAINT	GL 0011	XCL1W1	.000	10.000	.00
TOTAL MATERIAL CONSUMED (UNITS)				.000 .00			
				7,725.000			
-----							
OPERATION HOURS							
				----- STANDARD HOURS -----			
OPER	CE	SETUP LABOR	RUN LABOR	MACHINE	TOTAL	PER PIE	
0011 PAINT HARDWARE		.00	.00	.00	.00	.00	
00 WORK CTR PLW01 YIELD	.0						
00 COMPLETE	.000						
00 SCRAP	.000						
0012 PAINT HARDBOARD		.00	.00	.00	.00	.00	
00 WORK CTR PL201 YIELD	.0						
00 COMPLETE	.000						
00 SCRAP	.000						
TOTAL OPERATION HOURS		.00	.00	.00	.00		
OPERATION HOURS PER UNIT		.0000	.0000	.0000	.0000		

NORTHCREEK IND		ITEM/LINE PROCESS SUMMARY BY LINE		DATE 8/28/
** TIME 13:35:05	PAGE 1	AMQ2P1		
IN UNITS AND HOURS FOR WAREHOUSE 1 FROM PLCL1 TO LAST SCHED DATES FROM FIRST TO LAST				
LINE PLCL1	CLOCK	PRODUCTION LINE ONE	SCHEDULED	
			1,250.000	
----- STANDARD HOURS -----				
SETUP LABOR	RUN LABOR	MACHINE	TOTAL	
14.25	25.00	15.00	54.25	
-----				
LINE PLCL3	CLOCK	PRODUCTION LINE THREE		
----- STANDARD HOURS -----				
SETUP LABOR	RUN LABOR	MACHINE	TOTAL	
5.00	3.50	2.75	11.25	
-----				
** GRAND TOTALS FOR LINES FROM PLCL1 TO LAST				
----- STANDARD HOURS -----				
SETUP LABOR	RUN LABOR	MACHINE	TOTAL	
19.25	28.50	17.75	65.50	

The Item/Line Process reports (AMQ2P1, AMQ2P2, AMQ2P3, AMQ2P4, AMQ2P5, and AMQ2P6) show standard costs, material consumed (costs), and standard hours for manufacturing an item or items on a production line over a period a time. The AMQ2P1, AMQ2P3, and AMQ2P5 reports show material and labor in units and hours. The AMQ2P2, AMQ2P4, and AMQ2P6 reports show material labor as costs. The printing sequence of these reports are by line, by item, or by planner.

These reports are printed when you select option 5, Item/Line Process, on the Reports menu (AMQM20).

The report options as selected on display AMQ2E1 include warehouse; by line, by item, or by planner; material and labor (as units and hours or costs); and schedule date.

**Fields**

**LINE.** The production line (with description) on which the item is produced.

**WH.** The warehouse from which the components are issued or the finished items received (manufactured).

**ITEM.** The finished item (with description) to be produced for this schedule.

**TOTAL ITEMS (UNITS) SCHEDULED.** Total number of items scheduled for production.

**COMPLETED.** Total number of items produced.

**VARIANCE.** Difference between the total number of items scheduled for production and the total number of items produced.

**COMPONENT.** The material used in the production of the scheduled item.

**SEQ.** The user-defined sequence number used to uniquely identify the component.

**Description.** The description of the component.

**UM.** The unit of measure in which the item quantity is expressed.

**OPER W/U.** The operation sequence number that identifies the operation where the component is used.

**LINE LOC.** The location on the production line to which the specified component is delivered.

**MATERIAL CONSUMED (COSTS).**

**STANDARD.** Costs of standard units required.

**ACTUAL.** Costs of actual units consumed.

**SCRAP.** Number of units scrapped.

**VARIANCE.** Difference between standard material consumed and actual material consumed.

**TOTAL MATERIAL CONSUMED (COSTS).** Sum of actual units consumed and number of units scrapped.

**OPER.** The operation sequence number and description that identifies a new operation detail record.

**WORK CTR.** The grouping of workers or machines used to perform the operation.

**YIELD.** Operation yield expressed as a percentage.

**COMPLETE.** Total quantity received (RM transaction has been performed).

**SCRAP.** Total quantity scrapped.

**STANDARD HOURS.**

**SETUP LABOR.** The labor hours required to setup one unit of the item for production.

**RUN LABOR.** The labor hours required to run one unit of the item in production.

**MACHINE.** The actual machine hours total to date.

**TOTAL.** Sum of standard hours.

**PER PIECE.** The actual machine hours per unit.

**TOTAL OPERATING COSTS.** Column totals for standard costs.

**OPERATION COSTS PER UNIT.** Column totals for standard costs per unit.

## Item/Line Process by Planner—as Costs (AMQ2P6)

NORTHCREEK IND	ITEM/LINE PROCESS BY PLANNER	DATE 8/28/	
** TIME 9:49:29 PAGE 1 AMQ2P6	AS COSTS FOR ALL WAREHOUSES FROM FIRST TO LAST		
	SCHED DATES FROM FIRST TO LAST		
PLANNER 00502			
WH 1 ITEM CLRT177 WALL CLOCK			
LINE PLCL1 CLOCK PRODUCTION LINE ONE			
TOTAL ITEMS (UNITS) SCHEDULED	1,900.000	COMPLETED .000	VARIANCE 1,900.000
-----			
MATERIAL COSTS			
MATERIAL CONSUMED (COSTS) -----	OPER	-----	
COMPONENT SEQ	UM W/	VARIANCE	
U LINE LOC STANDARD ACTUAL	SCRAP		
BK3HPCK 3" BLACK HANDS PACK	PK 0101 XCL1W9	.00	
		.00	.0
0 BK9HPCK 9" BLACK HANDS PACK	PK 0101 XCL1W9	.00	
		.00	.00
0 BL3HPCK 3" BLUE CK DS PACK	PK 0101 XCL1W9	.00	
		.00	.0
0			
	TOTAL MATERIAL CONSUMED (COSTS)	.00	.0
0			
		.00	.00
-----			
OPERATION COSTS			
----- STANDARD COSTS -----			
OPER	SETUP LABOR	RUN LABOR	OVERHEAD
OTAL PER UNIT			MACHINE
0011 PAINT HARDWARE	4.51		2.75
9.75			
WORK CTR PLW01 YIELD .0		.00	2.50
.0000			
COMPLETE .000			
SCRAP .000			
0011 PAINT HARDBOARD	4.51		2.75
9.75			
WORK CTR PL201 YIELD .0		.00	2.50
.0000			
COMPLETE .000			
SCRAP .000			
TOTAL OPERATING COSTS	9.02		5.50
9.50			1
		.00	5.00
OPERATION COSTS PER UNIT	.0000		.0000
.00		.0000	.0000

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NORTHCREEK IND  
 \*\* TIME 9:49:43 PAGE 1 AMQ2P6

ITEM/LINE PROCESS SUMMARY BY PLANNER DATE 8/28/

AS COSTS  
 FOR WAREHOUSE 1  
 FROM FIRST TO LAST  
 SCHED DATES FROM FIRST TO LAST

PLANNER 00502

DATE LAST

			SCHEDULED	COMPLETED	VARIANCE
MAINTAINED					
WH 1	ITEM CLRT177	WALL CLOCK	1,900.000	.000	1,900.000
	08/29/**				

----- STANDARD COSTS -----

MATERIAL CONSUMED (COSTS)	SETUP LABOR	LABOR	SCRAP	RUN LABOR	OVERHEAD	MACHINE	TOTAL	STANDARD	ACTUA
L			0		0		0	0	
			0			0			
0				0					

-----

\*\* GRAND TOTALS FOR ITEMS FROM CLRT177 TO CLRT177

----- STANDARD COSTS -----

MATERIAL CONSUMED (COSTS)	SETUP LABOR	LABOR	SCRAP	RUN LABOR	OVERHEAD	MACHINE	TOTAL	STANDARD	ACTUA
L			0		0		0	0	
			0			0			
0				0					

---

This report is printed when you select option 5, Item/Line Process, on the Reports menu (AMQM20).

The report options as selected on display AMQ2E1 include warehouse; by line, by item, or by planner; material and labor (as units and hours or costs); and schedule date.

**Fields**

**PLANNER.** The code of the person responsible for planning and scheduling this finished item.

**WH.** The warehouse from which the components are issued or the finished items received (manufactured).

**ITEM.** The finished item (with description) to be produced for this schedule.

**LINE.** The production line (with description) on which the item is produced.

**TOTAL ITEMS (UNITS) SCHEDULED.** Total number of items scheduled for production.

**COMPLETED.** Total number of items produced.

**VARIANCE.** Difference between the total number of items scheduled for production and the total number of items produced.

**COMPONENT.** The material used in the production of the scheduled item.

**SEQ.** The user-defined sequence number used to uniquely identify the component.

**Description.** The description of the component.

**UM.** The unit of measure in which the item quantity is expressed.

**OPER W/U.** The operation sequence number that identifies the operation where the component is used.

**LINE LOC.** The location on the production line to which the specified component is delivered.

**MATERIAL CONSUMED (COSTS).**

**STANDARD.** Costs of standard units required.

**ACTUAL.** Costs of actual units consumed.

**SCRAP.** Number of units scrapped.

**VARIANCE.** Difference between standard material consumed and actual material consumed.

**TOTAL MATERIAL CONSUMED (COSTS).** Sum of actual units consumed and number of units scrapped.

**OPER.** The operation sequence number and description that identifies a new operation detail record.

**WORK CTR.** The grouping of workers or machines used to perform the operation.

**YIELD.** Operation yield expressed as a percentage.

**COMPLETE.** Total quantity received (RM transaction has been performed).

**SCRAP.** Total quantity scrapped.

**STANDARD COSTS.**

**SETUP LABOR.** The labor costs required to setup one unit of the item for production.

**RUN LABOR.** The labor costs required to run one unit of the item in production.

**OVERHEAD.** Machine content standard overhead costs.

**MACHINE.** The actual machine costs total to date.

**TOTAL.** Sum of standard costs.

**PER UNIT.** The actual machine costs per unit.

**TOTAL OPERATING COSTS.** Column totals for standard costs.

**OPERATION COSTS PER UNIT.** Column totals for standard costs per unit.

## Item/Line Process by Planner—in Units and Hours (AMQ2P5)

NORTHCREEK IND		ITEM/LINE PROCESS BY PLANNER				DATE 8/28/	
** TIME 9:49:03	PAGE 1	AMQ2P5					
IN UNITS AND HOURS FOR WAREHOUSE 1 FROM FIRST TO LAST SCHED DATES FROM FIRST TO LAST							
PLANNER 00502							
WH 1 ITEM CLRT177 WALL CLOCK							
LINE PLCL1 CLOCK PRODUCTION LINE ONE							
TOTAL ITEMS (UNITS) SCHEDULED	1,900.000	COMPLETED	.000	VARIANCE	1,900.000		
-----							
MATERIAL PIECES CONSUMED							
OPER							
-----							
MATERIAL CONSUMED (UNITS)							
COMPONENT	SEQ	STANDARD	ACTUAL	UM W/ SCRAP	VARIANCE		
U LINE LOC							
BK3HPCK		3" BLACK HANDS PACK		PK 0101	XCL1W9	.000	.000
0	.000						
BK9HPCK		9" BLACK HANDS PACK		PK 0101	XCL1W9	.000	.000
0	.000						
BL3HPCK		3" BLUE CK DS PACK		PK 0101	XCL1W9	.000	.000
0	.000						
TOTAL MATERIAL CONSUMED (UNITS)						.000	.000
0							
						7,725.000	7,725.000
-----							
7,725.000							
-----							
OPERATION HOURS							
----- STANDARD HOURS -----							
OPER	CE	SETUP	LABOR	RUN	LABOR	MACHINE	TOTAL
0011	PAIN'T HARDWARE	1.00	.00	.00	1.00	.00	.00
00	WORK CTR PLW01	YIELD	.0	.000	.000		
00	COMPLETE						
00	SCRAP						
0011	PAIN'T HARDBOARD	.00	.00	.00	.00	.00	.00
00	WORK CTR PL201	YIELD	.0	.000	.000		
00	COMPLETE						
00	SCRAP						
TOTAL OPERATION HOURS			1.00	.00	.000	.00	.00
OPERATION HOURS PER UNIT			.0000	.0000	.0000	.0000	.0000

---

NORTHCREEK IND  
 \*\* TIME 9:49:03 PAGE 1 AMQ2P5 ITEM/LINE PROCESS SUMMARY BY PLANNER DATE 8/28/

IN UNITS AND HOURS  
 FOR WAREHOUSE 1  
 FROM FIRST TO LAST  
 SCHED DATES FROM FIRST TO LAST

PLANNER 00502

DATE LAST	MAINTAINED	SCHEDULED	COMPLETED	VARIANCE
WH 1	ITEM CLRT177 00/00/00	WALL CLOCK	1,900.000	.000
				1,900.000

MATERIAL CONSUMED (UNITS)		STANDARD HOURS		TOTAL	STANDARD	ACTUAL
SETUP LABOR	SCRAP	RUN LABOR	MACHINE			
2.00	.000	.00	.00	2.00	.000	7,725.000

\*\* TOTALS FOR PLANNER 00502

STANDARD HOURS		TOTAL
SETUP LABOR	RUN LABOR	
2.00	.00	2.00

\*\* GRAND TOTALS FOR PLANNERS FROM FIRST TO LAST

STANDARD HOURS		TOTAL
SETUP LABOR	RUN LABOR	
2.00	.00	2.00

---

This report is printed when you select option 5, Item/Line Process, on the Reports menu (AMQM20).

The report options as selected on display AMQ2E1 include warehouse; by line, by item, or by planner; material and labor (as units and hours or costs); and schedule date.

### Fields

**PLANNER.** The code of the person responsible for planning and scheduling this finished item.

**WH.** The warehouse from which the components are issued or the finished items received (manufactured).

**ITEM.** The finished item (with description) to be produced for this schedule.

**LINE.** The production line (with description) on which the item is produced.

**TOTAL ITEMS (UNITS) SCHEDULED.** Total number of items scheduled for production.

**COMPLETED.** Total number of items produced.

**VARIANCE.** Difference between the total number of items scheduled for production and the total number of items produced.

**COMPONENT.** The material used in the production of the scheduled item.



**SEQ.** The user-defined sequence number used to uniquely identify the component and show its position in the bill of material.

**Description.** The description of the component.

**UM.** The unit of measure in which the item quantity is expressed.

**OPER W/U.** The operation sequence number that identifies the operation where the component is used.

**LINE LOC.** The location on the production line to which the specified component is delivered.

**MATERIAL CONSUMED (UNITS).**

**STANDARD.** Standard units required.

**ACTUAL.** Actual units consumed.

**SCRAP.** Number of units scrapped.

**VARIANCE.** Difference between standard material consumed and actual material consumed.

**TOTAL MATERIAL CONSUMED (UNITS).** Sum of actual units consumed and number of units scrapped.

**OPER.** The operation sequence number and description that identifies a new operation detail record.

**WORK CTR.** The grouping of workers or machines used to perform the operation.

**YIELD.** Operation yield expressed as a percentage.

**COMPLETE.** Total quantity received (RM transaction has been performed).

**SCRAP.** Total quantity scrapped.

**STANDARD HOURS.**

**SETUP LABOR.** The labor hours required to setup one unit of the item for production.

**RUN LABOR.** The labor hours required to run one unit of the item in production.

**MACHINE.** The actual machine hours total to date.

**TOTAL.** Sum of standard hours.

**PER PIECE.** The actual machine hours per piece.

**TOTAL OPERATION HOURS.** Column totals for standard hours.

**OPERATION HOURS PER UNIT.** Column totals for standard hours per unit.

## Location Audit (AMQ2L)

NORTHCREEK IND		LOCATION AUDIT		DATE 08/29/		
**	TIME 14:44:25	PAGE 1	AMQ2L			
WH	SCHED ITEM	COMPONENT	LINE	LOCATION	SCHEDULE	ERRORS
1	MDL100S		MDL1S	MDL1W		W AM-
9139	DELIVERY LOCATION IS A LINE LOCATION					
1	CLRT177	BL3HPCK	PLCL1			E AM-9095 WAREHOUSE LOCATION NOT FOUND
1	MDL100S		MDL1S		S000105	E AM-
9098	MOMAST FINISHED ITEM LOCATION NOT FOUND					
1	MDL100S	DL4QHT2	RDS1Q		S000105	E AM-
9426	LOCATION COMPONENT RECORD IS MISSING					

The Location Audit report provides a comprehensive validation of the location fields used in the REP application. The location data in the following files is validated: Item/Line, Component/Line, Component/Location, Item Balance (scheduled items), Manufacturing Order Master, and Manufacturing Detail (schedule orders). Run this report periodically to verify the integrity of these files.

This report is printed when you select option 10, Location Audit, on the Reports menu (AMQM20).

### Fields

**WH.** The warehouse from which components are issued or the finished items received (manufactured).

**SCHED ITEM.** The number of the finished item to be produced for this schedule.

**COMPONENT.** The number assigned to the material used in the production of the scheduled item.

**LINE.** The production line on which the scheduled item is produced.

**STOCK LOCN .** For Item Balance validation, the default supply location for the item; for Manufacturing Order Master File validation, the finished item stock location.

**LINE LOCN .** For Item/Line, Component/Location, and Component/Line validation, the default line location; for Manufacturing Order Data File validation, the line location.

**SCHEDULE.** The number assigned to this production schedule.

**ERRORS.** Error messages for the referenced item.

---

## Location Detail (AMIXK)

---

GATEWAY MFG CO	LOCATION DETAIL	DATE 8/10/
** TIME 16.00.16	PAGE 1 AMIXK	
	LOCATION DETAIL FILE	LOCATION QUANTITY FILE
		TRANSACTION HISTORY FILE
SESSION STATUS		
RECORDS ADDED	3	0
RECORDS CHANGED	2	0
RECORDS DELETED	3	0

\*\*\* END OF PRINT \*\*\*

---

To print this report, use option 3 on the Location Control menu (AMIM79).

### Fields

**RECORDS ADDED.** The number of records added to each file during the session.

**RECORDS CHANGED.** The number of records changed in each file during the session.

**RECORDS DELETED.** The number of records deleted from each file during the session.

## Location/Component Maintenance Edit List (AMQCLC)

```

NORTHCREEK IND          LOCATION/COMPONENT MAINTENANCE EDIT LIST      DATE **/**/
** TIME 11.26.39  PAGE   1  AMQCLC
                                     OPER
WAREHOUSE                ATL  ATLANTA WAREHOUSE
LINE LOCATION            FLNA10
COMPONENT ITEM           BLVYNSTR306      30' X 6' BLUE VINYL STRIPS
*** ADD ***

                                NEW VALUE
QUANTITY PER CONTAINER          .000
VALIDATION REQUIRED              0
REPLENISHMENT QUANTITY          .000
TRIGGER QUANTITY                .000
MINIMUM QUANTITY                .000
MAXIMUM QUANTITY                .000
AUTO REPLENISHMENT FLAG        0
REPLENISHMENT BASIS            0
USE EXCESS FROM MINIMUMS FLAG  0
OVERRIDE SUPPLY LOCATION
DATE LAST MAINTAINED          **/07/14
MAINTAINED BY                 QUAMMEN
-----
TOTAL ADDS                     1
TOTAL CHANGES                 0
TOTAL DELETES                  0
    
```

### Fields

**Warehouse.** Code defined by your company that identifies the warehouse in which this item is currently stocked.

**Location.** Identifier of the location at the production line where component items are to be delivered by the replenishment system.

**Component item.** Item number of the component.

**Quantity per container.** The quantity of an item stored in a full standard container.

**Validation required.** One of the following codes:

- 0** No, validation of the standard replenishment quantities and replenishment parameters is not required.
- 1** Yes, validation of the standard replenishment quantities and replenishment parameters is required.

If this flag is on, the standard replenishment quantities and replenishment parameters contained in this record should be visually inspected and approved. This validation is required because this record may have been created with default values during Item/Line and Component/Line file maintenance. Use option 2=Change on the Work With Location Component Definitions panel to set the quantities and parameters as you want them. You can set the validation flag off at the same time. Use option 7=Validate on the Work With Location Component Definitions panel to turn off the flag if the default values are acceptable to you.

The validation required flag is for your use only. The setting of the flag does not influence the use of this record. This record is considered active in all repetitive processes, regardless of the setting of the flag. It allows schedules to be released even if the flag is on.

**Replenishment quantity.** The standard container multiple assigned to the replenishment requests generated for this component item at this line location. This quantity is used for all replenishments except the last replenishment for a schedule (which is controlled by the value entered in the Run-out code field).

Replenishment needs less than this quantity are rounded up to this value.

Replenishment needs greater than this quantity are rounded up to the next multiple of this quantity.

For example, if this value is set at quantity=2, and the quantity needed for a schedule is calculated to be 7, the replenishment quantity calculated will be 8, assuming the Run-out code is not set to limit the issue of the component to only the amount needed.

**Replenishment trigger.** The amount of a component item that must be consumed before an automatic replenishment will be generated for this component item at this line location. This quantity is only effective when Auto Replenish is set to 1=Yes.

**Replenishment minimum.** The minimum amount of a component item that will be ordered by a replenishment that is generated for this component at this line location.

**Replenishment maximum.** The quantity of an item stored in a full standard container.

**Auto replenish.** This code determines whether replenishments will be generated automatically when a pick list is run.

- 0 Replenishment records will not be generated automatically for this component item at this location.
- 1 Replenishment records will be generated automatically for this component item at this location.

**Replenishment basis.** This code determines whether the replenishment requirements for this location/component are grouped across all schedules, or whether the replenishment requirements are maintained by specific schedules. Inventory will be allocated to a schedule or to a location based on this code:

- 0 Schedule based replenishment. Replenishment records for this component item will maintain their unique identity to a specific schedule.
- 1 Location based replenishment. Replenishment records will be accumulated and summarized across all schedules for this component item at this line location for a specific required date.

**Use excess from minimums.** This code determines whether excess allocated inventory can be allocated to other schedules. Excess material occurs because of minimum and multiple constraints that are applied to replenishment requests, or when material is issued in containers that hold more than what is needed at a line location. This excess material can be allocated, even before it is transferred, when the replenishments for the next schedule are calculated, if you use code 1.

- 0** The material that is in excess of the quantity required at a line location is not used by the replenishment system until the quantity is received at the line by a (CL) transaction. This is the default.
- 1** The material that is in excess of the quantity required at a line location can be allocated when the replenishment requests for the next schedule are calculated.

**Override supply location.** If specified, this location will be replenished from the default location of supply for this component item at this line location.

**Date last maintained.** Date someone last maintained this record.

**Maintained by.** User ID of the person who last maintained this record.

## Maintain Customer Manufacturing Dates Audit (AMQ42)

```

NORTHCREEK IND          MAINTAIN CUSTOMER MANUFACTURING DATES AUDIT      DATE 8/28/
**  TIME 13:49:30  PAGE      1  AMQ42

WH  ORDER          REL NO  ITEM          MFG DATE          REQUEST          S-NUMBER          ERRORS
1   01-Q01234567   10015  MPLSBB        BEFORE  AFTER  DATE          S-NUMBER          W AM-
9109 ITEM DATE EXCEEDS HEADER DATE      8/28/**  8/30/**  8/28/**
                                           01020304050607080901

TOTAL RECORDS CHANGED      1
    
```

This report shows the manufacturing due dates and delivery dates assigned to line items and blanket release line items on a customer order.

This report is printed when you select option 2, Maintain Customer Manufacturing Dates, on the Schedule Management menu (AMQM40).

### Fields

**WH.** The warehouse from which components are issued or the finished items received (manufactured).

**ORDER.** Control number assigned to the order.

**BLK REL.** Blanket release number from a customer order.

**ITEM.** The number of the item on the customer order.

**MFG DATE.** The manufacturing due date.

**REQUEST DATE.** The delivery date requested by the customer.

**S-NUMBER.** The features and options code for the item. This field only appears if you chose feature/options support during PDM/EPDM tailoring.

**ERRORS.** Error messages for the item.

**TOTAL RECORDS CHANGED.** The total number of records changed during this session.

## Pick List (AMQ3T1 and AMQ3T2)

NORTHCREEK IND		DATE	8/29/**	PICK LIST	106	PAGE	1	AMQ3T1
		TIME	8:50:57	BY	SUPPLY LOCATION			
P	REF COMPONENT	SEQ	UM	WH	SPL LOC	----- QUANTITY -----	CNTR	
R	SCH NBR					TO PICK CNTRS	PIECES	DESC
					LINE LOC BATCH/LOT	FIFO	TURNAROUND	
	SCH DATE	SCH ITEM			PRD LIN			
	1	SSINDGLU	PT 1	A1B121		2.5000	2.500	
		SUPER STRENGTH INDUSTRIAL GLUE					0569044	
	S000000	9/19/**	MPLBLK		LIN01			[barcode is printed here]
	2	METEDPNL71	EA 1	A1B211		20.000	2	0.000
		METAL 7' X 1" END PANEL		FLNE10			8/29/**	200517123
	S000000	9/19/**	MPLSBB		LIN01			[barcode is printed here]
XA					PICK LIST	45		DATE 7/26/
**	TIME 13:58:04	PAGE	1	AMQ3T2				
					BY LINE LOCATION			
	REF COMPONENT	SEQ	UM	WH	SPL LOC	----- QUANTITY -----	CNTR	LINE
	SCH NBR	SCH DATE	SCH ITEM		PRD LIN	TO PICK CNTRS	PIECES	DESC
LOT	FIFO	TURNAROUND						BATCH/
		FRTPLT		01	ATL	.000	.000	XML1WC
	800011017							
		FRONT PORCH LIGHT						
	S000167	7/13/**	MH2BR1B		PLML1			
W AM-9246		INVENTORY NOT AVAILABLE			1.000			
		RECITLT		01	ATL	.000	.000	XML1WC
	800011025							
		RECESSED INDIRECT TRACK LIGHT						
	S000167	7/13/**	MH2BR1B		PLML1			
W AM-9246		INVENTORY NOT AVAILABLE			1.000			
		STDOVDLT		01	ATL	.000	.000	XML1WC
	800011033							
		STANDARD OVERHEAD LIGHT						
	S000167	7/13/**	MH2BR1B		PLML1			
W AM-9246		INVENTORY NOT AVAILABLE			1.000			
		FLLDPNDR		01	ATL	.000	.000	XML1WD
	800011041							
		FOLDING PINE DOOR						
	S000167	7/13/**	MH2BR1B		PLML1			
W AM-9246		INVENTORY NOT AVAILABLE			6.000			
		HLED RP73		01	ATL	.000	.000	XML1WD
	800011058							
		7' X 3' HOLLOW PINE DOORS						
	S000167	7/13/**	MH2BR1B		PLML1			
W AM-9246		INVENTORY NOT AVAILABLE			12.000			
		METDR73		01	ATL	.000	.000	XML1WD
	800011066							
		7' X 3' METAL DOOR						
	S000167	7/13/**	MH2BR1B		PLML1			
W AM-9246		INVENTORY NOT AVAILABLE			3.000			
		TRMDPSLG		01	ATL	.000	.000	XML1WD
	800011074							
		10' X 7' THERMAL SLIDING DOOR						
	S000167	7/13/**	MH2BR1B		PLML1			
W AM-9246		INVENTORY NOT AVAILABLE			12.000			
		PCTWND		01	ATL	.000	.000	XML1WE
	800011082							
		PICTURE WINDOW 4' X 5'						
	S000167	7/13/**	MH2BR1B		PLML1			
W AM-9246		INVENTORY NOT AVAILABLE			1.000			
		STDWND34		01	ATL	.000	.000	XML1WE
	800011090							
		STANDARD WINDOW 3' X 4'						
	S000167	7/13/**	MH2BR1B		PLML1			
W AM-9246		INVENTORY NOT AVAILABLE			1.000			
		HGHFWRHTEX		01	ATL	.000	.000	XML1W5
	800011108							
		HIGH POWER HEAT EXCHANGER						
	S000167	7/13/**	MH2BR1B		PLML1			
W AM-9246		INVENTORY NOT AVAILABLE			1.000			



The Pick List shows the components to be picked and placed at particular production line locations. The report can be printed on either 14-7/8 x 11 or 8-1/2 x 11 paper, depending on which format was selected.

The report prints with the supply location listed first if you selected the Pick List in that sequence. If you selected Delivery Location sequence, the Delivery Location appears first, then the Supply Location. If you selected both Delivery and Supply Location sequence, the Pick List will print out one copy of each.

When you have location based schedules, the following fields are not printed: **SEQ**, **UM**, **SCH NBR**, **SCH DATE**, **SCH ITEM**, and **PRD LINE**.

This report is printed when you select option 3, Print Pick List, on the Material Management menu (AMQM30).

## Fields

**PR.** The priority code for components:

**Y** Specifies those components immediately needed at its line location.

**N** Indicates those components that can be sent to the line location within the normal replenishment cycle.

**REF.** A sequential number assigned by the system that identifies a specific line number on a pick list.

**COMPONENT.** The component (with description) that is to be picked and issued to the production line.

**SEQ.** The user-defined sequence number used to uniquely identify the component and show its position in the bill of material.

**UM.** The unit of measure of the component to be issued.

**WH.** The warehouse from which the components are to be issued or the finished items received (manufactured).

**SPL LOC.** The location that supplies materials to line delivery locations.

### **QUANTITY.**

**TO PICK.** The quantity of the component to be picked and issued from the supply location.

**CNTRS.** The quantity to be picked, expressed in containers.

**PIECES.** The quantity to be picked, expressed in pieces.

**CNTR DESC.** The user-defined description of the container.

**SCH NBR.** The number assigned to this production schedule.

**LINE LOC.** The location at the production line where the component is delivered.

**BATCH/LOT.** The batch/lot number assigned to an item lot. This field contains valid data only if you selected the Inventory Management install/tailor option to use batch/lot control.

**FIFO.** The date an item/lot was received into inventory. This field contains valid data only if you selected the Inventory Management install/tailor option to use FIFO date control.

**TURNAROUND.** The turnaround number of the component.

**SCH DATE.** The date when the item's schedule is due to be completed.

**SCH ITEM.** The item for which the production schedule is generated.

**PRD LIN.** The production line on which the scheduled item is manufactured.

## Prime Production Line Audit (AMQ3S)

NORTHCREEK IND		PRIME PRODUCTION LINE AUDIT				DATE 8/28/	
**	TIME 8:37:29	PAGE	1	AMQ3S			
-----DATE-----							
WH	LINE	SCHED ITEM				QUANTITY	
	START	SCHEDULE					
1	PLN1E	FEEDER LINE E -					
	DOORS	METDR73	7' X 3" METAL DOOR		5.000	8/30/**	8/31/**
		CF OPTION	1	REVISION	S000103	S-NUMBER	
		COMPONENT	SEQ		REQ DATE	QUANTITY REQ	
	*JIT	GLSPNU73	0245	10' X 7' PANEL	08/29/**	10.000	
	*JIT	DRHNDLAC	0250	BRASS DOOR HANDLE	08/29/**	5.000	
-----DATE-----							
WH	LINE	SCHED ITEM				QUANTITY	
	START	SCHEDULE					
1	PLA1K	DOOR KIT ASSEMBLY		DRKIT73	DOOR ASSEMBLY KIT -		
	DOOR 73	5.000	08/29/**	08/29/**			
		CF OPTION	1	REVISION	S000121	S-NUMBER	
		COMPONENT	SEQ		REQ DATE	QUANTITY REQ	
	*JIT	BRKTLFT	0200	LEFT DOOR BRACKET	08/29/**	5.000	
	*JIT	BRKRGT	0210	RIGHT DOOR BRACKET	08/29/**	5.000	
	*JIT	HDW73	0220	HARDWARE KIT - DOOR 73	08/29/**	1.000	

This report shows all schedules that have been selected for priming. The report shows only JIT components and lists the initial replenishment quantity.

This report is printed when you select option 1, Prime Production Lines, on the Material Management menu (AMQM30).

### Fields

**WH.** The warehouse from which components are issued or the finished items received (manufactured).

**LINE.** The production line (with description) on which the scheduled item is produced.

**SCHED ITEM.** The finished item (with description) to be produced for this schedule.

**QUANTITY.** The quantity of the item to be produced on this schedule.

**START DATE.** The date released schedules are to be started.

**SCHED DATE.** The date when the item's schedule is due to be completed.

**CF OPTION (Carry forward option).** The code that identifies whether this schedule uses carry forward processing:

- 1 Schedule is not part of a production campaign
- 2 Schedule is part of a production campaign
- 3 This is the last schedule in a production campaign

**REVISION.** This field appears only if EPDM is activated. The revision identifier associated with this item.

**SCHED NUMBER.** The number of the schedule associated with this item.

**S-NUMBER.** The features and option code for the item. This field only appears if you chose feature/options support during PDM/EPDM tailoring.

**COMPONENT.** The number assigned to the material used in the production of the scheduled item.

**SEQ.** The user-defined sequence number used to uniquely identify the component.

**DESCRIPTION.** The description of the component.

**REQ DATE.** The delivery date requested by the customer for the item.

**QUANTITY REQ.** The quantity of this item required by the schedule.

## Prime Production Line Audit (AMQ4N3)

NORTHCREEK IND PRIME PRODUCTION LINE AUDIT DATE 8/28/  
 \*\* TIME 8:37:29 PAGE 1 AMQ4N3

```

-----DATE-----
WH LINE                                SCHED ITEM                                QUANTITY
  START SCHEDULE
1  PLN1E FEEDER LINE E -
  DOORS                                METDR73      7' X 3" METAL DOOR                    5.000  8/30/**  8/31/**
                                CF OPTION      REVISION      SCHED NUMBER  S000114  S-NUMBER

                                COMPONENT      SEQ                                REQ DATE    QUANTITY REQ
                                *JIT          GLSPNU73      0245 10' X 7' PANEL                    08/29/**    10.000
                                *JIT          DRHNDLAC      0250 BRASS DOOR HANDLE                    08/29/**     5.000
  
```

```

-----DATE-----
WH LINE                                SCHED ITEM                                QUANTITY
  START SCHEDULE
1  PLA1K DOOR KIT ASSEMBLY
  DOOR 73                                5.000 08/29/** 08/29/** DRKIT73      DOOR ASSEMBLY KIT -
                                CF OPTION      REVISION      SCHEDULE NUMBER  S000132  S-NUMBER

                                COMPONENT      SEQ                                REQ DATE    QUANTITY REQ
                                *JIT          BRKTLFT      0200 LEFT DOOR BRACKET                    08/29/**     5.000
                                *JIT          BRKRGT      0210 RIGHT DOOR BRACKET                    08/29/**     5.000
                                *JIT          HDW73        0220 HARDWARE KIT - DOOR 73                08/29/**     1.000
  
```

This report shows all schedules that have been selected to be released and primed. The layout of this report is the same as the Prime Production Line Audit (AMQ3S) report. The field descriptions are the same as for that report.

This report is printed when you select option 2, Release and Prime, in the SEL field on the Release Schedules (Select) display (AMQ462).

## Product Structure Maintenance Edit List–Item/Line (AMQX1)

---

NORTHCREEK IND	PRODUCT STRUCTURE MAINTENANCE EDIT LIST	DATE	8/28/
** TIME 9:34:15 PAGE 1 AMQX1			
	ITEM/LINE	OPER 01	UPDATE# 72
SCHEDULED ITEM	LINE COMPONENT SEQ FE OP FEATURE ITEM		
*****ADDED*****			
MPLSBB MOLDED PLASTIC BEACH BALL	PLN1F SSINDGLU		
	SUPER STRENGTH INDUSTRIAL GLUE		
*****ADDED*****			
MPLSBB MOLDED PLASTIC BEACH BALL	PLN2F SSINDGLU		
	SUPER STRENGTH INDUSTRIAL GLUE		
NUMBER OF COMPONENT/LINE MASTER FILE RECORDS ADDED	2		
NUMBER OF COMPONENT/LINE MASTER FILE RECORDS DELETED			
NUMBER OF ITEM/LINE MASTER FILE RECORDS DELETED			

---

### Fields

**SCHEDULED ITEM.** The scheduled item and description from PDM/EPDM .

**LINE.** The production line from PDM/EPDM .

**COMPONENT.** The component number and description used in the production of the scheduled item.

**SEQ.** The user-defined sequence number that shows the position of the component in the bill of material.

**FE.** The user-defined number to identify features.

**OP.** The option number for the feature.

**FEATURE ITEM.** The feature item number from the product structure record.

**Description of the record action.** Indicates if the action is added, changed or deleted.

**NUMBER OF COMPONENT/LINE MASTER FILE RECORDS ADDED.** The number of component/line master file records added during the product structure maintenance.

**NUMBER OF COMPONENT/LINE MASTER FILE RECORDS DELETED.** The number of component/line master file records deleted during the product structure maintenance.

**NUMBER OF ITEM/LINE MASTER FILE RECORDS DELETED.** The number of item/line master file records deleted during the product structure maintenance.

## Production Facility Maintenance (AMVT7)

NORTHCREEK IND.		PRODUCTION FACILITY MAINTENANCE				DATE **/**/	
**	TIME 9.15.15	PAGE 1	AMVT7				
UPDATE# 137							OPER 53
RECORD CHANGED	FACILITY ID	AA001	FACILITY TYPE	1	WORK CENTER		
	DESCRIPTION	SAWS/SHEARING					
OLD VALUE	DEPARTMENT	DP20	PN FAC ACTG CLS	AB1	QUEUE TIME-DAYS	1.50	
	FOREMAN	JLF	PRIME LOAD CODE	3	AVG QUEUE TIME	35.84	
	LOCATION	B8E34	TRACKING SIGNAL	1.60	QUEUE MAD	.88	
	STD EFFICIENCY	.88	AVG STD OUTPUT	94.52	MACH RESOURCE NO.		
	AVG EFFICIENCY	.85	AVG ACTL OUTPUT	111.20	LABOR RESOURCE NO.		
	EXTRACT MACH BRKS	0	REPORTING METHODS	0	CLOCKING WINDOW	1:45	
	MACHINE RATE	2.000	RUN LABOR RATE	5.500	SETUP LABOR RATE	7.350	OVERHEAD RATE/PERCENT
	STANDARD	2.000		5.200		7.035	300.000
							B
							B
	-----LENGTH-----		-----CAPACITY-----		CALENDAR ID	XA	
	DESIRED	MAXIMUM	DESIRED	MAXIMUM	POST TO OLDEST SCHED	0	
	SHIFT 1	7.5	9.0	3.0	4.0	POST TO FUTURE SCHED	0
	SHIFT 2	.0	.0	.0	.0	FACILITY STOCK LOC	AWL04
	SHIFT 3	.0	.0	.0	.0		
RECORD CHANGED	FACILITY ID	AA001	FACILITY TYPE	1	WORK CENTER		
	DESCRIPTION	SAWS/SHEARING					
NEW VALUE	DEPARTMENT	DP20	PN FAC ACTG CLS	ABB	QUEUE TIME-DAYS	1.50	
	FOREMAN	A3Y	PRIME LOAD CODE	3	AVG QUEUE TIME	34.84	
	LOCATION	B8E34	TRACKING SIGNAL	1.60	QUEUE MAD	.88	
	STD EFFICIENCY	.88	AVG STD OUTPUT	94.52	MACH RESOURCE NO.		
	AVG EFFICIENCY	.85	AVG ACTL OUTPUT	111.20	LABOR RESOURCE NO.		
	EXTRACT MACH BRKS	0	REPORTING METHODS	0	CLOCKING WINDOW	1:45	
	MACHINE RATE	2.000	RUN LABOR RATE	5.500	SETUP LABOR RATE	7.350	OVERHEAD RATE/PERCENT
	STANDARD	2.000		5.200		7.035	300.000
							B
							B
	-----LENGTH-----		-----CAPACITY-----		CALENDAR ID	XA	
	DESIRED	MAXIMUM	DESIRED	MAXIMUM	POST TO OLDEST SCHED	0	
	SHIFT 1	7.5	9.0	3.0	4.0	POST TO FUTURE SCHED	0
	SHIFT 2	.0	.0	.0	.0	FACILITY STOCK LOC	AWL03
	SHIFT 3	.0	.0	.0	.0		

NORTHCREEK IND. PRODUCTION FACILITY MAINTENANCE CONTROL SHEET DATE 8/31/\*\* TIME 9.15.15 PAGE 2 AMVT7  
 UPDATE# 10

----- TRANSACTION UPDATE STATISTICS -----

FACILITIES ADDED	FACILITIES CHANGED	FACILITIES DELETED
1	1	1

### Fields

**FACILITY ID.** A user-assigned ID representing the facility.

**DESCRIPTION.** A description of this facility.

**DEPARTMENT.** The alphanumeric department ID associated with this facility.

**FOREMAN.** The identifier for the foreman for this facility.

**LOCATION.** The identifier for the location of this facility.

**STD EFFICIENCY (Standard Efficiency).** A standard you enter and maintain using Production Facility maintenance. It should be compared, by user, to average efficiency. It should reflect the expected value of average standard output divided by average actual output.

**AVG EFFICIENCY (Average Efficiency).** The average efficiency is the average of the standard output divided by the actual output of a period (in hours) for quantity worked. You enter and maintain this field using Production Facility maintenance. If PC&C is installed and interfacing, this field is also maintained or calculated automatically.

**EXTRACT MACH BRKS (Extract Machine Breaks).** A code that tells the PM&C application whether or not to extract break time from machine hours:

- 1 Extract break time.
- 0 Do not extract break time

**REPORTING METHOD.** The method used at the facility for reporting job transactions. The values for the methods are:

- 0 ON/OF reporting. Both ON (On) and OF (Off) transactions are required for each job. Jobs completed without both transactions are flagged as errors.
- 1 Off-only reporting with full ON override. OF transactions are required for each job. ON transactions are optional. If a job starts with an ON transaction, all information is used from the ON transaction. If an ON transaction does not exist, start times for the job are calculated from previous OF and T/A transactions and all other information is used from the OF transaction.
- 2 Off-only reporting with ON facility ID override. OF transactions are required for each job. ON transactions are optional. If the job starts with an ON transaction, the only information used from the ON transaction is the facility ID. All other information is used from the OF transaction. Start times are always calculated from previous OF and T/A transactions (even if an ON transaction exists).

**CLOCKING WINDOW.** The clocking window time defined for facilities using off-only reporting to group jobs that run concurrently and apportion time among those jobs. It can be any value from 0:00 to 9:59 (one second less than ten minutes). A value of 0:00 indicates that jobs at this facility are treated as if they are done consecutively.

**FACILITY TYPE.** A code representing the type of production facility this is:

- blank Work center (job shop)
- 1 Production line
- 2 Work station.

**PN FAC ACTG CLS (Production Facility Accounting Class).** Class, defined by your company, to group or classify orders or items by production facility for accounting purposes.

**PRIME LOAD CODE.** The prime load code is used in calculating the length of operation time for the forward scheduling routine. It identifies the critical operation time factors necessary to schedule each operation's due date from its operation start date.

- 0 No hours accumulated



- 1 Run machine hours
- 2 Setup labor hours divided by setup crew size
- 3 (Setup labor hours divided by setup crew size) plus run machine hours
- 4 Run labor hours
- 5 (Setup labor hours divided by setup crew size) plus run labor hours.

**TRACKING SIGNAL.** The tracking signal is the sum of the deviations of the current queue from old average queue, calculated with each running of the PC&C Work Center Analysis report.

**AVERAGE STD OUTPUT.** The average standard output is the average of the standard time (hours) produced per period at a facility. The standard hours are based on the operation quantity worked and the time basis code.

**AVERAGE ACTL OUTPUT.** The average actual output is the average of the actual time (hours) worked per period at a facility.

**Note:** A period is defined as the time between order close-out and purges, which is not the same as month end period in the Inventory Management application.

**PRODUCT LINE.** A description that corresponds with the facility type code.

**QUEUE TIME-DAYS.** The expected number of days a job waits in the queue before work on it begins.

**AVG QUEUE TIME.** The average queue time is the average of total of standard hours of work remaining in a facility for a period of time.

**QUEUE MAD.** The mean absolute deviation (MAD) is a smoothed average of the differences (made positive if they are negative) between the current queue within a facility and the old average queue of that facility.

**MACH RESOURCE NO..** This number, used by MPSP, identifies a machine in a facility as a critical resource. For example, a machine that affects major work flow in a facility.

**LABOR RESOURCE NO..** This number, used by MPSP, identifies the labor in a facility as a critical resource. For example, a facility with limited available labor hours because of workers with special skills.

**CURRENT MACHINE RATE.** This rate, in cost per hour, is used with the run machine field of the associated routing to calculate the current run machine cost. PDM product costing can optionally use this in determining labor overhead content this-level in the associated Item Master B-records.

Standard machine rate is also shown.

**CURRENT RUN LABOR RATE.** This rate from the Labor/Overhead Table, in cost per hour, is used with the run labor field of the associated routing to calculate the current run labor cost. PDM product costing can optionally use this in determining current labor and labor overhead content this-level in the associated Item Master B-records.

Standard run labor rate is also shown.

**CURRENT SETUP LABOR RATE.** This rate from the Labor/Overhead Table, in cost per hour, is used with the setup labor hours field of the associated routing to calculate the current setup labor cost. PDM product costing can optionally use this in

determining current labor and labor overhead content this-level in the associated Item Master B-records.

Standard setup labor rate is also shown.

**CURRENT LABOR OVERHEAD RATE/PERCENT.** The current labor overhead rate or percent from the Labor/Overhead Table used in the labor overhead calculation.

Standard labor overhead rate or percent is also shown.

**CURRENT LABOR OVERHEAD CODE.** This code indicates which of four methods (A, B, C, or D) is used to calculate current labor overhead this-level in the associated Item Master B-records. PDM product costing must be active and the cost technique code in associated Item Master B-records must be R if this code is used.

Standard labor overhead code is also shown.

**DESIRED SHIFT LENGTH.** The number of prime load code hours normally available for the duration of shifts 1, 2, or 3 for this facility.

**MAXIMUM SHIFT LENGTH.** The maximum number of prime load code hours available for the duration of shifts 1, 2, or 3 for this facility.

**DESIRED SHIFT CAPACITY.** The number of workers or machines normally available in this facility during shifts 1, 2, or 3.

**MAXIMUM SHIFT CAPACITY.** The maximum number of workers or machines available in this facility during shifts 1, 2, or 3.

**CALENDAR ID.** The identifier of the production calendar associated with this facility. This field is used by REP to explicitly define the days a production line is available for work.

**POST TO OLDEST SCHED.** The method used for applying transaction quantities in REP:

**blank** Defaults to the setting from the REPCTL record.

**0** Off, posting is by individual schedules for all items on this production line.

**1** On, multi-schedule posting, beginning with the oldest schedule, is used for all items on this production line.

**POST TO FUTURE SCHED.** The method used for applying transaction quantities in REP. The valid codes are:

**blank** Defaults to the setting from the REPCTL record.

**0** Off, post to past and current schedules on this production line.

**1** On, post to past, current, and future schedules on this production line.

***FACILITY STOCK LOC.*** If the facility is a workstation, this field represents the line location where items are delivered and used in a production line operation. If the facility is a production line, then this field represents the stocking location where finished goods are stored. This field is used by REP as a default line location when setting up the Item-Line definition for a schedule controlled item.

## Production Reporting List (AMQ4J)

NORTHCREEK IND    DATE 8/28/\*\*    PRODUCTION REPORTING LIST PAGE    1    AMQ4J  
 TIME 10:20:59

WH	LINE	ITEM	MODEL	100 SYSTEM	SCHEDULE
1	MDL1S	MDL100S			S000023
SCHED DATE	START DATE	SCHEDULE	QUANTITY	S-NUMBER	
8/31/**	8/30/**		17.000		
DEPT	PLANNER	RCV LOC		TURNAROUND	
REPI		A1B111		200512733	

[Barcode is printed here]

ACTIVE OPER	DEPT	ALT RTG CODE	TURNAROUND
Y 0010 PAINT CABINET	REPI		200513021

[Barcode is printed here]

Y 0020 INSTALL CHASSIS	REPI	200543711
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[Barcode is printed here]

Y 0030 MOUNT MOTOR	REPI	200532873
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[Barcode is printed here]

The Production Reporting List can be printed for all schedules not printed previously; within a range of start dates or due dates; or for a single schedule by production line, item number, warehouse, schedule date, or S-number; depending on the options chosen. The turnaround numbers for the schedule and its operations are printed in barcode as well as in numeric characters if you requested bar code and turnaround number support during installation.

This report is printed when you select option 7, Print Schedule Information, on the Schedule Management menu (AMQM40).

### Fields

**WH.** The warehouse from which the components are to be issued or the finished items received (manufactured).

**LINE.** The production line on which the scheduled item is to be manufactured.

**ITEM.** The item (with description) for which the production schedule is generated.

**SCHEDULE.** The number assigned to this production schedule.

**SCHED DATE.** The date when the item's schedule is due to be completed.

**START DATE.** The date when the schedule is to be started.

**SCHEDULE QUANTITY.** The quantity of the item released to production on this schedule.

**S-NUMBER.** The features and options code for the scheduled item. This field only appears if you selected the PDM/EPDM install/tailor option to use feature and option numbers.

**DEPT.** The user-defined department code.

**PLANNER.** The code of the person responsible for planning and scheduling this finished item.

**RCV LOC.** The location in the warehouse to which the finished item is to be delivered.

**TURNAROUND.** The turnaround number of the component (only appears if PM&C is present and interfacing).

**Bar code.** Bar code only appears if bar code support was requested and if the printer has IPDS capability.

**ACTIVE.** This code designates a component as being active or inactive.

**OPER.** The operation number and description for the scheduled item where the component is used.

**DEPT.** The user-defined department code.

**ALT RTG CODE.** This code indicates which additional operations are added to the routing.

## Production Schedules By Item (AMQ2N2)

NORTHCREEK IND		PRODUCTION SCHEDULES BY ITEM				DATE 8/28/	
** TIME	8:33:18	PAGE	1	AMQ2N2			
FOR WAREHOUSE 1							
FROM METDR73				TO LAST ITEM			
PRODUCTION DATES FROM FIRST				TO LAST			
ITEM METDR73	7' X 3' METAL DOOR	REVISION		SCHED GROUP		S-NUMBER	
PROD % LINE	SCHEDULE			LINE	SCHED	-- SCHEDULE TOTALS --	
DATE	LINE	WH		HOURS	HOURS	CNTRS	UNITS CAP N
UMBER	REFERENCE	STS					
8/30/**	PLN1E	FEEDER	LINE E -				
DOORS		1		8.0	.3		
						.000 3.8	S000012 FIRST9999 20
8/31/**	PLN1E	FEEDER	LINE E -				
DOORS		1		8.0	.3	1	
						5.000 3.8	S000013 20
8/31/**	PLN1E	FEEDER	LINE E -				
DOORS		1		8.0	.1		
						.000 1.3	S000015 00
8/31/**	PLN1E	FEEDER	LINE E -				
DOORS		1		8.0	.7	1	
						10.000 8.8	S000016 00
8/31/**	PLN1E	FEEDER	LINE E -				
DOORS		1		8.0	.1		
						.000 1.3	S000017 00
8/31/**	PLN1E	FEEDER	LINE E -				
DOORS		1		8.0	.3	1	
						5.000 3.8	S000018 00
				**TOTALS	1.8	3	20.000
ITEM TRMDPSLG	10' X 7' THERM SLG DR	REVISION		SCHED GROUP		S-NUMBER	
PROD % LINE	SCHEDULE			LINE	SCHED	-- SCHEDULE TOTALS --	
DATE	LINE	WH		HOURS	HOURS	CNTRS	UNITS CAP N
UMBER	REFERENCE	STS					
8/31/**	PLN1E	FEEDER	LINE E -				
DOORS		1		8.0	.4	1	
						5.000 5.0	S000019
9/01/**	PLN1E	FEEDER	LINE E -				
DOORS		1		8.0	.4	1	
						5.000 5.0	S000020
				**TOTALS	.8	2	10.000

The Production Schedules report provides information concerning items scheduled for production. It can be printed in four sequences: by production line (AMQ2N1), by item (AMQ2N2), by planner (AMQ2N3), by schedule group (AMQ2N4), and by schedule number (AMQ2N5).

This report is printed when you select option 4, Production Schedules, on the Reports menu (AMQM20), and select the appropriate options on the Production Schedules Report (Select) display (AMQ2D1). This report prints schedules by production line and production date for an item within a warehouse.

The report options as selected on display AMQ2D1 include warehouse; by line, by item, by planner, by schedule group, or by schedule number; and production date.

### Fields

**ITEM.** The item (with description) for which the production schedule is generated.

**REVISION.** This field appears only if EPDM is activated. The revision identifier associated with this item.

**SCHED GROUP.** The user-defined code that identifies items with similar manufacturing characteristics.

**S-NUMBER.** The features and options code for the finished item. This field only appears if you selected the PDM/EPDM install/tailor option to use feature and option numbers.

**PROD DATE.** The date when the schedule is to be completed.

**LINE.** The production line (with description) on which the scheduled item is to be manufactured.

**WH.** The warehouse from which the components are issued or the finished items received (manufactured).

**TOTAL LINE HRS.** The total hours available on the line for the day.

**SCHED HOURS.** The number of hours allocated to produce the item on this line.

**SCHEDULE TOTALS.**

**CNTRS.** The total scheduled quantity expressed in containers.

**UNITS.** The total scheduled quantity expressed in units.

**% LINE CAPACITY.** The percentage of the line capacity required to complete this schedule.

**SCHED NUMBER.** The number of the schedule associated with this item.

**REFERENCE.** The user-defined reference number of the schedule associated with this item.

**STS (STATUS).** The status of the schedule associated with this item.

**\*\*TOTAL.** The total number of scheduled hours, containers, and units scheduled for the item.

## Production Schedules By Line (AMQ2N1)

NORTHCREEK IND		PRODUCTION SCHEDULES BY LINE				DATE 8/28/	
** TIME 15:47:25 PAGE 1 AMQ2N1							
		FOR WAREHOUSE 1 FROM PLNE1 TO LAST					
		PRODUCTION DATES FROM FIRST		TO LAST			
LINE	PLN1E	FEEDER	LINE	E - DOORS	DEPARTMENT	REP3	LINE HOURS AVAILABLE 8.0
PROD DATE	8/30/**						
RUN		CARRY FWD		SCHED	SCHED NUMBER	REFERENCE STS	SCHED
SEQ ITEM						REVISION WH	GROUP ITEM RATE C CNTRS
NUMBER							UNITS QTY (UNITS) HOURS S-
1	METDR73		7' X 3'	METAL DOOR		1	15.0000 P 1 5.000 .000 .3
	S111111	FIRST9999	20				
2	TRMDPSLG		10' X 7'	THERMAL SLIDING DOOR		1	15.0000 P 1 5.000 .000 .4
	S111112						
LINE UTILIZATION %		10.00		**TOTALS		2	10.00 - .000 .7
PROD DATE 8/31/**							
RUN		CARRY FWD		SCHED	SCHED NUMBER	REFERENCE STS	SCHED
SEQ ITEM						REVISION WH	GROUP ITEM RATE C CNTRS
NUMBER							UNITS QTY (UNITS) HOURS S-
1	METDR73		7' X 3'	METAL DOOR		1	15.000 P 1 5.000 .000 .3
	S000039		20				
2	TRMDPSLG		10' X 7'	THERMAL SLIDING DOOR		1	15.000 P 1 5.000 .000 .4
	S000310		20				
LINE UTILIZATION %		10.00		**TOTALS		2	10.00 - .000- .7

This report prints the production date and schedule information on all scheduled items for all lines that are selected.

This report is printed when you select option 4, Production Schedules, on the Reports menu (AMQM20), and select the appropriate options on the Production Schedules Report (Select) display (AMQ2D1).

The report options as selected on display AMQ2D1 include warehouse; by line, by item, by planner, by schedule group, or by schedule number; and production date.

### Fields

**LINE.** The production line (with description) on which the scheduled item is to be manufactured.

**DEPARTMENT.** The user-defined department code.

**LINE HOURS AVAILABLE.** The number of capacity hours available for the line and day.

**PROD DATE.** The date when the schedule is to be completed.

**RUN SEQ.** The sequence in which the schedules are run on the production line.



**ITEM.** The item (with description) for which the production schedule is generated.

**REVISION.** This field appears only if EPDM is activated. The revision identifier associated with this item.

**WH.** The warehouse from which the components are issued or the finished items received (manufactured).

**SCHED GROUP.** The user-defined code that identifies items with similar manufacturing characteristics.

**ITEM RATE.** The rate at which items are produced on the production line. Stated in either pieces per hour or cycle time.

**PC.** The field indicates if the Item Rate field value is cycle time (C), or pieces per hour (P).

**SCHEDULE TOTALS.**

**CNTRS.** The total scheduled quantity expressed in containers.

**UNITS.** The total scheduled quantity expressed in units.

**CARRY FORWARD QTY (UNITS).** The number of units ahead of or behind the scheduled number of units.

**SCHED HOURS.** The number of hours allocated to produce the item on this line.

**SCHED NUMBER.** The number of the schedule associated with this item.

**REFERENCE.** The user-defined reference number of the schedule associated with this item.

**STS (STATUS).** The status of the schedule associated with this item.

**S-NUMBER.** The features and options code for the finished item. This field only appears if you selected the PDM/EPDM install/tailor option to use feature and option numbers.

**LINE UTILIZATION %.** The percentage of the line capacity utilized for that day.

**\*\*TOTALS.** The total number of scheduled containers, units, carry forward quantity, and schedule hours for the item.

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## Production Schedules By Planner (AMQ2N3)

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NORTHCREEK IND PRODUCTION SCHEDULES BY PLANNER DATE 8/28/  
 \*\* TIME 8:33:41 PAGE 1 AMQ2N3

FOR ALL WAREHOUSES  
 FROM 503 TO LAST  
 PRODUCTION DATES FROM FIRST TO LAST

PLANNER 00503

ITEM METDR73		7' X 3' METAL DOOR		REVISION	SCHED GROUP		S-NUMBER				
PROD	LINE	SCHEDULE	LINE	ST	WH	HOURS	SCHED	-- SCHEDULE TOTALS --			
DATE	LINE	LINE	LINE	STS	WH	HOURS	HOURS	CNTRS	UNITS	CAP	NUMBER
8/30/**	PLN1E	FEEDER	LINE E -								
DOORS	1	8.0	.3			.000	3.8	S000012	20		
8/31/**	PLN1E	FEEDER	LINE E -								
DOORS	1	8.0	.3	1		5.000	3.8	S000013	20		
8/31/**	PLN1E	FEEDER	LINE E -								
DOORS	1	8.0	.1			.000	1.3	S000015			
8/31/**	PLN1E	FEEDER	LINE E -								
DOORS	1	8.0	.7	1		10.000	8.8	S000016			
8/31/**	PLN1E	FEEDER	LINE E -								
DOORS	1	8.0	.1			.000	1.3	S000017			
8/31/**	PLN1E	FEEDER	LINE E -								
DOORS	1	8.0	.3	1		5.000	3.8	S000018			
** TOTALS						1.8	3	20.000			

PLANNER 00503

ITEM TRMDPDLG		10' X 7' THERM SL DR		REVISION	SCHED GROUP		S-NUMBER				
PROD	LINE	SCHEDULE	LINE	ST	WH	HOURS	SCHED	-- SCHEDULE TOTALS --			
DATE	LINE	LINE	LINE	STS	WH	HOURS	HOURS	CNTRS	UNITS	CAP	NUMBER
8/31/**	PLN1E	FEEDER	LINE E -								
DOORS	1	8.0	.4	1		5.000	5.0	S000019	20		
9/01/**	PLN1E	FEEDER	LINE E -								
DOORS	1	8.0	.4	1		5.000	5.0	S000020	20		
**TOTALS						.8	2	10.000			

This report prints schedules by production line and production date for an item within a planner and warehouse.

This report is printed when you select option 4, Production Schedules, on the Reports menu (AMQM20), and select the appropriate options on the Production Schedules Report (Select) display (AMQ2D1).

The report options as selected on display AMQ2D1 include warehouse; by line, by item, by planner, by schedule group, or by schedule number; and production date.

### Fields

**PLANNER.** The code of the person responsible for planning and scheduling this finished item.

**ITEM.** The item (with description) for which the production schedule is generated.

**REVISION (WREVS).** This field appears only if EPDM is activated. The revision identifier associated with this item.

**SCHED GROUP.** The user-defined code that identifies items with similar manufacturing characteristics.

**S-NUMBER.** The features and options code for the finished item. This field only appears if you selected the PDM/EPDM install/tailor option to use feature and option numbers.

**PROD DATE.** The date when the schedule is to be completed.

**LINE.** The production line (with description) on which the scheduled item is to be manufactured.

**WH.** The warehouse from which the components are issued or the finished items received (manufactured).

**TOTAL LINE HRS.** The total hours available on the line for the day.

**SCHED HOURS.**

The number of hours allocated to produce the item on this line.

**SCHEDULE TOTALS.**

**CNTRS.** The total scheduled quantity expressed in containers.

**UNITS.** The total scheduled quantity expressed in units.

**% LINE CAPACITY.** The percentage of the line capacity required to complete this schedule.

**SCHED NUMBER.** The number of the schedule associated with this item.

**REFERENCE.** The user-defined reference number of the schedule associated with this item.

**STS (STATUS).** The status of the schedule associated with this item.

**\*\*TOTALS.** The total number of scheduled hours, containers, and units scheduled for the item.

## Production Schedules By Schedule Group (AMQ2N4)

NORTHCREEK IND				PRODUCTION SCHEDULES BY SCHEDULE GROUP				DATE		8/31/	
** TIME 9:55:58 PAGE 1 AMQ2N4				FOR WAREHOUSE ATL FROM GRP01 TO GRP01 FOR ALL PRODUCTION DATES							
LINE FNLO0				TOTAL		SCHED		-- SCHEDULE TOTALS --			
ITEM	SCHEDULE	DESCRIPTION	REVISION	WH	LINE HRS	HOURS	CNTRS	UNITS	S-		
NUMBER	NUMBER	REFERENCE	STS								
**PROD DATE	8/04/**	SCHED GROUP	GRP01								
MXA103		MXA ASSEMBLY	103	ATL	8.0	34.0		.000			
S000214	FIRST9999	20									
TOTAL SCHED GROUP						34.0		.000			
TOTAL PROD DATE						34.0		.000			

NORTHCREEK IND				PRODUCTION SCHEDULES BY SCHEDULE GROUP				DATE		8/31/	
** TIME 9:55:58 PAGE 2 AMQ2N4				FOR WAREHOUSE ATL FROM GRP01 TO GRP01 FOR ALL PRODUCTION DATES							
LINE PLPL1				TOTAL		SCHED		-- SCHEDULE TOTALS --			
ITEM	SCHEDULE	DESCRIPTION	REVISION	WH	LINE HRS	HOURS	CNTRS	UNITS	S-		
NUMBER	NUMBER	REFERENCE	STS								
**PROD DATE	4/20/**	SCHED GROUP	GRP01								
PLSDKS		PLASTIC DUCKS		ATL	24.0	.3		197.000			
S000044		20									
PLSDKS		PLASTIC DUCKS		ATL	24.0	.8		197.000			
S000044		20									
TOTAL SCHED GROUP						1.1		394.000			
TOTAL PROD DATE						1.1		394.000			

This report prints production schedules by item within a schedule group and production date, for a specific production line and warehouse.

This report is printed when you select option 4, Production Schedules, on the Reports menu (AMQM20), and select the appropriate options on the Production Schedules Report (Select) display (AMQ2D1).

The report options as selected on display AMQ2D1 include warehouse; by line, by item, by schedule group, by planner, or by schedule number; and production date.

### Fields

**LINE.** The production line (with description) on which the scheduled item is to be manufactured.

**ITEM.** The item (with description) for which the production schedule is generated.

**REVISION (WREVSN).** This field appears only if EPDM is activated. The revision identifier associated with this item.

**WH.** The warehouse from which the components are issued or the finished items received (manufactured).

**TOTAL LINE HRS.** The total hours available on the line for the day.

**SCHED HOURS.** The number of hours allocated to produce the item on this line.

**SCHEDULE TOTALS.**

**CNTRS.** The total scheduled quantity expressed in containers.

**UNITS.** The total scheduled quantity expressed in units.

**SCHED NUMBER.** The number of the schedule associated with this item.

**REFERENCE.** The user-defined reference number of the schedule associated with this item.

**STS (STATUS).** The status of the schedule associated with this item.

**S-NUMBER.** The features and options code for the finished item. This field only appears if you selected the PDM/EPDM install/tailor option to use feature and option numbers.

**PROD DATE.** The date when the schedule is to be completed.

**SCHED GROUP.** The user-defined code that identifies items with similar manufacturing characteristics.

**TOTAL SCHED GROUP.** The total number of scheduled hours, containers, and units scheduled on a particular line on that production date.

**TOTAL PROD DATE.** The total number of scheduled hours, containers, and units scheduled on a particular line, on that production date for a schedule group.

## Production Schedules By Schedule Number (AMQ2N5)

NORTHCREEK IND		PRODUCTION SCHEDULES BY SCHEDULE NUMBER DATE 8/26/											
**	TIME 14:28:45	PAGE	1	AMQ2N5									
FOR WAREHOUSE ATL													
FROM S000001 TO S000999													
FOR ALL PRODUCTION DATES													
ITEM	PLSDKS	PLASTIC DUCKS	REVISION	SCHED GROUP	S-NUMBER	-- SCHEDULE TOTALS --							
PROD	% LINE	SCHEDULE	LINE	SCHED	---	---	---	---	---	---	---		
DATE	LINE	LINE	WH	HOURS	HOURS	CNTRS	UNITS	CAP	NUMBER				
REFERENCE	STS												
8/18/	**	PLPL1	MASTER TOY ASSEMBLY LINE	ATL	24.0	12.5	.000	52.1	S000002				
		20											
4/19/	**	PLPL1	MASTER TOY ASSEMBLY LINE	ATL	24.0	.3	83.333	1.3	S000043				
		20											
4/20/	**	PLPL1	MASTER TOY ASSEMBLY LINE	ATL	24.0	.3	197.000	1.3	S000044				
4/20/	**	PLPL1	MASTER TOY ASSEMBLY LINE	ATL	24.0	.8	197.000	3.3	S000044				
4/19/	**	PLPL1	MASTER TOY ASSEMBLY LINE	ATL	24.0	.0	.000	.0	S000143				
4/20/	**	PLPL1	MASTER TOY ASSEMBLY LINE	ATL	24.0	.4	100.000	1.7	S000143				
4/20/	**	PLPL1	MASTER TOY ASSEMBLY LINE	ATL	24.0	.4	100.000	1.7	S000144				
				**TOTALS		14.7		677.333					
ITEM	MH2BR1B	2 BEDROOM MOBILE HOME	REVISION	SCHED GROUP	S-NUMBER	-- SCHEDULE TOTALS --							
PROD	% LINE	SCHEDULE	LINE	SCHED	---	---	---	---	---	---	---		
DATE	LINE	LINE	WH	HOURS	HOURS	CNTRS	UNITS	CAP	NUMBER				
REFERENCE	STS												
7/13/	**	PLML1	MOBILE HOME MAIN LINE ONE	ATL	8.0	1.5	3.000	18.8	S000167	20			
7/14/	**	PLML1	MOBILE HOME MAIN LINE ONE	ATL	8.0	2.0	4.000	25.0	S000210				
				**TOTALS		3.5		7.000					

This report prints production schedules by item within a range of schedule numbers for a specific warehouse.

This report is printed when you select option 4, Production Schedules, on the Reports menu (AMQM20), and select the appropriate options on the Production Schedules Report (Select) display (AMQ2D1).

The report options as selected on display AMQ2D1 include warehouse; by line, by item, by schedule group, by planner, or by schedule number; and production date.

### Fields

**ITEM.** The item (with description) for which the production schedule is generated.

**REVISION (WREVSN).** This field appears only if EPDM is activated. The revision identifier associated with this item.

**SCHED GROUP.** The user-defined code that identifies items with similar manufacturing characteristics.

**S-NUMBER.** The features and options code for the finished item. This field appears only if you selected the PDM/EPDM install/tailor option to use feature and option numbers.

**PROD DATE.** The date when the schedule is to be completed.

**LINE.** The production line (with description) on which the scheduled item is to be manufactured.

**WH.** The warehouse from which the components are issued or the finished items received (manufactured).

**TOTAL LINE HRS.** The total hours available on the line for the day.

**SCHED HOURS.** The number of hours allocated to produce the item on this line.

**SCHEDULE TOTALS.**

**CNTRS.** The total scheduled quantity expressed in containers.

**UNITS.** The total scheduled quantity expressed in units.

**% LINE CAPACITY.** The percentage of the line capacity required to complete this schedule.

**SCHED NUMBER.** The number of the schedule associated with this item.

**REFERENCE.** The user-defined reference number of the schedule associated with this item.

**STS (STATUS).** The status of the schedule associated with this item.

## Purge Schedules Audit (AMQ4E1)

NORTHCREEK IND		PURGE SCHEDULES AUDIT				DATE 9/30/	
**	TIME 14:44:25	PAGE 1	AMQ4E1	PURGE DATE 9/30/**	WS ID 06	USER TERRY	
WH	ITEM	LINE	DEPARTMENT	PLANNER	CF OPTION	SCHEDULE NUMBER	S-NUMBER
SCHEDULE		SCHEDULE		QUANTITY		REFERENCE	
STATUS		DATE	SCHEDULED	COMPLETED	VARIANCE	REFERENCE	
1	CLRT177	PLCL1	REP2	502	1	S111113	090707101016
**	1.000	8/28/	.000	1.000		10	
1	MDL100S	MDL1S	REP1	101	2	S002345	
**	50.000	8/29/	.000	50.000		40	
1	CLRT177	PLCL1	REP2	502	1	S000222	030703121003
**	240.000	8/28/	.000	240.000		40	
1	CLRT177	PLCL1	REP2	502	1	S000033	070016070316
**	300.000	8/28/	.000	300.000		10	

This report shows the schedules that were deleted from the data base.

This report is printed when you select option 8, Purge Schedules, on the Schedule Management menu (AMQM40).

### Fields

**WH.** The warehouse from which components are issued or the finished items received (manufactured).

**ITEM.** The finished item to be purged.

**LINE.** The production line where the purged schedule is located.

**DEPARTMENT.** The department associated with the specific operation.

**PLANNER.** The code of the person responsible for planning and scheduling this finished item.

**CF OPTION (Carry forward option).** The code that identifies whether this schedule uses carry forward processing:

- 1 Schedule is not part of a production campaign
- 2 Schedule is part of a production campaign
- 3 This is the last schedule in a production campaign

**SCHEDULE NUMBER.** The number of the schedule associated with this item.

**S-NUMBER.** The features and option code for the item. This field only appears if you chose feature/options support during PDM/EPDM tailoring.



**SCHEDULE DATE.** The date when the item's schedule is due to be completed.

**SCHEDULED QUANTITY.** The quantity of the item released to production on this schedule.

**COMPLETED QUANTITY.** The completed quantity for this item and line for this date.

**VARIANCE QUANTITY.** The difference between quantity scheduled and quantity completed.

**REFERENCE.** The user-defined code used to provide additional information.

**SCHEDULE STATUS.** The reporting status of an open or order schedule:

<b>00</b>	Planned order/schedule not released
<b>10</b>	Schedule released
<b>40</b>	Activity reported or schedule started (labor and/or material)
<b>55</b>	Order/schedule complete - material and labor

## Purge Schedules Audit-Totals (AMQ4E2)

```

NORTHCREEK IND          PURGE SCHEDULES AUDIT          DATE  8/28/
**  TIME 14:44:45  PAGE  2  AMQ4E2          PURGE DATE  8/28/**          WS ID 06          USER TERRY

                                TOTALS

FILE NAME                RECORDS
                           DELETED
MOMAST  SCHEDULE MASTER          4
MODATA  SCHEDULE DETAIL         100
MOROUT  SCHEDULE OPERATIONS      47
MODESC  OPERATION DESCRIPTION     0

                                4 ITEMS WITH NO LAST TRANSACTION REPORTED
    
```

This report shows the number of records deleted, the file name from which the records were deleted, and the number of items purged with no last transaction reported.

This report is printed when you select option 8, Purge Schedules, on the Schedule Management menu (AMQM40).

### Fields

**FILE NAME.** The name of the file from which records are deleted.

**RECORDS DELETED.** The number of records deleted.

**ITEMS WITH NO LAST TRANSACTION REPORTED.** Items on schedules that were purged with no last transaction reported.

## Purge Schedules Audit—Schedules not purged due to Pending Pick List Allocations (AMQ4E4)

NORTHCREEK IND		PURGE SCHEDULES AUDIT				DATE 9/30/	
**	TIME 14:44:25	PAGE 1	AMQ4E4	PURGE DATE 9/30/**		WS ID 06	USER TERRY
SCHEDULES NOT PURGED DUE TO PENDING PICK LIST ALLOCATIONS							
WH	ITEM	LINE	DEPARTMENT	PLANNER	CF OPTION	SCHEDULE NUMBER	S-NUMBER
SCHEDULE		SCHEDULE	DATE	SCHEDULED	QUANTITY	COMPLETED	VARIANCE
STATUS							
1	CLRT177	PLCL1	REP2	502	1	S111113	090707101016
**	1.000	.000	8/28/	1.000		10	
1	MDL100S	MDL1S	REP1	101	2	S002345	
**	50.000	.000	8/29/	50.000		40	
1	CLRT177	PLCL1	REP2	502	1	S000222	030703121003
**	240.000	.000	8/28/	240.000		40	
1	CLRT177	PLCL1	REP2	502	1	S000033	070016070316
**	300.000	.000	8/28/	300.000		10	
NUMBER OF SCHEDULES NOT PURGED DUE TO UNAPPLIED IP TRANSACTIONS . . . :							330

This report shows the schedules that were not deleted from the data base due to pending pick list allocations.

This report is printed when you select option 8, Purge Schedules, on the Schedule Management menu (AMQM40).

The layout of this report is the same as Report AMQ4E1. The field descriptions are the same as those for Report AMQ4E1, with the addition of the following:

### Fields

**PENDING REPLENISHMENT RECORDS.** shows pending replenishment records that keep a schedule from being deleted. You can bring up the Pick List through Component Line transfer and cancel the replenishment record, transfer the full amount, or indicate Yes for final transfer.

## Purge Schedules Audit—Schedules not purged due to Pending Transactions (AMQ4E5)

NORTHCREEK IND		PURGE SCHEDULES AUDIT				DATE 9/30/	
**	TIME 14:44:25	PAGE 1	AMQ4E5	PURGE DATE 9/30/**	WS ID 06	USER TERRY	
SCHEDULES NOT PURGED DUE TO PENDING TRANSACTIONS							
WH	ITEM	LINE	DEPARTMENT	PLANNER	CF OPTION	SCHEDULE NUMBER	S-NUMBER
SCHEDULE		SCHEDULE	DATE	SCHEDULED	QUANTITY	VARIANCE	REFERENCE
STATUS							
1	CLRT177	PLCL1	REP2	502	1	S111113	090707101016
**	1.000	.000	8/28/	1.000	10		
1	MDL100S	MDL1S	REP1	101	2	S002345	
**	50.000	.000	8/29/	50.000	40		
1	CLRT177	PLCL1	REP2	502	1	S000222	030703121003
**	240.000	.000	8/28/	240.000	40		
1	CLRT177	PLCL1	REP2	502	1	S000033	070016070316
**	300.000	.000	8/28/	300.000	10		
NUMBER OF SCHEDULES NOT PURGED DUE TO UNAPPLIED IP TRANSACTIONS . . . :							330

This report shows the schedules that were not deleted from the data base due to pending transactions.

This report is printed when you select option 8, Purge Schedules, on the Schedule Management menu (AMQM40).

The layout of this report is the same as Report AMQ4E1. The field descriptions are the same as those for Report AMQ4E1.

## Purge Schedules Audit—Schedules not purged due to Unapplied IP Transactions (AMQ4E3)

NORTHCREEK IND		PURGE SCHEDULES AUDIT				DATE 9/30/	
**	TIME 14:44:25	PAGE 1	AMQ4E3	PURGE DATE 9/30/**	WS ID 06	USER TERRY	
SCHEDULES NOT PURGED DUE TO UNAPPLIED IP TRANSACTIONS							
WH	ITEM	LINE	DEPARTMENT	PLANNER	CF OPTION	SCHEDULE NUMBER	S-NUMBER
SCHEDULE		SCHEDULE	DATE	SCHEDULED	QUANTITY	COMPLETED	VARIANCE
STATUS							
1	CLRT177	PLCL1	REP2	502	1	S111113	090707101016
**	1.000	.000	8/28/	1.000		10	
1	MDL100S	MDL1S	REP1	101	2	S002345	
**	50.000	.000	8/29/	50.000		40	
1	CLRT177	PLCL1	REP2	502	1	S000222	030703121003
**	240.000	.000	8/28/	240.000		40	
1	CLRT177	PLCL1	REP2	502	2	S000033	070016070316
**	300.000	.000	8/28/	300.000		10	
NUMBER OF SCHEDULES NOT PURGED DUE TO UNAPPLIED IP TRANSACTIONS . . .							330

This report shows the schedules that were not deleted from the data base due to unapplied transactions. If errors appear, run the Released Schedules Errors Report from menu AMQM20, option 3, to determine the unapplied transactions that apply to the above schedules.

This report is printed when you select option 8, Purge Schedules, on the Schedule Management menu (AMQM40).

See "Purge Schedules Audit (AMQ4E1)" for a description of the fields on this report.

## Recalculate Schedules Audit (AMQ4S1)

```

NORTHCREEK IND          RECALCULATE SCHEDULES AUDIT      DATE 8/29/** TIME 13:32:28 PAGE 1 AMQ4S1
                          WS ID 01          USER TERRY*

START  SCHED
DATE  DATE  SITE WH LINE ITEM          MESSAGES
8/28/** 8/29/** 1  PLN1E METDR73      7' X 3' METAL DOOR      E - AM-9029 ACTIVE SCHEDULE BYPASSED
                          SCHED NUMBER S000108 S-NUMBER
    
```

This report is used to list recalculated schedules. It prints messages for Active Schedules Bypassed or Start Date Prior To Current Date. The report lists only those transactions with errors. The report title varies depending on what you chose on the Select display.

This report is printed when you select option 10, Recalculate Schedules, on the Schedule Management menu (AMQM40) and complete the information needed on the Select display.

### Fields

**START DATE.** The schedule start date.

**SCHED DATE.** The date when the item's schedule is due to be completed.

**SITE.** The site associated with the warehouse. This field appears only if EPDM is activated.

**WH.** The warehouse from which components are issued or the finished items received (manufactured).

**LINE.** The production line on which the scheduled item is produced.

**ITEM.** The finished item (with description) to be produced for this schedule.

**MESSAGES.** Warning and error messages for the schedule that was recalculated.

**SCHEDULE NUMBER.** The number of the schedule associated with this item.

**S-NUMBER.** The features and option code for the item. This field only appears if you chose feature/options support during PDM/EPDM tailoring.

## Release Schedules Audit (AMQ4N1)

```

NORTHCREEK IND                RELEASE SCHEDULES AUDIT                DATE 08/28/
**  TIME 14:44:25  PAGE 1  AMQ4N1                WS ID 01                USER
TERRY
START   SCHED   SCHED NO/   ACCTNG CLASS/
DATE   DATE   WH   LINE USER SEQ ITEM/COMPONENT   ERRORS
08/29/** 08/29/** 1   PLINE S14187 METDR73   7' X 3' DOOR   MEL
                S-NUMBER
                0245  GLSPNU73   10' X 7' PANEL
                0250  DRUNDLAC   BRASS DOOR HANDLE
9018 SCHED NUMBER FORMAT NOT VALID                E AM-
    
```

This report is printed when you select option 6, Release Schedules, on the Schedule Management menu (AMQM40).

### Fields

**START DATE.** The beginning date of the schedule when components are available at the line.

**SCHED DATE.** The date when the item's schedule is due to be completed.

**WH.** The warehouse from which components are issued or the finished items received (manufactured).

**LINE.** The production line on which the scheduled item is produced.

**SCHED NO.** The number assigned to this production schedule.

**USER SEQ.** The user-defined sequence number used to uniquely identify the component.

**ITEM/COMPONENT.** The finished item to be produced for this schedule.

**ACCTNG CLASS.** Class, defined by your company, to group or classify orders for accounting purposes.

**ERRORS.** Error messages for the item.

**ITEM DESCRIPTION.** The description of the item.

**S-NUMBER.** The features and option code for the item. This field only appears if you chose feature/options support during PDM/EPDM tailoring.

**COMPONENT NUMBER AND DESCRIPTION.** The component number and description assigned to the material used in the production of the scheduled item.

## Release Schedules Audit-Totals (AMQ4N2)

```

NORTHCREEK IND          RELEASE SCHEDULES AUDIT          DATE 8/29/
** TIME 13:47:55  PAGE 1 AMQ4N2                                WS ID 06          USER T
ERRY
NUMBER OF SCHEDULES RELEASED          2
NUMBER OF SCHEDULES IN ERROR          0

FILE NAME          RECORDS CREATED  RECORDS UPDATED
MOMAST SCHEDULE MASTER          70          2
MODATA SCHEDULE DETAIL          22
MOROUT SCHEDULE OPERATIONS          9
MODESC OPERATION DESCRIPTION
    
```

This report shows the total number of schedules released, number of schedules in error, and number of records created or updated for the indicated master files.

This report is printed when you select option 6, Release Schedules, on the Schedule Management menu (AMQM40).

### Fields

**NUMBER OF SCHEDULES RELEASED.** Total number of schedules released.

**NUMBER OF SCHEDULES IN ERROR.** The number of schedules containing errors.

**FILE NAME.** The name of master files containing created or updated records.

**RECORDS CREATED.** The number of records created in the indicated files.

**RECORDS UPDATED.** The number of records updated in the indicated files.



## Release Schedules-Item Shortage (AMQ4Q)

NORTHCREEK IND  
 \*\* TIME 13:47:55 PAGE 1 AMQ4Q  
 RELEASE SCHEDULES DATE 8/29/  
 ITEM SHORTAGE WS ID WAR591821 USER  
 TERRY

WH	COMPONENT	SEQ	TYPE	PLANNER	ONHAND	ALLO
1	BLUPNT	BLUE PAINT	4	501	5,000.000	8,29

ORDER/	LINE	ITEM	DESC/	REQ DATE	DUE DATE	REQUIRED QTY	RECEIPTS	REMAINING	S-NUMBER
VENDOR									
SCHED									
01-CO1000002				99230156		0030000	00001	4/12/**	4/12/
**	999.000				4,001.000				
S000060	PLPL1	MPLSBB	MOLDED					4/26/**	4/26/
**	1,000.000				3,001.000				
S000061	PLPL1	MPLSBB	MOLDED					4/28/**	4/27/
**	2,500.000				501.000				
S000062	PLPL1	MPLSBB	MOLDED					4/29/**	4/28/
**	4,500.000				3,999.000-				
S000064	PLPL1	MPLSBB	MOLDED					4/30/**	4/30/
**	50.000				4,049.000- SHORT*				
S000063	PLPL1	MPLSBB	MOLDED					4/30/**	4/29/
**	150.000				4,199.000- SHORT*				
S000065	PLPL1	MPLSBB	MOLDED					5/03/**	5/03/
**	5.000				4,204.000- SHORT*				

WH	COMPONENT	SEQ	TYPE	PLANNER	ONHAND	ALLO
1	PLSPEL	PLASTIC PELLETS	4	501	24,000.000	16,59

ORDER/	LINE	ITEM	DESC/	REQ DATE	DUE DATE	REQUIRED QTY	RECEIPTS	REMAINING	S-NUMBER
VENDOR									
SCHED									
P000082				92301				5/16/**	5/16/**
**	35.000				34,000.000				10,000.000
01-CO1000002				99230156		0020000	00001	4/12/**	4/12/
**	1,000.000				0010000			4/16/**	4/16/
01-CO1000005				44590623		0010000	00001	4/19/**	4/19/
**	500.000				33,965.000				
01-CO1000005				44590623		0010000	00003	4/20/**	4/20/
**	2,500.000				32,465.000				
01-CO1000005				44590623		0010000	00002	4/21/**	4/21/
**	1,000.000				29,965.000				
S000061	PLPL1	MPLSBB	MOLDED					4/26/**	4/26/**
**	9,000.000				28,965.000			2,000.000	
S000062	PLPL1	MPLSBB	MOLDED					4/27/**	4/27/
**	5,000.000				21,965.000				
S000063	PLPL1	MPLSBB	MOLDED					4/29/**	4/29/
**	100.000				12,965.000				
S000064	PLPL1	MPLSBB	MOLDED					4/30/**	4/30/
**	10.000				12,565.000				
S000065	PLPL1	MPLSBB	MOLDED					5/03/**	5/03/
**	10.000				12,555.000				

NUMBER OF ITEMS - 2 ITEMS WITH SHORTAGES - 1

The Release Schedules Item Shortage report includes a listing of all component items required for released schedules. This report is printed when you select option 6, Release Schedules, on the Schedule Management menu (AMQM40). This report prints in a tailored fashion, depending on the first position of the order number (ORDNO), or if the Item Number (ITNBR) is blank, as follows:

<b>blank</b>	The order is a requirement from the Schedule Demand Interface file (SCHDMD). *** DEMAND *** prints to the right of the Order Number in the ITEM/SALESREP column.
<b>S or M</b>	The order is a receipt. *** RECEIPT *** prints to the right of the Order Number in the ITEM and SALESREP column, showing that the merchandise or stock is received in inventory (same as IM).
<b>C</b>	The order is a customer order. Salesrep Number (SLSNO) prints in the ITEM and SALESREP column and Customer Number (CUSTNO) prints in the DESC/VENDOR and CUSTOMER column.
<b>P</b>	The order is a purchase order. Vendor Number (VNDNR) prints in the DESC/VENDOR and CUSTOMER column.

If the Item Number (ITNBR) is not blank and the first position of the Order Number is not C, the Item Number (ITNBR) prints in the ITEM and SALESREP column and Item Description (FITDS) prints in DESC/VENDOR and CUSTOMER column.

If the ITNBR is not blank but the Order Number and Line is blank, then the item shortage is from the Requirements file (REQMTS) unless otherwise noted.

## Fields

**WH (Warehouse).** The warehouse from which the components are issued or the finished items received (manufactured).

**COMPONENT.** The material used in the production of the scheduled item.

**SEQ.** The user-defined sequence number used to uniquely identify the component.

**Description.** The description of the component item.

**TYPE.** Code that best describes the type of item:

<b>0</b>	Phantom
<b>1</b>	Assembly or subassembly
<b>2</b>	Fabricated item
<b>3</b>	Raw material
<b>4</b>	Purchased item
<b>9</b>	User option
<b>F</b>	Feature
<b>K</b>	Kit

**PLANNER.** The code of the person responsible for planning and scheduling the item that has shortages.

**ON HAND.** The total quantity of the component that is available.

**ALLOCATED.** The number of parts reserved for a schedule for a specific location.

**ON ORDER.** The quantity of the component that is on order.

**ORDER/SCHED.** The control number assigned to each schedule in the data base by the system.

**LINE.** The production line where the released schedule is to be produced.

**ITEM.** Number of the item, which can be any raw material, manufactured or purchased part, subassembly, assembly, or end item.

**SALESREP.** Code defined by your company to identify the sales representative assigned to the customer account.

**DESC/VENDOR.** The schedule item description or vendor number.

**CUSTOMER.** Unique number that identifies a customer.

**RELEASE.** Sequential number assigned by the system to identify individual releases.

**REQ DATE.** The date the component is required for the actual or forecast demand.

**DUE DATE.** The date the item's schedule is due to be completed.

**REQUIRED QTY.** The quantity of the component needed to produce the scheduled quantity of the finished item.

**RECEIPTS.** The actual scheduled and planned receipt quantity.

**REMAINING.** The quantity of the component that is available through the required date (quantity on hand plus quantity on order minus quantity allocated minus quantity required).

**S-NUMBER.** The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**MESSAGE.** A note to indicate a shortage for the component on the schedule (SHORT), or that the component/line location is the same as the supply location (JIT).

**NUMBER OF ITEMS.** The number of item checked for shortages.

**ITEMS WITH SHORTAGES.** The number of items that have shortages.

---

## Release Schedules—Schedules Shortage (AMQ4W)

NORTHCREEK IND				RELEASE SCHEDULES	DATE	8/29/
**	TIME 13:47:55	PAGE	1 AMQ4W	SCHEDULE SHORTAGE	WS ID	06 USE
R TERRY						
-----						
WH	ITEM	PLANNER	LINE	START DATE	SCHED DATE	SCHEDULE QTY S-
1	MDL100S MODEL 100 SYSTEM	MDL1S		8/28/**	8/29/**	960.000
SCHEDULE NUMBER S000194						
COMPONENT	SEQ		TYPE	REQ DATE	REQUIRED QTY	SHORT QTY
MJIT103		POWER STROBE	4	8/28/		
**	960.000	1,920.000		SHORT*		
MJIT106		WING NUTS	4	8/28/		
**	3,840.000	7,680.000		SHORT*		
MJIT211		MOUNTING SCREWS	4	8/28/		
**	11,520.000	13,040.000		SHORT*		
MJIT604		FUSE HOLDER BASE	4	8/28/		
**	960.000	1,920.000		SHORT*		
MJIT610		MOTOR	4	8/28/		
**	960.000	1,920.000		SHORT*		
MJIT614		DISK DRIVE	4	8/28/		
**	960.000	1,920.000		SHORT*		
						ON THIS SCHEDULE
.000 CAN BE MADE						
-----						
WH	ITEM	PLANNER	LINE	START DATE	SCHED DATE	SCHEDULE QTY S-
1	MDL100S MODEL 100 SYSTEM	MDL1S		8/28/**	8/29/**	960.000
SCHEDULE NUMBER S000195						
COMPONENT	SEQ		TYPE	REQ DATE	REQUIRED QTY	SHORT QTY
MJIT212		FINISHING WASHERS	4	8/28/		
**	11,520.000	23,040.000		SHORT*		
MJIT409		BLACK SWITCH	4	8/28/		
**	960.000	1,920.000		SHORT*		
MJIT602		TRANSFORMER ASSEMBLY	4	8/28/		
**	960.000	1,920.000		SHORT*		
MJIT604		FUSE HOLDER CAP	4	8/28/		
**	960.000	1,920.000		SHORT*		
MJIT612		UPPER POWER DRIVE	4	8/28/		
**	960.000	1,920.000		SHORT*		
MJIT614		LOWER POWER DRIVE	4	8/28/		
**	960.000	1,920.000		SHORT*		
						ON THIS SCHEDULE
.000 CAN BE MADE						
-----						
WH	ITEM	PLANNER	LINE	START DATE	SCHED DATE	SCHEDULE QTY S-
1	MDL100S MODEL 100 SYSTEM	MDL1S		8/28/**	8/29/**	960.000
SCHEDULE NUMBER S000196						
COMPONENT	SEQ		TYPE	REQ DATE	REQUIRED QTY	SHORT QTY
MJIT401		RED LIGHT	4	8/28/		
**	960.000	1,920.000		SHORT*		
MJIT402		YELLOW LIGHT	4	8/28/		
**	960.000	1,920.000		SHORT*		
MJIT403		GREEN LIGHT	4	8/28/		
**	960.000	1,920.000		SHORT*		
MJIT406		RED LIGHT SWITCH	4	8/28/		
**	960.000	1,920.000		SHORT*		
MJIT603		CAPACITOR WITH SCREWS	4	8/28/		
**	960.000	1,920.000		SHORT*		
MJIT606		FUSE HOLDER NUT	4	8/28/		
**	960.000	1,920.000		SHORT*		
						ON THIS SCHEDULE
.000 CAN BE MADE						
-----						
NUMBER OF SCHEDULES CHECKED - 3 SCHEDULES SHORT - 3						

The Release Schedules-Schedule Shortage report is used to list schedules from the Allocation Work File that is generated from AMQ4N. The report includes a listing of all

schedules that were released in this schedule release run. It lists the items which are short for each schedule and how many can be made from this schedule.

This report is printed when you select option 6, Release Schedules, on the Schedule Management menu (AMQM40).

## Fields

**WH (Warehouse).** The warehouse from which the components are issued or the finished items received (manufactured).

**ITEM.** The item on the released schedule that has components which are short.

**Description.** The description of the scheduled item.

**PLANNER.** The code of the person responsible for planning and scheduling the item that has shortages.

**LINE.** The production line where the released schedule is to be produced.

**START DATE.** The scheduled start date of a manufacturing order or operation.

**SCHED DATE.** The date the item's schedule is due to be completed.

**SCHEDULE QTY.** The quantity of the scheduled item.

**S-NUMBER.** The features and options code for the item. S-number appears if you chose feature/options support during PDM/EPDM tailoring.

**SCHEDULE NUMBER.** The number assigned to this production schedule.

**COMPONENT.** The material used in the production of the scheduled item.

**SEQ.** The user-defined sequence number used to uniquely identify the component.

**Description.** The description of the component item.

**TYPE.** Code that best describes the type of item:

0	Phantom
1	Assembly or subassembly
2	Fabricated item
3	Raw material
4	Purchased item
9	User option
F	Feature
K	Kit

**REQ DATE.** The date the component is required for the actual or forecast demand.

**REQUIRED QTY.** The quantity of the component needed to produce the scheduled quantity of the finished item.

**SHORT QTY.** The quantity that is short for this component.

**Message.** A note to indicate a shortage for the component on the schedule (SHORT), or that the component/line location is the same as the supply location (JIT).

**ON THIS SCHEDULE.** The actual quantity of the scheduled item that can be made.

**NUMBER OF SCHEDULES CHECKED.** The number of schedules checked for shortages.

**SCHEDULES SHORT.** The number of schedules that have shortages.

## Released Schedules (AMQ2M1, AMQ2M2, AMQ2M3, and AMQ2M4)

NORTHCREEK IND		RELEASED SCHEDULES BY LINE				DATE	*****	TIME	*****						
PAGE	1	AMQ2M1					OPER								
		FOR WAREHOUSE DT1													
		FROM LINEA TO LINEA													
		SCHED DATES FROM 00/00/00 TO 99/99/99													
LINE	LINEA	PRODUCTION	LINE	FOR	WHS	DT1	SCHEDULE	NBR	S000052	CARRY FORWARD	OPTION	2	SCHED	ACCO	
UNTING	CLASS														
ITEM	A1	MODEL	100	SYSTEM	WAREHOUSE	DT1	ENG	DRAW					S-		
PLANNER		CUST	JOB	NBR	REFERENCE	NBR	DEPT	SCHED	DATE	**/**/					
**	RUN	SEQUENCE	0									SCHED	RESC		
DEMAND	M	REQMT													
HED	CODE	0													
		CUMULATIVE	YIELD	100.0											
		QUANTITY													
-	DATE														
START	SCHEDULED	2.000	UNIT	.0000	SETUP	.00	SCHEDULED								
RT	SCRAPPED	.000	SCRAP	.00	LABOR	.00	ACTUAL	STA							
	RECEIVED	.000	RECEIPT	.00	OVERHEAD	.00									
			RCPT	PTD	ISSUE	.00									
ACTIVE	Y	OPERATION	0010	CUT	WORK	CENTER	AWK	C1	WORK	CENTER	1	FOR	LINE	A /	
WHS	DT1	DEPT													
		STANDARD													
		MISCELLANEOUS													
P	CREW	SIZE	1	HOURS	RATE	TIME	BASIS	PRIME	LOAD	4	SETU				
ESS	SETUP	LABOR	1.00	1.000	UNITS	COMPLETED	.000	OVERHEAD	COST	D	REWORK	FLAG	0	PROC	
	RUN	LABOR	4.00	1.000	UNITS	SCRAPPED	.000					TOOL			
	RUN	MACHINE	4.00	1.000	CURRENT	YIELD	100.0					PFAC			
		OUTSIDE													
AC	COMPONENT	SEQ	DATE	DATE	LAST	QUANTITY									
ISSUED	LINE	LOC	REQUIRED	FLR	ISSUED	SCHED	SCRAP	COMP	SCRAP	UM	UNIT	COST	REQUIRED		
Y	A1B	0010	6.000	.000	.000	.000	.000	.000	EA	.0000	**/**/				
**	**/**/**	L11													
		AVERAGE	ACTUAL	MATERIAL	COST	PER	UNIT					.0000			
		AVERAGE	STANDARD	LABOR,	MACHINE,	AND	OVERHEAD	COST	PER	UNIT					.0000
		TOTAL	COST	PER	UNIT	FOR	THIS	OPERATION					.0000		
		TOTAL	CUMULATIVE	COST	PER	UNIT	INCLUDING	THIS	OPERATION					.0000	

The Released Schedules reports (AMQ2M1, AMQ2M2, AMQ2M3, and AMQ2M4) list information concerning released schedules and provide a “snapshot” of each schedule at a single point in time.

This program is run on demand to review schedule status and should be run periodically to verify the integrity of the REP transaction entries.

The layout of the reports is the same, but they are provided in different sequences:

- The Released Schedules by Line report (AMQ2M1) is sequenced by production line, due date, run sequence, schedule group, item number, S-number, warehouse, and schedule number.
- The Released Schedules by Item report (AMQ2M2) is sequenced by item number, S-number, due date, warehouse, line, run sequence, schedule group, and schedule number.



- The Released Schedules by Planner report (AMQ2M3) is sequenced by planner, item number, S-number, due date, warehouse, line, run sequence, schedule group, and schedule number.
- The Released Schedules by Schedule report (AMQ2M4) is sequenced by schedule number.

These reports are printed when you select option 3, Released Schedules, on the Reports menu (AMQM20).

The report options as selected on display AMQ2C1 include warehouse; by line, by item, by planner, or with errors only; and schedule date.

## Fields

**LINE.** The production line (with description) on which the scheduled item is to be manufactured.

**ITEM.** The item (with description) for which the production schedule is generated.

**PLANNER.** The code of the person responsible for planning and scheduling this finished item.

**SCHEDULE NBR.** The number assigned to this production schedule.

**WAREHOUSE.** The warehouse from which the components are issued or the finished items received (manufactured).

**CF OPTION (Carry forward option).** The code that identifies whether this schedule uses carry forward processing:

- 1 Schedule is not part of a production campaign
- 2 Schedule is part of a production campaign
- 3 This is the last schedule in a production campaign

**ENG DRAW.** The unique engineering drawing number assigned to an end product or item.

**S-NUMBER.** The features and options code for the finished item. This field only appears if you selected the PDM install/tailor option to use feature and option numbers.

**CUST JOB NBR.** The customer job number that is associated with the schedule.

**REFERENCE NBR.** The user-defined code used to provide additional information.

**DEPT.** The user-defined department code.

**SCHED DATE.** The date when the item's schedule is due to be completed.

**RUN SEQUENCE.** The sequence in which the schedules are run on the production line.

**SCHED RESCHED CODE.** Code used to indicate whether or not an individual manufacturing order or purchase order line item can be rescheduled automatically by the system.

- 0** Default to item reschedule code. This is the default.
- 1** Cannot be rescheduled automatically
- 2** Can be scheduled out
- 3** Can be scheduled in
- 4** Can be scheduled both out and in

**DEMAND.** The customer order or other top level requirement that generated this manufacturing order or purchase order item. Possible values are listed below. MSSR refers to the Master Schedule Source Planning code.

<b>BLENDED</b>	The larger of forecast and customer requirements (MSSR=B)
<b>CUSONLY</b>	Customer orders (MSSR=C)
<b>Cxxxxxx</b>	Customer orders, not combined (MSSR=D or E). The customer order shows in the format of 01-CO-nnnnnnnn.
<b>FORCAST</b>	Forecast quantity (MSSR=F)
<b>GENDMND</b>	Generated component quantity based on parent planned orders (MSSR not D or E)
<b>Mxxxxxx</b>	Manufacturing order number
<b>MANUAL</b>	Manually entered demand. Source of demand is optional at time of entry (MSSR=M)
<b>M FCST</b>	Manual forecast
<b>M HELD</b>	Manual held requirement
<b>M REQMT</b>	Manual requirement
<b>SAFETY</b>	Safety stock
<b>NEG QOH</b>	Negative quantity on hand
<b>P FCST</b>	Propagated forecast
<b>P REQMT</b>	Propagated requirement
<b>PRODPLN</b>	Production planned quantity (MSSR=P)
<b>Sxxxxxx</b>	Repetitive Manufacturing order, allocated quantity
<b>Xxxxxxx</b>	InterSite transfer order
<b>XS FCST</b>	Forecast quantity in excess of customer requirements (MSSR=D)

**CUMULATIVE YIELD.** The cumulative yield for this schedule expressed as a percentage.

**QUANTITY.**

**SCHEDULED.** The quantity of the item released to production on this schedule.

**SCRAPPED.** The quantity of the scheduled item to be scrapped.

**RECEIVED.** The quantity of the scheduled item received from the production line.

**COST.**

**UNIT.** The cost of each unit of the scheduled item.

**SCRAP.** The cost of units scrapped charged to the scheduled item.

**RECEIPT.** The cost of units received to date from production.

**RCPT PTD.** The cost of units received this period from production.

**SETUP.** The actual setup labor cost for the operation.

**LABOR.** The actual run labor cost for the operation.

**OVERHEAD.** The actual overhead cost for the operation.

**ISSUE.** The actual cost of the components issued to a schedule.

**DATE.**

**SCHEDULED START.** The date a schedule is to be started in production.

**ACTUAL START.** The actual date that a schedule is started in production.

**ACTIVE.** This code designates an operation as being active or inactive.

**OPERATION.** The operation number and description for the scheduled item where the component is used.

**WORK CENTER.** The grouping of workers or machines (with description) used to perform the operation.

**DEPT.** The user-defined department code.

**Description of operation.** Additional description detail for the operation.

**Standard.**

**SETUP LABOR HOURS.** The standard setup labor hours per unit for an operation.

**SETUP LABOR RATE.** The standard setup labor rate in dollars per hour.

**RUN LABOR HOURS.** The standard run labor hours per unit for an operation times the scheduled quantity.

**RUN LABOR RATE.** The standard run labor rate in dollars per hour.

**RUN MACHINE HOURS.** The standard run machine hours per unit for an operation times the scheduled quantity.

**RUN MACHINE RATE.** The standard run machine rate in dollars per hour.

**OUTSIDE COST.** The cost per piece charged by the vendor to produce the item. This field is used when the time basis code is C.

**UNITS COMPLETED.** The number of units completed for this operation.

**UNITS SCRAPPED.** The number of units scrapped for this operation.

**CURRENT YIELD.** Completed units for this operation expressed as a percentage.

**CODE.**

**TIME BASIS.** This code indicates the relationship between standard operation run unit time and expected operation quantities. The code is used to determine standard operation run labor hours, and run machine hours.

<b>blank</b>	Hours per unit
<b>C</b>	Cost per piece (outside operations)
<b>H</b>	Hours per lot size
<b>P</b>	Pieces per hour
<b>M</b>	Minutes per piece
<b>1</b>	Hours per 10 units
<b>2</b>	Hours per 100 units
<b>3</b>	Hours per 1000 units
<b>4</b>	Hours per 10000 units

**OVERHEAD COST.** This code indicates how the overhead for this production facility is calculated.

**CODE.**

**PRIME LOAD.** The code used in the operation duration calculation for forward scheduling.

<b>0</b>	No hours accumulated
<b>1</b>	Run machine hours
<b>2</b>	Setup labor hours divided by setup crew size
<b>3</b>	(Setup labor hours divided by setup crew size) plus run machine hours
<b>4</b>	Run labor hours
<b>5</b>	(Setup labor hours divided by setup crew size) plus run labor hours

**REWORK FLAG.** The code that identifies a rework operation:

<b>Y</b>	Rework operation
<b>N</b>	Not a rework operation

**MISCELLANEOUS.**

**SETUP CREW SIZE.** The value used to calculate a setup machine hours value using a setup labor value.

**PROCESS SHEET.** The process sheet number used to identify the detailed instruction for the operation.

**PF AC CL.** Class, defined by your company, to group or classify orders or items by production facility for accounting purposes.

**TOOL.** The number assigned to a specific tool or list of tools needed to perform the operation.

**AC.** This code designates a component as being active or inactive.

**COMPONENT.** The component used in the production of the scheduled item.

**SEQ.** The user-defined sequence number that shows the position of the component in the bill of material.

**REQUIRED QUANTITY.** The total quantity of the component required for the operation.

**ISSUED QUANTITY.** The total quantity of the component issued to date for the operation.

**SCHEM SCRAP QUANTITY.** The quantity of the scheduled item scrapped.

**COMP SCRAP QUANTITY.** The quantity of the component scrapped.

**UM.** The component unit of measure.

**UNIT COST.** The cost of each unit of the component.

**DATE REQUIRED.** The date when the component is required at the production line.

**DATE LAST ISSUED.** The date when the component was last issued to the production line.

**LINE LOC.** The location at the production line where the component is delivered.

**FLR STK.** This code indicates if an item is classified as floor stock:

<b>blank</b>	Not floor stock
<b>C</b>	Controlled floor stock item
<b>U</b>	Uncontrolled floor stock item

**AVERAGE ACTUAL MATERIAL COST PER UNIT.** This is a calculated field.

**AVERAGE STANDARD LABOR, MACHINE, AND OVERHEAD COST PER UNIT.**

This is a calculated field.

**TOTAL COST PER UNIT FOR THIS OPERATION.** This is a calculated field.

**TOTAL CUMULATIVE COST PER UNIT INCLUDING THIS OPERATION.** This is a calculated field.

## Released Schedules Errors (AMQ2M5)

NORTHCREEK IND		RELEASED SCHEDULES ERRORS				DATE	*****	TIME	*****		
* PAGE 1 AMQ2M5		PENDING BACKFLUSH TRANSACTIONS FOR WAREHOUSE DT1				OPER					
LINE	PLN1A	SHIFT	TRAN TYPE		RM	PRODUCTION RECEIPT	--				
TRANSACTION QTY--											
ITEM	BACCFEX	BLUE ALUM CAPE CODE EXTERIOR		TRAN DATE	*****	REF	CN				
TRS	PIECES										
WAREHOUSE	1	SCHEDULE	S000044	SCHED DATE	*****	TRAN BATCH	97	SEQ	2		
0	1.000										
BATCH/LOT	S-NUMBER		TRAN REASON								
OPER COMPONENT		--LOCATION--	ACTION		ST	PICK LIST	TOTAL ON HAND	-----QUANTITY-----			
ATCH/LOT	FIFO	SUPPLY LINE						BACKFLUSH	CNTRS	PIECES	B
	BLKVRSHG	FLNA50	ISSUE			12,751.000		30		.000	
	*****										
ATCH001	*****	A3B311	FLNA50	REPLENISH	30	4		8		80.000	B

The Released Schedules Errors report is an exception report that identifies Production Receipts (RM), Schedule Scrap (SM), and Operation Reporting (RO) transactions that generated unapplied Planned Issues (IP) transactions in error which are still uncorrected. It provides information to resolve these remaining problems. Data on relevant unapplied component replenishment and backflush activity for each originating transaction is included. All transactions with unapplied activity are listed.

This report is printed whenever any Released Schedules report (AMQ2M1, AMQ2M2, AMQ2M3, or AMQ2M4) is requested. It is also be produced when you select option 3, Released Schedules, on the Reports menu (AMQM20) and type 4 in REPORT OPTION.

### Fields

**LINE.** The production line on which the scheduled item is to be manufactured.

**ITEM.** The item for which the production schedule is generated.

**WAREHOUSE.** The warehouse from which the components are issued or the finished items received (manufactured).

**BATCH/LOT.** The batch/lot number assigned to an item lot. This field only appears if you selected the PDM/EPDM install/tailor option to use batch/lot numbers.

**SHIFT.** The production period when the transaction occurred.

**DESCRIPTION.** The description of the item.

**SCHEDULE.** The number assigned to this production schedule.

**SCHED DATE.** The date when the item's schedule is due to be completed.

**S-NUMBER.** The features and options code for the scheduled item. This field only appears if you selected the PDM/EPDM install/tailor option to use feature and option numbers.

**TRANSACTION.**

**TRAN TYPE.** The code (with description) of the pending backflush transactions.

<b>RM</b>	Schedule Receipts
<b>RO</b>	Operation Reporting
<b>SM</b>	Schedule Scrap
<b>IP</b>	OffLine Issue

**TRAN DATE.** The date the transaction occurred.

**TRAN BATCH.** The number of the batch where the transaction is entered.

**TRAN REASON.** The user-defined transaction reason code.

**TRANSACTION QTY.**

**CNTRS.** The transaction quantity expressed in containers.

**PIECES.** The transaction quantity expressed in pieces.

**REF.** The user-defined code used to provide additional information.

**SEQ.** The sequence number of the transaction.

**OPER.** The user-defined sequence number that shows the position of the component in the bill of material.

**COMPONENT.** The component used in the production of the scheduled item.

**LOCATION.**

**SUPPLY.** The location that supplies materials to line delivery locations.

**LINE.** The location at the production line where the component is delivered.

**ACTION.** Transaction action code:

**Issue** Transaction reflects issue of components to the line to the stock area.

**Replenishment** Transaction involved replenishment of components.

**Backflush** Transaction reflects completion of operation step or scrap activity with corresponding reduction of stock for component parts.

**ST.** The status of a replenishment operation.

**PICK LIST.** The identification number assigned to each pick list.

**TOTAL ONHAND.** The total onhand quantity of the component.



**QUANTITY.**

**BACKFLUSH.** The quantity to be backflushed when schedule receipts or scrap is reported.

**CNTRS.** The replenishment quantity expressed in containers.

**PIECES.** The replenishment quantity expressed in pieces.

**BATCH/LOT.** The batch/lot number assigned to an item lot. This field contains valid data only if you selected the Inventory Management install/tailor option to use batch/lot control.

**FIFO.** The date an item/lot was received into inventory. This field only appears if you selected the Inventory Management install/tailor option to use FIFO date control.

## Released Schedule Maintenance Edit List (AMQ5B1)

```

NORTHCREEK IND          RELEASED SCHEDULE MAINTENANCE EDIT LIST          DATE 8/29/
** TIME 9:52:00 PAGE    1 AMQ5B1                                     OPER 01          UPDATE# 47

ITEM TRMDPSLG          10' X 7' THERMAL SLIDING DOOR REVISION          SCHEDULE DATE 8/31/** S-NUMBER
LINE PLN1E FEEDER LINE E -
DOORS                  SCHEDULE 5000211 SCHEDULE QTY          5.000 RESCHEDULE CODE 9

WAREHOUSE ATL          SCHEDULE GROUP 14257 STATUS 10 PCS/CYC P
ITEM RATE              15.000 ALTERNATE ROUTING CODE          RUN SEQUENCE 990

*****ADDED*****
CARRY FORWARD QUANTITY          125.000          PLANNER 10000
SETUP COST                      25.25 UNIT COST          10.0000 DEPARTMENT DR10
LABOR COST                      117.00 OVERHEAD COST          15.00 CUSTOMER JOB C14278
ISSUE COST                      50.00 SCRAP COST          2.50 REFERENCE NUMBER 14278-
2112
RECEIPT COST                  5.00 RECEIPT COST THIS PERIOD          125.00 ENGINEER DRAWING DOOR129
87-C

*****ADDED*****
COMPONENT          GLSPNL73          10' X 7' GLASS PANEL REVISION          USER SEQUENCE
OPER WHERE USED 0010          REQUIRED DATE          08/31/** UNIT COST .0000
STOCK LOCATION A1B311          LINE LOCATION          FLEN10
ADJ QTY PER          2.0000          FLOOR STOCK CODE          CUSTOMER JOB NUMBER
STD QTY PER          2.0000          BACKFLUSH CODE          2

*****ADDED*****
OPERATION 0015 PAINTING          ALTERNATE ROUTING CODE          AB
REPORTING POINT          Y          CURRENT OPERATION YIELD          9.999 REWORK FLAG          Y
TIME BASIS CODE          H          WORK CENTER          WC250 DEPARTMENT DR015
STANDARD SETUP LABOR HOURS          15.25          STANDARD SETUP LABOR RATE          6.275 PROCESS SHEET 19257
STANDARD RUN MACHINE HOURS          10.25          STANDARD MACHINE RATE          15.000 TOOL T13385
STANDARD RUN LABOR HOURS          12.50          STANDARD RUN LABOR RATE          99.999

*****ADDED*****
COMPONENT          DRHNDLAC          BRASS DOOR HANDLE REVISION          USER SEQUENCE 0250
QUANTITY ALLOCATED          5.000          BATCH/LOT G5RV          FIFO DATE 08/29/**

*****ADDED*****
OPERATION          0010 PAINTING
SEQUENCE NUMBER 2450 USE BEIGE ON UNIT/ALLOW OVERNITE DRYING
    
```

The Released Schedule Maintenance Edit List is used to list all changes that take place during Released Schedule Maintenance. When the maintenance session is ended the report is printed. Any adds, changes, or deletes to Manufacturing Order Master, Manufacturing Material Detail, Open Operation Additional Description, Manufacturing Order Operations, Replenishment, and Allocated Quantity are printed on the report.

This report is printed when you select option 2, Released Schedules, on the File Maintenance menu (AMQM50).

### Fields

**ITEM.** The item (with description) for which the production schedule is generated.

**REVISION.** This field appears only if EPDM is activated. The revision associated with this component item.

**WAREHOUSE.** The warehouse from which the components are issued or the finished items received (manufactured).

**SCHEDULE DATE.** The date when the item's schedule is due to be completed.

**SCHEDULE QTY.** The quantity of the item released to production on this schedule.

**S-NUMBER.** The features and options code for the scheduled item. This field only appears if you selected the PDM/EPDM install/tailor option to use feature and option numbers.

**RUN SEQUENCE.** The sequence in which the schedule is to be run on the production line.

**SCHEDULE GROUP.** The user-defined code that identifies items with similar manufacturing characteristics.

**STATUS.** The status of the production schedule.

**PCS/CYC.** The field indicates if the Item Rate field value is cycle time (C), or pieces per hour (P).

**ITEM RATE.** The number of units produced in one hour.

**ALTERNATE ROUTING CODE.** This code indicates which additional operations are added to the routing.

**Description of the record action.** Indicates if the action is added, changed, or deleted.

**CARRY FORWARD QUANTITY.** The number of units ahead of or behind the scheduled number of units.

**SETUP COST.** The actual setup labor cost for the operation.

**LABOR COST.** The actual run labor cost for the schedule.

**ISSUE COST.** The actual cost of the components issued to a schedule.

**RECEIPT COST.** The cost of completed units received to date from production.

**UNIT COST.** The cost of each unit of the scheduled item.

**OVERHEAD COST.** The actual overhead cost for the schedule.

**SCRAP COST.** The cost of each scrapped unit of the scheduled item.

**RECEIPT COST THIS PERIOD.** The cost of completed units received this period from production.

**PLANNER.** The code of the person responsible for planning and scheduling this finished item.

**DEPARTMENT.** The user-defined department code.

**CUSTOMER JOB.** The customer job number which is associated with the schedule.

**REFERENCE NUMBER.** The user-defined code used to provide additional information.

**ENGINEER DRAWING.** The unique engineering drawing number assigned to an end product or item.

**Description of the record action.** Indicates if the action is added, changed, or deleted.

**COMPONENT.** The component (with description) used in the production of the scheduled item.

**OPER WHERE USED.** The operation sequence number that identifies the operation where the component is used.

**STOCK LOCATION.** The default location where parts are taken from, to supply production line requirements.

**QUANTITY PER.** The quantity of a component required to produce a single unit.

**REQUIRED DATE.** The date when the component is required for the operation.

**LINE LOCATION.** The location at the production line where the component is delivered.

**FLOOR STOCK CODE.** This code indicates if an item is classified as floor stock:

<b>blank</b>	Not floor stock
<b>C</b>	Controlled floor stock item
<b>U</b>	Uncontrolled floor stock item

**USER SEQUENCE.** The user-defined sequence number used to uniquely identify the component.

**UNIT COST.** The cost of each unit of the scheduled item.

**MAXIMUM CONTAINERS.** The maximum number of containers that are planned to be stored at the line location.

**CUSTOMER JOB NUMBER.** The customer job number which is associated with the schedule.

**Description of the record action.** Indicates if the action is added, changed, or deleted.

**OPERATION.** The operation number and description for the scheduled item where the component is used.

**REPORTING POINT.** The code that identifies an operation where transactions can be reported:

<b>Y</b>	Reporting point
<b>N</b>	Not a reporting point

**TIME BASIS CODE.** This code indicates the relationship between standard operation run unit time and expected operation quantities. The code is used to determine standard operation run labor hours, and run machine hours.

**STANDARD SETUP LABOR HOURS.** The standard setup labor hours per unit for an operation.

**STANDARD RUN MACHINE HOURS.** The standard run machine hours per unit for an operation.

**STANDARD RUN LABOR HOURS.** The standard run labor hours per unit for an operation.

**ALTERNATE ROUTING CODE.** This code indicates which additional operations are added to the routing.

**CURRENT OPERATION YIELD.** The number of completed units for the operation.

**WORK CENTER.** The grouping of workers or machines used to perform the operation.

**STANDARD SETUP LABOR RATE.** The standard setup labor rate in dollars per hour.

**STANDARD MACHINE RATE.** The standard run machine rate in dollars per hour.

**STANDARD RUN LABOR RATE.** The standard run labor rate in dollars per hour.

**ACCOUNTING CLASS.** Class, defined by your company, to group or classify orders for accounting purposes.

**REWORK FLAG.** This code designates an operation as being active or inactive.

**DEPARTMENT.** The user-defined department code.

**PROCESS SHEET.** The process sheet number used to identify the detailed instruction for the operation.

**TOOL.** The number assigned to a specific tool or list of tools needed to perform the operation.

**Description of the record action.** Indicates if the action is added, changed, or deleted.

**COMPONENT.** The component used in the production of the scheduled item.

**QUANTITY ALLOCATED.** The number of components reserved for the schedule.

**BATCH/LOT.** The batch/lot number assigned to an item lot. This field contains valid data only if you selected the Inventory Management install/tailor option to use batch/lot control.

**USER SEQUENCE.** The user-defined sequence number used to uniquely identify the component.

**FIFO DATE.** The date an item/lot was received into inventory. This field only appears if you selected the Inventory Management install/tailor option to use FIFO dates.

**Description of the record action.** Indicates if the action is added, changed, or deleted.

**OPERATION.** The operation number and description for the scheduled item where the component is used.

**SEQUENCE NUMBER.** The user-defined sequence number that shows the position of the component in the bill of material.

## Released Schedule Maintenance Edit List-Totals (AMQ5B2)

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NORTHCREEK IND	RELEASED SCHEDULE MAINTENANCE EDIT LIST	DATE 08/29/
** TIME 14:44:25 PAGE 1 AMQ5B2		
	TOTALS	
ADDED COMPONENT RECORDS	9	
CHANGED COMPONENT RECORDS	14	
DELETED COMPONENT RECORDS	1	
ADDED OPERATION RECORDS	101	
CHANGED OPERATION RECORDS	34	
DELETED OPERATION RECORDS	0	
ADDED OPERATION DESCRIPTION RECORDS	3,456	
CHANGED OPERATION DESCRIPTION RECORDS	578	
DELETED OPERATION DESCRIPTION RECORDS	1,345	
ADDED DISCRETE ALLOCATION RECORDS	67	
CHANGED DISCRETE ALLOCATION RECORDS	202	
DELETED DISCRETE ALLOCATION RECORDS	231	
CHANGED SCHEDULE RECORDS	48	
ADDED COMPONENT STATUS RECORDS	7	
CHANGED COMPONENT STATUS RECORDS	2	
DELETED COMPONENT STATUS RECORDS	1	

---

This report shows the totals for any adds, changes, or deletions to component, operation, operation description, discrete allocation records, component status records, and changed schedule records in the Released Schedule file.

This report is printed when you select option 2, Released Schedules, on the File Maintenance menu (AMQM50).

### Fields

**ADDED COMPONENT RECORDS.** The number of component records added to MODATA during the release schedule maintenance session.

**CHANGED COMPONENT RECORDS.** The number of component records changed in MODATA during the release schedule maintenance session.

**DELETED COMPONENT RECORDS.** The number of component records deleted in MODATA during the release schedule maintenance session.

**ADDED OPERATION RECORDS.** The number of operation records added to MOROUT during the release schedule maintenance session.

**CHANGED OPERATION RECORDS.** The number of operation records changed in MOROUT during the release schedule maintenance session.

**DELETED OPERATION RECORDS.** The number of operation records deleted in MOROUT during the release schedule maintenance session.

**ADDED OPERATION DESCRIPTION RECORDS.** The number of operation description records added to MODESC during the release schedule maintenance session.

**CHANGED OPERATION DESCRIPTION RECORDS.** The number of operation description records changed in MODESC during the release schedule maintenance session.

**DELETED OPERATION DESCRIPTION RECORDS.** The number of operation description records deleted in MODESC during the release schedule maintenance session.

**ADDED DISCRETE ALLOCATION RECORDS.** The number of discrete allocation records added to SLALLO during the release schedule maintenance session.

**CHANGED DISCRETE ALLOCATION RECORDS.** The number of discrete allocation records changed to SLALLO during the release schedule maintenance session.

**DELETED DISCRETE ALLOCATION RECORDS.** The number of discrete allocation records deleted in SLALLO during the release schedule maintenance session.

**CHANGED SCHEDULE RECORDS.** The number of schedule records changed in MOMAST during the release schedule maintenance session.

**ADDED COMPONENT STATUS RECORDS.** The number of component status records added to CMPSTS during the release schedule maintenance session.

**CHANGED COMPONENT STATUS RECORDS.** The number of component status records changed in CMPSTS during the release schedule maintenance session.

**DELETED COMPONENT STATUS RECORDS.** The number of component status records deleted in CMPSTS during the release schedule maintenance session.



# Schedule Packet (AMQ4H1)

NORTHCREEK IND		SCHEDULE PACKET				DATE 8/28/				
**	TIME 10:20:32	PAGE	1	AMQ4H1						
SCHEDULE NUMBER	WH	ITEM	LINE	QUANTITY	START DATE	SCHED DATE	S-			
S000023	1	MDL100S	MODEL 100 SYSTEM	MDL1S	17.000	8/30/**	8/31/**			
RCV LOC	ENG DRAWING	REFERENCE	PLANNER	DEPT	ACTIVE OPER	ACTIVE MATL				
TURNAROUND NBR				REP1	11	35				
A1B111										
147289453										
-----										
ACTIVE	OPER	WORK CENTER	DEPT	ALT RTG	PROCESS SHEET	TOOL	SETUP TIME	RUN TIME	OPERATION YIELD	STATUS
Y	0010	PAINT CABINET	MDL01	REP1			.00	.00	100.00	10
295573236										
USE BEIGE ON CABINET/ALLOW OVERNITE DRYING										
LINE	A	FLR	DATE	-- REQUIRED QTY --						
LOC	C COMPONENT	SEQ	WH	REQUIRED	CNTRS	PIECES	UM	BATCH/		
LOT	FIFO	STK								
MDL1W1	Y MJIT103	POWER STROBE	1	8/30/**	1	7.000	EA		0/	
00/00										
MDL1W1	Y MJIT202	PAINT	1	8/30/**	1	.051	EA		0/	
00/00	U									
MDL1W1	Y MJIT103	WOOD INSERTS 6X2X1/2"	1	8/30/**	1	8.000	EA		0/	
00/00										
-----										
ACTIVE	OPER	WORK CENTER	DEPT	ALT RTG	PROCESS SHEET	TOOL	SETUP TIME	RUN TIME	OPERATION YIELD	STATUS
Y	0020	MOUNT MOTOR	MDL02	REP1			.00	.00	100.0	10
A										
LINE	A	FLR	DATE	-- REQUIRED QTY --						
LIN LOC	C COMPONENT	SEQ	WH	REQUIRED	CNTRS	PIECES	UM	BATCH/		
LOT	FIFO	STK								
MDL1W2	Y MJIT210	UPPER FRONT PANEL	1	8/30/**	1	7.000	EA		0/	
00/00										
MDL1W2	Y MJIT211	MOUNTING SCREWS	1	8/30/**	20	4.000	EA		0/	
00/00										
MDL1W2	Y MJIT212	FINISHING WASHERS	1	8/30/**	20	4.000	EA		0/	
00/00										

The Schedule Packet report can be printed for all schedules not printed previously; within a range of start dates or due dates; or for a single schedule by production line, item number, warehouse, schedule date, or S-number; depending on the option chosen. The information and sequence depend on the information you enter. If you answer **No** to Material Detail, no information pertaining to the components prints on this report. If you answer **Yes** to Material Detail, the components can be printed by order, operation, item, or user sequence. The operations are always printed in operation sequence.

This report is printed when you select option 7, Print Schedule Information, on the Schedule Management menu (AMQM40). In order to show complete component information, it is suggested that you run this report prior to any CL (transfer to the line) transaction being processed for the selected schedule.

## Fields

**SCHEDULE.** The number assigned to this production schedule.

**WH.** The warehouse from which the components are to be issued or the finished items received (manufactured).

**ITEM.** The item (with description) for which the production schedule is generated.

**LINE.** The production line on which the scheduled item is to be manufactured.

**QUANTITY.** The quantity of the item released to production on this schedule.

**START DATE.** The date when the schedule is to be started.

**SCHED DATE.** The date when the item's schedule is due to be completed.

**S-NUMBER.** The features and options code for the scheduled item. this field only appears if you selected the PDM/EPDM install/tailor option to use feature and option numbers.

**RCV LOC.** The location in the warehouse to which the finished item is to be delivered.

**ENG DRAWING.** The unique engineering drawing number assigned to an end product or item.

**REFERENCE.** The user-defined code used to provide additional information.

**PLANNER.** The code of the person responsible for planning and scheduling this finished item.

**DEPT.** The user-defined department code.

**ACTIVE OPER.** The number of the active operation.

**ACTIVE MATL.** The number of active material records. The number of material detail records in the schedule's detail chain.

**TURNAROUND NBR.** The turnaround number of the component.

**ACTIVE.** This code designates a component as being active or inactive.

**OPER.** The operation number and description for the scheduled item where the component is used. Additional operation descriptions appear below the operation.

**WORK CENTER.** The grouping of workers or machines used to perform the operation.

**DEPT.** The user-defined department code.

**ALT RTG.** This code indicates which additional operations are added to the routing.

**PROCESS SHEET.** The process sheet number used to identify the detailed instruction for the operation.

**TOOL.** The number assigned to a specific tool or list of tools needed to perform the operation.

**SETUP TIME.** The time required to prepare the production line to begin the schedule.

**RUN TIME.** The time required to complete the schedule on the production line.

**OPERATION YIELD.** The number of completed units for the operation.

**STATUS.** The status of a replenishment operation.

**LINE LOC.** The location at the production line where the component is delivered.

**AC.** This code designates an operation as being active or inactive.

**COMPONENT.** The component (with description) used in the production of the scheduled item.

**SEQ.** The user-defined sequence number that shows the position of the component in the bill of material.

**WH.** The warehouse from which the components are to be issued or the finished items received (manufactured).

**DATE REQUIRED.** The date when the component is required for the operation.

**REQUIRED QUANTITY.**

**CNTRS.** The required quantity expressed in containers.

**PIECES.** The number of pieces in a partial container.

**UM.** The component unit of measure.

**BATCH/LOT.** The batch/lot number assigned to an item lot. This field contains valid data only if you selected the Inventory Management install/tailor option to use batch/lot control.

**FIFO.** The date an item/lot was received into inventory. This field contains valid data only if you selected the Inventory Management install/tailor option to use FIFO date control.

**FLR STK.** This code indicates if an item is classified as floor stock:

<b>blank</b>	Not floor stock
<b>C</b>	Controlled floor stock item
<b>U</b>	Uncontrolled floor stock item

## Schedule Packet Summary List (AMQ4H2)

NORTHCREEK IND		SCHEDULE PACKET SUMMARY LIST				DATE 8/29/	
**	TIME 10:20:32	PAGE	1	AMQ4H2			
ALL NOT PREVIOUSLY PRINTED							
SCHED NUMBER	LINE	WH	ITEM	PLNR	START DATE	SCHED DATE	SCHEDULE QUANTITY S-
S000023	MDL1S	1	MDL100S	MODEL 100 SYSTEM	8/30/**	8/31/**	17.000
S000024	MDL1S	1	MDL100S	MODEL 100 SYSTEM	9/01/**	9/04/**	17.000
S000025	MDL1S	1	MDL100S	MODEL 100 SYSTEM	9/04/**	9/05/**	17.000
S000026	MDL1S	1	MDL100S	MODEL 100 SYSTEM	9/05/**	9/06/**	17.000
S000027	MDL1S	1	MDL100S	MODEL 100 SYSTEM	9/06/**	9/08/**	17.000
S000028	MDL1S	1	MDL100S	MODEL 100 SYSTEM	9/08/**	9/11/**	17.000
S000029	MDL1S	1	MDL100S	MODEL 100 SYSTEM	9/11/**	9/12/**	17.000
S000030	MDL1S	1	MDL100S	MODEL 100 SYSTEM	9/13/**	9/14/**	17.000
S000031	MDL1S	1	MDL100S	MODEL 100 SYSTEM	9/14/**	9/15/**	17.000
S000032	MDL1S	1	MDL100S	MODEL 100 SYSTEM	9/15/**	9/18/**	17.000
S000033	MDL1S	1	MDL100S	MODEL 100 SYSTEM	9/19/**	9/20/**	17.000
S000034	MDL1S	1	MDL100S	MODEL 100 SYSTEM	9/20/**	9/21/**	17.000
S000035	MDL1S	1	MDL100S	MODEL 100 SYSTEM	9/21/**	9/22/**	17.000
S000036	MDL1S	1	MDL100S	MODEL 100 SYSTEM	9/22/**	9/25/**	17.000
S000037	MDL1S	1	MDL100S	MODEL 100 SYSTEM	9/25/**	9/26/**	17.000

The Schedule Packet Summary List report can be printed for all schedules not printed previously; within a range of start or due dates; or for a single schedule by production line, item number, warehouse, schedule date, or S-number; depending on the option you chose.

This report is printed when you select option 7, Print Schedule Information, on the Schedule Management menu (AMQM40).

The report options as selected on display AMQ4G2 and AMQ4G3 include warehouse, schedules selected, material detail (Y or N), and material sequence.

### Fields

**SCHED NUMBER.** The number assigned to this production schedule.

**LINE.** The production line on which the scheduled item is to be manufactured.

**WH.** The warehouse from which the components are to be issued or the finished items received (manufactured).

**ITEM.** The item (with description) for which the production schedule is generated.

**PLNR.** The code of the person responsible for planning and scheduling this finished item.

**START DATE.** The date when the schedule is to be started.

**SCHED DATE.** The date when the item's schedule is due to be completed.

**SCHEDULE QUANTITY.** The quantity of the item released to production on this schedule.

**S-NUMBER.** The features and options code for the scheduled item. This field only appears if you selected the PDM/EPDM install/tailor option to use feature and option numbers.

## Schedule Performance By Item (AMQ232)

```

NORTHCREEK IND                SCHEDULE PERFORMANCE                DATE 8/28/
** TIME 14:12:45 PAGE      1 AMQ232

                                FOR WAREHOUSE 1
                                BY ITEM FROM FIRST          TO LAST
                                SCHED DATE FROM 08/29/** TO 08/29/** FOR SHIFT 1

ITEM MDL100S                MODEL 100 SYSTEM

S-NUMBER
LINE MDL1S MODEL 100 SYSTEM MAIN LINE

YIELD  --- SCHEDULE          CF    SCHED  ----- QUANTITY ----- %  ---
ANDARD WH  PLANNER  SHIFT  OPT    DATE    SCHEDULE    COMPLETE  SCRAPPED    VARIANCE  CMP  ACTUAL ST
        NUMBER
0      0.0    100.0    1     1     8/28/**    960.000    .000      .000      960.000-
0      0.0    100.0    S000034  1     8/28/**    960.000    .000      .000      960.000-
0      0.0    100.0    S000034  1     8/28/**    960.000    .000      .000      960.000-
0      0.0    100.0    S000034  2     8/29/**    960.000    .000      .000      960.000-
0      1     101     1     2     8/29/**    960.000    .000      .000      960.000-
0      0.0    100.0    S000044  2     8/29/**    960.000    .000      .000      960.000-
0      0.0    100.0    S000045  2     8/29/**    960.000    .000      .000      960.000-
0      0.0    100.0    S000046  2     8/29/**    960.000    .000      .000      960.000-
0      0.0    100.0    S000047  2     8/29/**    960.000    .000      .000      960.000-

TOTALS FOR SHIFT 1
GRAND TOTALS FOR ALL SHIFTS    .000    .000    0    0.0
100.0                          .000    .000-
    
```

The Schedule Performance report shows schedule performance data for the schedules in the selected range. Schedule completion, schedule scrap, and schedule yield are shown by shift. Completion percent and variance are summarized by schedule due date. This report is sequenced by item, S-Number, production line, warehouse, and schedule date.

This report is printed when you select option 2, Schedule Performance, on the Reports menu (AMQM20).

The report options as selected on display AMQ221 include warehouse; by line, by item, and by planner; schedule date; and shift (1, 2, or 3).

### Fields

**ITEM.** The item (with description) for which the production schedule is generated.

**S-NUMBER.** The features and options code for the scheduled item. This field only appears if you selected the PDM/EPDM install/tailor option to use feature and option numbers.

**LINE.** The production line (with description) on which the scheduled item is to be manufactured.

**WH.** The warehouse from which the components are to be issued or the finished items received (manufactured).

**PLANNER.** The code of the person responsible for planning and scheduling this finished item.

**SHIFT.** The period when production occurred.

**CF OPTION (Carry forward option).** The code that identifies whether this schedule uses carry forward processing:

- 1 Schedule is not part of a production campaign
- 2 Schedule is part of a production campaign
- 3 This is the last schedule in a production campaign

**SCHED DATE.** The date when the item's schedule is due to be completed.

**QUANTITY.**

**SCHEDULE.** The quantity of the item released to production on this schedule.

**COMPLETE.** The quantity of the item completed on this schedule.

**SCRAPPED.** The quantity of the item scrapped on this schedule.

**VARIANCE.** The difference between completed quantity and scheduled quantity.

**% CMP.** The percentage of the items on the schedule that have been completed.

**YIELD.**

**ACTUAL.** The actual number of units completed on this schedule.

**STANDARD.** The standard number of units that should be completed for this item.

**SCHEDULE NUMBER.** The number of the schedule associated with this item.

**TOTALS FOR SHIFT.** The total number of units completed and scrapped on this schedule for this shift.

**GRAND TOTALS FOR ALL SHIFTS.** The total number of units scheduled, completed and scrapped, total variance, total percent complete, and total actual and standard yields for all shifts.

## Schedule Performance By Line (AMQ231)

NORTHCREEK IND		SCHEDULE PERFORMANCE				DATE 08/29/						
** TIME 14:44:25 PAGE 1 AMQ231												
FOR ALL WAREHOUSES BY LINE FROM FIRST TO LAST												
		SCHED DATE FROM FIRST		TO LAST		FOR ALL SHIFTS						
LINE	MDLIS	MODEL	100	SYSTEM	MAIN	LINE						
ITEM	MDL100S	MODEL	100	SYSTEM	S-NUMBER							
YIELD	----	SCHEDULE	CF	SCHED	-----	QUANTITY	-----	%	----			
ANDARD	WH	PLANNER	SHIFT	OPT	DATE	SCHEDULE	COMPLETE	SCRAPPED	VARIANCE	CMP	ACTUAL	ST
100.0	1	101	1				0.000	0.000		0	0.0	
100.0		S000024					0.000	0.000		0	0.0	
100.0			2				0.000	0.000		0	0.0	
100.0		S000024					0.000	0.000		0	0.0	
100.0			3				0.000	0.000		0	0.0	
0			TOTALS FOR	2	8/29/**	960.000	0.000	0.000	960.000-			
	0	0.0	100.0									
100.0	1	101	1				0.000	0.000		0	0.0	
100.0		S000031					0.000	0.000		0	0.0	
100.0		S000032	2				0.000	0.000		0	0.0	
100.0		S000033	3				0.000	0.000		0	0.0	
**			TOTALS FOR	2	9/01/	960.000	0	0.0	100.0			
	960.000		0.000		0.000							
100.0			GRAND TOTALS			1,920.000	0.000	0.000		0	0.0	
							0.000		1,920.000-			

NORTHCREEK IND		SCHEDULE PERFORMANCE				DATE 08/29/						
** TIME 14:44:25 PAGE 1 AMQ231												
FOR ALL WAREHOUSES BY LINE FROM FIRST TO LAST												
		SCHEDULES PURGED THRU		9/01/**		FOR ALL SHIFTS (1)						
LINE	MDLIS	MODEL	100	SYSTEM	MAIN	LINE						
ITEM	MDL100S	MODEL	100	SYSTEM	S-NUMBER							
YIELD	----	SCHEDULE	CF	SCHED	-----	QUANTITY	-----	%	----			
ANDARD	WH	PLANNER	SHIFT	OPT	DATE	SCHEDULE	COMPLETE	SCRAPPED	VARIANCE	CMP	ACTUAL	ST
100.0	1	101	1				0.000	0.000			0.0	
100.0			2				0.000	0.000			0.0	
100.0			3				0.000	0.000			0.0	
0			TOTALS FOR	2	8/29/**	960.000	0.000	0.000	960.000-			
	0	0.0	100.0									
100.0	1	101	1				0.009	0.000			0.0	
100.0			2				0.000	0.000			0.0	
100.0			3				0.000	0.000			0.0	
0			TOTALS FOR	2	9/01/**	960.000	0.000	0.000	960.000-			
	0	0.0	100.0									
100.0			GRAND TOTALS			1,920.000	0.000	0.000		0	0.0	
							0.000		1,920.000-			

The Schedule Performance report shows schedule performance data for the schedules in the selected range. Schedule completion, schedule scrap, and schedule yield are shown by shift. Completion percent and variance are summarized by daily



schedule or schedule due date. This report is sequenced by production line, item, S-number, warehouse, and schedule date.

This report is printed when you select option 2, Schedule Performance, on the Reports menu (AMQM20). It is also printed when you select option 8, Purge Schedules, on the Schedule Management menu (AMQM40). (When printed through the Purge Schedules option, the report will include only purged schedules.)

The report options as selected on display AMQ221 include warehouse; by line, by item, and by planner; schedule date; and shift (1, 2, 3, or All).

## Fields

**LINE.** The production line (with description) on which the scheduled item is to be manufactured.

**ITEM.** The item (with description) for which the production schedule is generated.

**S-NUMBER.** The features and options code for the scheduled item. This field only appears if you selected the PDM/EPDM install/tailor option to use feature and option numbers.

**WH.** The warehouse from which the components are to be issued or the finished items received (manufactured).

**PLANNER.** The code of the person responsible for planning and scheduling this finished item.

**SHIFT.** The production period when the transaction occurred.

**CF OPTION (Carry forward option).** The code that identifies whether this schedule uses carry forward processing:

- 1 Schedule is not part of a production campaign
- 2 Schedule is part of a production campaign
- 3 This is the last schedule in a production campaign

**SCHED DATE.** The date when the item's schedule is due to be completed.

### QUANTITY.

**SCHEDULE.** The quantity of the item released to production on this schedule.

**COMPLETE.** The quantity of the item completed on this schedule.

**SCRAPPED.** The quantity of the item scrapped on this schedule.

**VARIANCE.** The difference between completed quantity and scheduled quantity.

**% CMP.** The percentage of the items on the schedule that have been completed.

### YIELD.

**ACTUAL.** The actual number of units completed on this schedule.

**STANDARD.** The standard number of units that should be completed for this item.

**SCHEDULE NUMBER.** The number of the schedule associated with this item.

**TOTALS FOR.** The total number of units scheduled, completed, and scrapped; variance; percent complete; and actual and standard yields on this schedule for this date.

**GRAND TOTALS.** The total number of units scheduled, completed and scrapped, total variance, total percent complete, and total actual and standard yields for this date.

## Schedule Performance By Planner (AMQ233)

```

NORTHCREEK IND                SCHEDULE PERFORMANCE                DATE 8/28/
**  TIME 9:31:34 PAGE    1  AMQ233

                                FOR WAREHOUSE 1
                                BY PLANNER FROM FIRST TO LAST
                                SCHED DATE FROM FIRST   TO LAST   FOR ALL SHIFTS

PLANNER    101

ITEM MDL100S      MODEL 100 SYSTEM          S-NUMBER
LINE MDL1S MODEL 100 SYSTEM MAIN LINE

YIELD ---- SCHEDULE          CF    SCHED  ----- QUANTITY ----- % ----
ANDARD WH      NUMBER      SHIFT OPT    DATE    SCHEDULE    COMPLETE    SCRAPPED    VARIANCE CMP    ACTUAL ST
100.0 1      S000054      1          .000    8/28/**  .000        .000        .000-      0     0.0
100.0 S000054      2          .000    .000        .000        .000        .000-      0     0.0
100.0 S000054      3          .000    .000        .000        .000        .000-      0     0.0
100.0 S000054
      TOTALS FOR      1    8/28/**  .000    .000        .000        .000-
0      0.0    100.0

100.0 1      S000064      1          .000    .000        .000        .000-      0     0.0
100.0 S000064      2          .000    .000        .000        .000        .000-      0     0.0
100.0 S000065      3          .000    .000        .000        .000        .000-      0     0.0
100.0 S000066
      TOTALS FOR      1    8/29/**  .000    .000        .000        .000-
0      0.0    100.0

100.0 GRAND TOTALS          .000    .000        .000        .000-
      .000    .000-
  
```

This report shows schedule performance data for the schedules in the selected range. Schedule completion, schedule scrap, and schedule yield are shown by shift. Completion percent and variance are summarized by schedule due date and daily schedule. This report is sequenced by planner, item, S-Number, production line, warehouse, and schedule date.

This report is printed when you select option 2, Schedule Performance, on the Reports menu (AMQM20).

The report options as selected on display AMQ221 include warehouse; by line, by item, and by planner; schedule date; and shift (1, 2, or 3).

### Fields

**PLANNER.** The code of the person responsible for planning and scheduling this finished item.

**ITEM.** The item (with description) for which the production schedule is generated.

**LINE.** The production line (with description) on which the scheduled item is to be manufactured.

**S-NUMBER.** The features and options code for the scheduled item. This field only appears if you selected the PDM/EPDM install/tailor option to use feature and option numbers.

**WH.** The warehouse from which the components are to be issued or the finished items received (manufactured).

**SHIFT.** The production period when the transaction occurred.

**CF OPTION (Carry forward option).** The code that identifies whether this schedule uses carry forward processing:

- 1 Schedule is not part of a production campaign
- 2 Schedule is part of a production campaign
- 3 This is the last schedule in a production campaign

**SCHED DATE.** The date when the item's schedule is due to be completed.

**QUANTITY.**

**SCHEDULE.** The quantity of the item released to production on this schedule.

**COMPLETE.** The quantity of the item completed on this schedule.

**SCRAPPED.** The quantity of the item scrapped on this schedule.

**VARIANCE.** The difference between completed quantity and scheduled quantity.

**% CMP.** The percentage of the items on the schedule that have been completed.

**YIELD.**

**ACTUAL.** The actual number of units completed on this schedule.

**STANDARD.** The standard number of units that should be completed for this item.

**SCHEDULE NUMBER.** The number of the schedule associated with this item.

**TOTALS FOR.** The total number of units completed and scrapped on this schedule for this date.

**GRAND TOTALS.** The total number of units scheduled, completed and scrapped, total variance, total percent complete, and total actual and standard yields for all shifts.

## Transaction Register-Posted Transactions (AMQ361)

NORTHCREEK IND		TRANSACTION REGISTER				DATE 01/21/	
**	TIME 14:44:25	PAGE 1	AMQ361	POSTED TRANSACTIONS		WSID 21	OPID 01
BATCH 347							
TRANS CODE:	CL	TYPE:	COMPONENT TRANSFER TO LINE	WAREHOUSE:	ATL		
SITE:	ALP			LINE:	PLPL1	LINE STAT	
SCHED NO:	S000130	SCHED ITEM:	MPLSBB	REVISION:			
US:	DATE: 1/25/			SUPPLY LOC:	ABCDEE		
**	DESCR: MOLDED	PLASTIC BEACH BALL	LINE LOC: XCP140	PIECES:	50.000		
TRANS DATE:	1/21/**	S-		USER SEQ:		QTY PER C	
NUMBER:	TIME:	COMP ITEM:	YELPNT	QTY CNTRS:	0		
NTR:	300000.000	DESCR:	DAISY YELLOW PAINT	BATCH/			
CREW:		FIFO DATE:	8/05/**	REASON:		REFERENCE	
LOT:		OPERATION:					
SHIFT:							
:							
OLD ON-HAND:	6500.000	NEW ON-HAND:	6500.000	TRANS COST:	.0000		
OLD ON-ORDER:	.000	NEW ON-ORDER:	.000	MATERIAL:	17.40		
OLD ALLOC:	50.000	NEW ALLOC:	50.000	LABOR:	.00		
OLD AVAIL:	6450.000	NEW AVAIL:	6450.000	OVERHEAD:	.00		
TRANS CODE:	CL	TYPE:	COMPONENT TRANSFER TO LINE	WAREHOUSE:	ATL	SITE:	A
LP				LINE:	PLPL1	LINE STAT	
SCHED NO:	S000130	SCHED ITEM:	MPLSBB	REVISION:			
US:	DATE: 1/25/			SUPPLY LOC:	A1B121		
**	DESCR: MOLDED	PLASTIC BEACH BALL	LINE LOC: XCP160	PIECES:	10.000		
TRANS DATE:	1/21/**	S-		USER SEQ:		QTY PER C	
NUMBER:	TIME:	COMP ITEM:	RESELTP	QTY CNTRS:	0		
NTR:	100000.000	DESCR:	REINFORCED SEALING TAPE	BATCH/			
CREW:		FIFO DATE:	8/05/**	REASON:		REFERENCE	
LOT:		OPERATION:					
SHIFT:							
:							
OLD ON-HAND:	3000.000	NEW ON-HAND:	3000.000	TRANS COST:	.0000		
OLD ON-ORDER:	.000	NEW ON-ORDER:	.000	MATERIAL:	17.40		
OLD ALLOC:	10.000	NEW ALLOC:	10.000	LABOR:	.00		
OLD AVAIL:	2990.000	NEW AVAIL:	2990.000	OVERHEAD:	.00		
TRANS CODE:	CL	TYPE:	COMPONENT TRANSFER TO LINE	WAREHOUSE:	ATL	SITE:	A
LP				LINE:	PLPL1	LINE STAT	
SCHED NO:	S000130	SCHED ITEM:	MPLSBB	REVISION:			
US:	DATE: 1/25/			SUPPLY LOC:	A1B131		
**	DESCR: MOLDED	PLASTIC BEACH BALL	LINE LOC: XCP110	PIECES:	.000		
TRANS DATE:	1/21/**	S-		USER SEQ:		QTY PER C	
NUMBER:	TIME:	COMP ITEM:	PLSPEL	QTY CNTRS:	2		
NTR:	10.000	DESCR:	PLASTIC PELLETS	BATCH/			
CREW:		FIFO DATE:	8/05/**	REASON:		REFERENCE	
LOT:	PLAS1	OPERATION:					
SHIFT:							
:							
OLD ON-HAND:	34000.000	NEW ON-HAND:	34000.000	TRANS COST:	.0000		
OLD ON-ORDER:	.000	NEW ON-ORDER:	.000	MATERIAL:	17.40		
OLD ALLOC:	100.000	NEW ALLOC:	100.000	LABOR:	.00		
OLD AVAIL:	33900.000	NEW AVAIL:	33900.000	OVERHEAD:	.00		

The Transaction Register report lists all the REP transactions that were entered.

This report is printed when you select option 8, Print Transaction Register, on the Material Management menu (AMQM30).

### Fields

**TRANS CODE.** The code of the transaction:

<b>RLL</b>	Replenishment by Location
<b>RLS</b>	Replenishment by Schedule
<b>CL</b>	Component Transfer to Line
<b>CN</b>	Component Return to Stores
<b>IP</b>	Planned Manufacturing Issue
<b>RM</b>	Schedule Receipts
<b>RO</b>	Operation Reporting
<b>SM</b>	Schedule Scrap
<b>SC</b>	Component Scrap
<b>PS</b>	Production Status

**TYPE.** The description of the transactions performed.

**WAREHOUSE.** The warehouse from which the components are to be issued.

**SITE.** This field appears only if EPDM is activated. The site associated with this warehouse.

**SCHED.**

**NO.** The number assigned by the system to each schedule in the data base.

**DATE.** The date when the item's schedule is due to be completed.

**ITEM.** The item for which the production schedule is generated.

**DESCR.** The description of item for which the production schedule is generated.

**REVISION.** This field appears only if EPDM is activated. The revision identifier for this scheduled item.

**LINE.** The production line on which the scheduled item is to be manufactured.

**LINE STATUS.** The status of a replenishment operation.

**LINE LOC.** The location at the production line where the component is delivered.

**RSP (RESUPPLY) .** The resupply code that indicates if the material is to be resupplied at the line location:

**0** No, the material is not to be resupplied at the line location.

**1** Yes, the material is to be resupplied at the line location.

**SUPPLY LOC.** The location that supplies materials to line delivery locations.

**TRANS.**

**DATE.** The date the transaction occurred.

**TIME.** The time that the transaction occurred.

**S-NUMBER.** The features and options code for the scheduled item. This field only appears if you selected the PDM/EPDM install/tailor option to use feature and option numbers.

**QTY CNTRS.** The transaction quantity expressed in containers.

**QTY PIECES.** The transaction quantity expressed in pieces.

**COMP.**

**ITEM.** The component used in the production of the scheduled item.

**DESCR.** The description of the component used in the production of the scheduled item.

**USER SEQ.** The user-defined sequence number used to uniquely identify the component and show its position in the bill of material.

**QTY PER CNTR.** The number of items that fit in the container used for priming the production line.

**CREW.** The user-defined code which identifies the production crew.

**BATCH/LOT.** The batch/lot number assigned to an item lot. This field contains valid date only if you selected the Inventory Management install/tailor option to use batch/lot control.

**FIFO DATE.** The date an item/lot was received into inventory. This field contains valid date only if you selected the Inventory Management install/tailor option to use FIFO date control.

**SHIFT.** The production period when the transaction occurred.

**OPERATION.** The operation number for the scheduled item where the component is used.

**REASON.** The user-defined transaction reason code.

**REFERENCE.** The user-defined code used to provide additional information.

**OLD/NEW BALANCE.**

**ON-HAND.** The onhand quantity before and after the transaction.

**ON-ORDER.** The quantity ordered before and after the transaction.

**ALLOC.** The allocated quantity before and after the transaction.

**AVAIL.** The available quantity before and after the transaction.

**TRANS COST.** The cost of the transaction based on IM costing method.

**MATERIAL.** The material cost of the transaction.

**LABOR.** The labor cost of the transaction.

**OVERHEAD.** The overhead cost of the transaction.



## Transaction Register–Transaction Totals (AMQ362)

NORTHCREEK IND		TRANSACTION REGISTER			DATE 08/29/	
** TIME 14:44:25 PAGE 1 AMQ362		TRANSACTION TOTALS				
L COST	TRANSACTION TYPES	TRANSACTION CODE	NUMBER OF TRANSACTIONS	---- TOTAL QUANTITY ---- CNTRS	---- PIECES	TOTA
.0000	COMPONENT TRANSFER TO LINE	CL	2	13	.000	
.0000	DELETED TOTALS		2	13	.000	
.0000	COMPONENT TRANSFER TO LINE	CL	39	50	409.700	
.0000	ERROR TOTALS		39	50	409.700	
.0000	COMPONENT RETURN TO STORES	CN	11	12	98.330	
.0000	POSTED TOTALS		11	12	98.330	
<b>TOTALS</b>						
.0000	DELETED TRANSACTIONS		2	13	.000	
.0000	ERROR TRANSACTIONS		39	50	409.700	
.0000	POSTED TRANSACTIONS		11	12	98.330	

This report prints the total REP transactions (deleted, error, and posted) that were entered.

This report is printed when you select option 8, Print Transaction Register, on the Material Management menu (AMQM30).

### Fields

**TRANSACTION TYPES.** The description of the transactions performed.

**TRANSACTION CODE.** The code of the transaction:

**RLL** Replenishment by Location  
**RLS** Replenishment by Schedule  
**CL** Component Transfer to Line  
**CN** Component Return to Stores  
**IP** Planned Manufacturing Issue  
**RM** Schedule Receipts  
**RO** Operation Reporting  
**SM** Schedule Scrap  
**SC** Component Scrap  
**PS** Production Status

**NUMBER OF TRANSACTIONS.** The number of transactions performed.

**TOTAL QUANTITY.**

**CNTRS.** The total transaction quantity expressed in containers.

**PIECES.** The number of pieces in a partial container used at a location.

**TOTAL COST.** The total costs of the transactions, posted totals, error totals, deleted totals, and received, posted, and error totals.

**DELETED TOTALS.** The total number of transactions, and the total quantity that have been deleted.

**ERROR TOTALS.** The total number of transactions, and the total quantity that is in error.

**POSTED TOTALS.** The total number of posted transactions, and the total quantity expressed in containers or pieces.

**TOTALS.**

**ERROR.** The total number of error transactions, and the total quantity in error.

**POSTED.** The total number of posted transactions, and the total quantity posted.

## Variable Capacity File Maintenance (AMVTC)

NORTHCREEK IND.		VARIABLE CAPACITY MASTER FILE MAINTENANCE							DATE 10/24/	
**	TIME 10.37.37	PAGE	1	AMVTC				OPER JAG	UPDATE#	5
ACTION	PRODUCT	START	MAINT			RESOURCE				
	FACILITY	DATE	DAYS	SHIFT 1	SHIFT 2	SHIFT 3	SHIFT 1	SHIFT 2	SHIFT 3	SOURCE DESCRIPTION
1 - ADD	CS015	1/07/								
**	10	7.5		3.0	5.0	.0	PLANNED OVERTIME			10/24/**
2 - BEFORE	AS005	1/06/								
**	99	8.0		3.0	5.0	.0	RESOURCE MOVE FROM AS095			3/23/**
**	AFTER	AS005	1/06/							
**	30	8.0		3.0	5.0	.0	TEMP RESOURCE FROM AS095			10/24/**
3 - DELETE	LA035	2/14/								
**	99	8.0		3.0	3.0	.0	PLANNED OVERTIME			3/23/**
9 - DELETE	AS095	2/14/								
**	10	7.5		2.0	5.0	.0	PLANNED OVERTIME (TEMP)			10/24/**
**	DELETE	AS095	5/01/**	3			1.0-			
**	.0	.0		PLANNED MACHINE P.M.			10/24/**			

NORTHCREEK IND.		VARIABLE CAPACITY MASTER FILE MAINTENANCE							DATE 10/24/	
**	TIME 10.37.37	PAGE	2	AMVTC	CONTROL SHEET			OPER JAG	UPDATE#	5
-----TRANSACTIONS-----										
TYPE		TOTAL								
1 - ADDS ENTERED		1								
2 - CHANGES ENTERED		1								
3 - DELETES ENTERED		1								
9 - DELETE ALL ENTERED		1								
TOTAL TRANSACTIONS		4								

### Fields

**ACTION.** The type of activity performed on the record: add (A), delete (D), delete all (X), or in the case of change (C), the record as it was before maintenance and as it appears now.

**PRODUCT FACILITY.** The user-assigned identifier for the facility where this variable resource will be applied.

**START DATE.** The date this resource becomes available.

**DAYS.** The number of days this resource will be available.

**SHIFT LENGTH.** The number of hours that this resource will be effective during each shift.

**RESOURCE.** The number (plus or minus) of resource units applied during each shift.

**SOURCE DESCRIPTION.** A description of the variable resource.

***MAINT DATE (Maintenance Date)***. The date this variable capacity record was last maintained.

## Work-in-Process Totals Sheet (AMVQ20)

GATEWAY MFG CO NO. 01		WORK IN PROCESS TOTALS SHEET		DATE 09/30/
** TIME 14.41.57	PAGE 2	AMVQ20	OPEN MANUFACTURING ORDERS AND SCHEDULES INCLUDED	OPER S1
SITE MF1				
	PRODUCTION LINE	ORDER/SCHEDULE		
	*** WIP COSTS ***	*** COSTS ***		
SETUP	.00	10.00		
LABOR	23,234.60	24,589.71		
OVERHEAD	34,699.20	120,976.58		
MATERIAL & PURCHASE		5,673.57		
MISCELLANEOUS		.00		
-----			VALUATION OF SCRAP	
TOTAL		151,249.86	INCLUDED IN TOTAL	
			ACTUAL COSTS	
			100,430.05	
MINUS RECEIPTS		131,142.96		
PLUS PRODUCTION				
LINE WIP COSTS	57,933.80	57,933.80		
WORK IN PROCESS		-----		
		78,040.70		

The Work-in-Process Totals Sheet is printed when you select that report. It is a one-page summary of costs for a site. Other reports also contain a one-page summary at the end. This summary page is titled Work-in-Process Totals Sheet if the report selection includes all open manufacturing orders. It is titled Cost Totals Sheet if the report selection includes any part of the open orders.

Including the sample reports shown, the following activities produce a Cost Totals Sheet or a Work-in-Process Totals Sheet:

Activity	Report ID
Any Summary Report	AMC31B
Any Detail Report	AMC31A
Any Exception Analysis Report	AMC181
Order Closeout Reporting and Purge	AMC561

## Fields

**WIP Costs/Costs.** Costs broken down by setup, labor, overhead (labor overhead), material and purchase, and miscellaneous cost of all manufacturing orders.

**Total.** The combined actual cost of setup, labor, overhead (labor overhead), material and purchase, and miscellaneous cost of all manufacturing orders.

**Minus receipts.** The value of the manufacturing order received into the inventory.

**Work-in-process.** Total actual cost minus inventory receipts.

**Valuation of scrap.** Part of the total actual costs that are scrap.

**Production line WIP costs.** Specifies labor and overhead costs for schedules that may be partially completed. Only schedules that are being actively worked on are included here. Active schedules have either a status of 40 or 55 with a schedule start date that is less than or equal to the current date and a due date that is greater than or equal to the current date. Costs are calculated based on the remaining operation quantity of the schedule.

## Chapter 11. Accounting controls and audits

The auditing of data is important in the decision to implement a computer system. A company invests not only a substantial amount of money, but all of its business information into the system. Management wants to know that the integrity of the data is ensured, that the users will be informed of all activities that change the data, and that in the case of failure, the data can be recreated.

External controls.....	11-1
Internal controls.....	11-1

### External controls

External controls originate outside the software. One such external control is access control. Improper safeguards within a computer system provide an opportunity for the introduction of deliberate or accidental errors. Therefore, access to the computer, programs, and files should be limited to authorized persons. You should use the system security passwords whenever possible.

Another external control is hardware control. Hardware has built-in checking to verify that all aspects of the system are working correctly.

One final example of external control is operational control. An important aspect of auditing is to establish procedures that ensure continuous and correct processing and the ability to recover from damage to data. Detailed documentation describing the operational system and procedures should be prepared for every function and be made available to each user. Authorizations that are required should be spelled out clearly.

### Internal controls

The purpose of internal controls is to ensure correctness, reliability, and the propriety of processing. XA applications provide the capabilities to edit the input, maintain controls, and audit the output back to the point of origination.

### Edits

Editing is the checking of data as it is first entered to the system. As you enter the data either online or in batch mode, the application checks the individual fields for correctness. This data may be checked against master files, lists of valid entries, or reasonableness values or ranges defined by the user. After individual field edits, there are cross-field edits; for example, if vendor number is zero (a one time vendor), then you must enter the vendor name and address. When you use more than one display to do a logical task, some cross-display edits occur; such as in Fixed Asset Accounting, the accumulated depreciation in the schedule record cannot exceed the capitalized value in the header record.

## Controls built into the programs

Controls are used to prove the accuracy of the output. Two kinds of controls will be discussed: control totals and procedure execution controls.

### Control totals

During data entry, running totals are created for groups of related records; the records must balance before you can continue with the task. For example, an Accounts Payable invoice must have the invoice total amount balance to the total of all the detail lines. If the invoice does not balance, however, you can accept the error temporarily and continue with the next invoice. The invoice in error will not get posted until you resolve the error, but you are not held up from continuing the task.

Other totals are accumulated for the group as a whole: batch totals for data entry and session totals for file maintenance. These totals are in control fields that you use to balance to adding machine tapes or hash totals previously calculated by hand. Totals can be for dollar amounts such as total open payables, total debits, and total credits. Totals can also represent number of things entered such as total invoices, total orders, and number of additions, changes, and deletions. Control totals are shown on status displays and printed on reports.

### Procedure execution controls

Procedure execution controls ensure that functions are performed in the correct sequence. These controls exist in two formats: within a menu option and between menu options.

Within one menu option, several tasks may be performed. As each job step completes, the control program calls each subsequent job in order. If any step is cancelled, the rest of the procedure is not performed.

The procedure control set up between menu options establishes a flag for each option in the sequence. Flags are set each time a menu option is successfully run. If you select a menu option out of sequence, a message appears and the job is canceled. For example, in Payroll, you must take options to select records and calculate gross pay before taking the option to calculate net pay. Sometimes a menu option is available only at certain times of the year. In Forecasting, all options on the Seasonal Update menu can only be run once at the end of the year.

All of these types of control are in place to help prevent erroneous updates by ensuring that functions are performed in the correct sequence.



## Audit trails

Having an audit trail gives you the ability to backtrack from a current total, utilizing the detailed transactions that have occurred since the earlier total, to prove the accuracy of the current total. XA has features that provide an excellent audit trail to trace the events and data that have changed in the system through time.

### Numbering system

Assigning unique numbers to individual entries and groups of entries is one way of providing an audit trail. These numbers follow the item throughout the system. The identifying numbers appear on displays and are printed on reports. So, if you want to trace the item backward, you simply look for that number on a preceding report. Some examples of audit numbers are:

- Batch numbers, to group a set of source documents entered together
- Sequence numbers, to identify an individual entry within a group and keep it in a desired sequence
- Line numbers, to identify a particular line within a logically-related set such as orders and invoices
- Transaction source numbers, to associate a group of related entries
- Journal reference numbers, a composite field to identify the journal type (PJ, CD, GJ, for example), a sequence number assigned to the journal, and a line number within the journal.

### Printed controls

The REP application includes audit trails on printed reports and listings. The system date and time are always printed on each report, so that you can keep output in chronological order. Run time options are often printed at the top of the report so the you can see the information the report should contain. File maintenance audit listings show all added and deleted records, as well as the before and after images of all changed records.

These system controls are an integral part of a application's auditing. In addition, external controls, such as access, procedural, hardware, and operational controls are also key in insuring the integrity of the system.

These features built into XA, combined with a good method of external control and held together by management commitment provide a system of edits, controls, and audit trails that help meet the concerns of accountants and auditors. By taking advantage of all of these features, a company can feel confident that the information provided by the system is correct and reliable and any questions that arise over specific data elements can be traced back to its origin.

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## Appendix A. Offline file load and data entry

As an alternative to entering transaction data interactively using XA, you can prepare the information offline in files on a separate system. The files that you create offline can then be loaded into the XA system and processed by XA. Offline files can be created on a diskette or written to a disk file.

To use data from offline files in XA, you must:

1. Gather the information to be entered.
2. Create a file with the information on diskette or disk. The file must follow the corresponding file layout given in this appendix.
3. Process the offline files by selecting an XA menu option.

This appendix describes those activities.

---

### Creating a diskette or disk file

You can create offline files on diskette or disk. You can create the files in several ways. For example:

- You can create the records with a user-written program on an offline data entry device, and write them to a disk or diskette file.
- You can have another system create the records on tape using the required file layout. You copy the tape file to disk or diskette.
- You can have a remote location send the records via telecommunications. You can write them to a disk or diskette file.

It does not matter how or where the records originate. As long as they reside in a disk or diskette file that has the defined file layout, they can be processed by XA.

### File format

Use the file format shown later in this appendix to set up records for the file you want to load from diskette or disk. The format gives you the following information for each field in which you can enter information:

- A brief description of the field
- The short field name (5 characters)
- The position of the field in the record (From and To)
- Whether the field is alphabetic (A), numeric (N), signed (S), or packed (P)
- For numeric, signed, and packed fields only, the number of decimal positions in the field (Dec. Pos.).

The long field names in the format match the information fields on the entry forms you filled out.

## File name

Assign a special name to each file, or use the default name listed here. You must enter the name when you load the file.

<b>File to be Loaded or Updated</b>	<b>Offline File Name</b>
Offline Diskette Entry file	RPTRN1
Offline Disk Repetitive Transactions file	RPTRN2
Offline REP Transactions Work file	RPTRNW
Schedule Demand file	SCHDMD

## Record length

Assign a record length of 128 for offline diskette files and greater than 128 for offline disk files.

## Special data requirements

When you enter the information for an offline record, type in the record code shown on the input form as the first two characters of the record.

If you enter dates, type them in using the same date format you use for the System i and for all XA applications.

Type the information carefully. The system will check for errors when you process the files. If it finds errors, you must correct the records with errors before you can finish processing them.

---

## Processing the offline files

When you have finished creating the offline files, you are ready to load the information onto the system. For instructions on how to load special transaction data from offline files, see “Option 6. Enter Transactions from Offline Files (AMQM30)” on page 5-83.

Following are the file formats for the offline files you can load for this application.

## File formats

### Transaction work offline file format–A record

**Offline file name:** Offline Entry file–A Records (RPTRN1A)

**Record length:** 105

**Function:** Collect information for the REP Transaction Work file

Field Description	Field Name	From	To	A/N	Dec. Pos.
Active Record Code	ACREC	1	1	A	
Record Code	RCDID	2	2	A	
Sequence Number	SEQNM	3	9	S	0
Transaction Code	TCODE	10	11	A	
Production Line	PLINE	12	16	A	
Finished Item Number	FITEM	17	31	A	
S-Number	SNMBR	32	51	A	
Order Due Date	ODUDT	52	57	P	0
Order Number	ORDNO	58	64	A	
Warehouse	HOUSE	65	67	A	
Component Item Number	CITEM	68	82	A	
User Sequence	USRSQ	83	86	A	
Transaction Date	TRNDT	87	92	S	0
Transaction Quantity (Containers)	QCNTR	93	95	S	0
Transaction Quantity (Pieces)	QPIEC	96	105	S	3

### Transaction work offline file format–B record

**Offline file name:** Offline Entry file–B Records (RPTRN1B)

**Record length:** 101

**Function:** Collect information for the REP Transaction Work file

Field Description	Field Name	From	To	A/N	Dec. Pos.
Active Record Code	ACREC	1	1	A	
Record Code	RCDID	2	2	A	
Sequence Number	SEQNM	3	9	S	0
Transaction Code	TCODE	10	11	A	
Supply Location	SLOCN	12	18	A	
Batch/Lot Number	LBHNO	19	28	A	
FIFO Date	FDATE	29	34	S	0
Delivery Location	DLOCN	35	41	A	
Operation Sequence Number	OPSEQ	42	45	A	
Employee Shift Override	SHIFT	46	46	A	
Line Status Code	LINCD	47	47	A	

<b>Field Description</b>	<b>Field Name</b>	<b>From</b>	<b>To</b>	<b>A/N</b>	<b>Dec. Pos.</b>
Crew Number or Crew Size	CREWN	48	50	A	
Priority Code	PRORT	51	51	A	
Rework Flag	REWRK	52	52	A	
Pick List Number	PLIST	53	57	S	0
Return List Number	RLIST	58	62	S	0
Pick List Line Reference Number	PNREF	63	67	S	0
Return List Line Ref. Number	RNREF	68	71	S	0
Reason Code	REASN	72	77	A	
Reference Number	REFNO	78	87	A	
Clock Time	TIMCD	88	91	A	
Cancel Replenishment Code	CNLRP	92	92	A	
Last Transaction Reported Flag	LSTTR	93	93	A	
Resupply Flag	RSPFA	94	94	A	
MODATA Low Level Sequence Number	MSQNO	95	101	S	0

### Repetitive transactions offline file format

**Offline file name:** Offline REP Transactions file (RPTRN2)

**Record length:** 186

**Function:** Collect information for the REP Transaction Work file

<b>Field description</b>	<b>Field name</b>	<b>From</b>	<b>To</b>	<b>A/N</b>	<b>Dec. pos.</b>
Active Record Code	ACREC	1	1	A	
Transaction Code	TCODE	2	3	A	
Production Line	PLINE	4	8	A	
Finished Item Number	FITEM	9	23	A	
S-Number	SNMBR	24	43	A	
Schedule Due Date	ODUDT	44	49	S	0
Schedule Number	ORDNO	50	56	A	
Warehouse	HOUSE	57	59	A	
Component	CITEM	60	74	A	
User Sequence	USRSQ	75	78	A	
Transaction Date	TRNDT	79	84	S	0
Transaction Qty (containers)	QCNTR	85	87	S	0
Transaction Qty (pieces)	QPIEC	88	97	S	3
Supply Location	SLOCN	98	104	A	
Batch/Lot Number	LBHNO	105	114	A	
FIFO Date	FDATE	115	120	S	0
Delivery Location	DLOCN	121	127	A	
Operation Sequence Number	OPSEQ	128	131	A	
Employee Shift Override	SHIFT	132	132	A	
Line Status Code	LINCD	133	133	A	

<b>Field description</b>	<b>Field name</b>	<b>From</b>	<b>To</b>	<b>A/N</b>	<b>Dec. pos.</b>
Crew Number or Crew Size	CREWN	134	136	A	
Priority	PRORT	137	137	A	
Rework Flag	REWRK	138	138	A	
Pick List Number	PLIST	139	143	S	0
Return List Number	RLIST	144	148	S	0
Pick List Line Reference Number	PNREF	149	153	S	0
Return List Line Ref. Number	RNREF	154	157	S	0
Reason Code	REASN	158	163	A	
Reference Number	REFNO	164	173	A	
Clock Time	TIMCD	174	177	A	
Cancel Replenishment Code	CNLRP	178	178	A	
Last Transaction Reported	LSTTR	179	179	A	
Resupply Flag	RSPFA	180	180	A	
MODATA Low Level Sequence Number	MSQNO	181	186	S	0

### Offline Repetitive Transactions Formatted Work file format

**Offline file name:** Offline REP Transactions Formatted Work file (RPTRNW)

**Record length:** 332

**Function:** Receive transactions information from offline diskette or disk file

<b>Field Description</b>	<b>Field Name</b>	<b>From</b>	<b>To</b>	<b>A/N</b>	<b>Dec. Pos.</b>
Active Record Code	ACREC	1	1	A	
Sequence Number	SEQNM	2	8	S	0
Transaction Code	TCODE	9	10	A	
Production Line	PLINE	11	15	A	
Finished Item Number	FITEM	16	30	A	
Schedule Item Description	FDESC	31	60	A	
S-Number	SNMBR	61	80	A	
Schedule Due Date	ODUDT	81	87	S	0
Schedule Number	ORDNO	88	94	A	
Warehouse	HOUSE	95	97	A	
Component Item Number	CITEM	98	112	A	
Component Item Description	CDESC	113	142	A	
User Sequence	USRSQ	143	146	A	
Transaction Date	TRNDT	147	153	S	0
Transaction Qty (containers)	QCNTR	154	156	S	0
Transaction Qty (pieces)	QPIEC	157	166	S	3
Previous Quantity On Hand	PRQOH	167	176	S	3
Previous Allocations	PRALC	177	186	S	3

<b>Field Description</b>	<b>Field Name</b>	<b>From</b>	<b>To</b>	<b>A/N</b>	<b>Dec. Pos.</b>
New Quantity On Hand	NUQOH	187	196	S	3
New Allocations	NUALC	197	206	S	3
Supply Location	SLOCN	207	213	A	
Batch/Lot Number	LBHNO	214	223	A	
FIFO Date	FDATE	224	230	S	0

<b>Field Description</b>	<b>Field Name</b>	<b>From</b>	<b>To</b>	<b>A/N</b>	<b>Dec. Pos.</b>
Delivery Location	DLOCN	231	237	A	
Operation Sequence Number	OPSEQ	238	241	A	
Employee Shift Override	SHIFT	242	242	A	
Line Status Code	LINCD	243	243	A	
Crew Number or Crew Size	CREWN	244	246	A	
Priority	PRORT	247	247	A	
Rework Flag	REWRK	248	248	A	
Pick List Number	PLIST	249	253	S	0
Return List Number	RLIST	254	258	S	0
Pick List Line Reference Number	PNREF	259	263	S	0
Return List Line Ref. Number	RNREF	254	267	S	0
Reason Code	REASN	268	273	A	
Reference Number	REFNO	274	283	A	
Clock Time	TIMCD	284	287	A	
Turnaround File Designator	TURNA	288	288	S	0
Turnaround Sequence Number	TURNN	289	295	S	0
Turnaround Check Digit	TURNC	296	296	S	0
Cancel Replenishment Code	CNLRP	297	297	A	
Last Transaction Reported Flag	LSTTR	298	298	A	
Message Number	MICNO	299	302	S	0
Update Time (posting)	UPDTM	303	308	S	0
Update Period (date)	UPDDT	309	315	S	0
Originating Transaction Code	ORGTR	316	317	A	
Number of Transactions in Set	NTRAN	318	320	S	0
Key of RPTRAN Header Transaction Record	HDKEY	321	327	S	0
Resupply Flag	RSPFA	328	328	A	
MODATA Low Level Sequence Number	MSQNO	329	332	P	0

## Schedule Demand file format

**Offline file name:** Schedule Demand file (SCHDMD)

**Record length:** 49

**Function:** Add user-defined schedule information

<b>Field Description</b>	<b>Field Name</b>	<b>From</b>	<b>To</b>	<b>A/N</b>	<b>Dec. Pos.</b>
Item	ITNBR	1	15	A	
Warehouse	HOUSE	16	18	A	
Request Date	RDATE	19	22	P	0
S-Number	SNMBR	23	42	A	
Demand Quantity	RQNTY	43	48	P	3
Error Flag	ERRFL	49	49	A	



---

## Batch reuse and transaction types

You can choose the option of deleting or holding transactions before saving the files (batch reuse option) during application tailoring.

### Batch reuse option

If you specify during application tailoring that transaction batches are to be deleted before saving files, those batches that are complete when the REP Transaction Register is printed are deleted. Should the master files require restoring, however, those transactions would have to be entered and processed again. Unless you are using offline entry and have retained your offline files, those transactions would have to be entered again at a work station.

If you specify that transaction batches are not to be deleted before saving files, any batches of transactions are retained when the REP Transaction Register is printed. Under this condition, the only way to free up the space is to save all files. However, if the master files should require restoring, you would not have to enter again those transactions processed since the last save. The information is still available in the retained batches.

**Note:** Note: If you do not delete transaction batches, and it becomes necessary to restore your files, the restored transaction batch or batches would subsequently be processed again to update the restored master files. If multiple batches are involved, the transactions would not necessarily be processed in the same sequence as they previously were. This can result in the average and last costs being calculated differently than in the previous run.

---

## Transaction types

You can enter many types of transactions to keep REP records current. Following is a list of the transactions that you can enter and maintain using the REP Material Management menu:

- Inventory Transactions
  - Cost Adjustment (CA). Used to recalculate the average unit cost and to replace the last unit cost of an item.
  - Average Cost Replace (CR). Used to change the average cost of an item.
  - Standard Cost Replace (CS). Used to change the standard unit cost of an item.
  - Inventory Adjustment (IA). Used to adjust the on hand balance of an item.
  - Planned Manufacturing Issue (IP). Used to report individual component issues to manufacturing orders.
  - Miscellaneous Issue (IS). Used to report issues that are not charged to customer or manufacturing orders.
  - Interwarehouse Issue (IW). Used to report issues to another warehouse.
  - Pick Complete by Item (PB). Used to report the pick completion of an item (bulk pick).
  - Miscellaneous Receipt (RC). Used to report receipts for items that do not have open orders.
  - Interwarehouse Receipt (RW). Used to report receipts from other warehouses.
  - Sales Shipment (SA). Used to report sales shipments when Customer Order Management (COM) is not interfacing or is not passing information to IM.
  - Scrap From Stock (SS). Used to report items that have been scrapped from stock.
  - Interwarehouse Transfer (TW). Used to complete both the issue and receipt of an interwarehouse transfer.

- REP Transactions
  - Component Transfer to Line (CL). Used to report the movement of components to the production line.
  - Component Return to Stores (CN). Used to report the return of components to the warehouse.
  - Production Status (PS). Used to report production line status statistics, such as line downtime.
  - Replenishment (RL). Used to report the need for replenishment, and the components used by line location (RLL) or by schedule (RLS).
  - Schedule Receipt (RM). Used to report an item receipt from production.
  - Operation Reporting (RO). Used to report the quantity completed at an operation for the scheduled item.
  - Component Scrap (SC). Used to report component items that have been scrapped on a manufacturing order.
  - Schedule Scrap (SM). Used to report the scrapping of partially completed end items.

## Transaction tables

Use the following tables to see the updates that take place in records as a result of using a transaction.

Table 11-1. Item Balance file (ITEMBL) - Parent Item

Fields	Transaction Types							
	RL	CL	CN	RM	RO	SM	SC	PS
On hand total quantity				+				
Last date changing qty on hand				=n				
Req'ts planning activity flag				=1		=1		
Force cycle count flag				=1				
On-order production quantity				-				
Qty received this period				+				
Qty received since last planning run				+				
Date of last scrap							=n	
Rec. after production date				+				
Rec. before production date				+				
Cycle count transactions				+		+		

Legend:

Symbol	Meaning
+	Increase
-	Decrease
+n	Increase by n
=n	Set equal to n
*	If qty on hand goes negative

Table 11-2. Item Balance file (ITEMBL) - Component

Fields	Transaction Types							
	RL	CL	CN	RM	RO	SM	SC	PS
				(IP)	(IP)	(IP)		
On-hand total quantity				-	-	-	-	
Last date changing qty				=n	=n	=n	=n	
Requirements planning activity				=1	=1	=1		
Force cycle count flag				=1	=1	=1		
Qty used year-to-date				+	+	+	+	
Manufacturing allocated qty				-	-	-	-	
Quantity issued this period				+	+	+	+	
Quantity issued year-to-date				+	+	+	+	
Date of last issue				=n	=n	=n	=n	
Quantity used this period				+	+	+	+	
Date of last usage				=n	=n	=n	=n	
Usage cost, period-to-date				X	X	X	X	
Usage cost, year-to-date				X	X	X	X	
Quantity scrapped this period						+	+	
Quantity scrapped year to date						+	+	
Date of last scrap						=n	=n	
Scrap cost, period to date						X	X	
Scrap cost, year to date						X	X	
Cycle count transactions				+	+	+	+	

Legend:

Symbol	Meaning
X	Calculate
+	Increase
-	Decrease
=n	Set equal to n

Table 11-3. Manufacturing Order Detail File (MODATA) - Component

Fields	Transaction Types							
	RL	CL	CN	RM	RO	SM	SC	PS
				(IP)	(IP)	(IP)		
Issue quantity total to date				+	+	+	+	
Date of last issue				=n	=n	=n	=n	
Quantity scrapped							+	
Component order scrapped						+		
Issue quantity this period				+	+	+	+	
Actual cost this period				X	X	X	X	
Actual cost to date				X	X	X	X	
Planned scrap quantity						-	-	

Legend:

Symbol	Meaning
X	Calculate
+	Increase
-	Decrease
=n	Set equal to n

Table 11-4. Manufacturing Order Master file (MOMAST) - Parent Item

Fields	Transaction Types							
	RL	CL	CN	RM /LT	RO	SM	SC	PS
Manufacturing order status				=n				
Quantity received				+				
Last activity date				=n		=n	=n	
Scrap quantity						+		
Receipt cost this period				X				
Issue cost				X			X	
Receipt cost				X				
Scrap cost						X		
Quantity received shift 1				+				
Quantity received shift 2				+				
Quantity received shift 3				+				
Quantity scrapped shift 1						+		
Quantity scrapped shift 2						+		
Quantity scrapped shift 3						+		
Last transaction reported				=n				
Actual start date		=n						
Setup cost				X	X	X		
Labor cost				X	X	X		
Overhead cost				X	X	X		
Average Receipt Cost				X				
Legend:								
Symbol	Meaning							
X	Calculate							
+	Increase							
=n	Set equal to n							

Table 11-5. Manufacturing Operations file (MOROUT)

Fields	Transaction Types							
	RL	CL	CN	RM	RO	SM	SC	PS
				(IP)	(IP)	(IP)		
Total qty complete this period				+	+			
Total qty complete to date				+	+			
Quantity scrapped total to date						+		
Setup labor hours this period				+	+	+		
Setup machine hours this period				+	+	+		
Run machine hours this period				+	+	+		
Run labor hours this period				+	+	+		
Setup labor hours total to date				+	+	+		
Setup machine hours total				+	+	+		
Run machine hours total to date				+	+	+		
Run labor hours total to date				+	+	+		
Setup labor cost total to date				X	X	X		
Machine cost total to date				X	X	X		
Run labor cost total to date				X	X	X		
Overhead cost total to date				X	X	X		
Date of last transaction				=n	=n	=n		
Setup labor cost this period				X	X	X		
Machine cost this period				X	X	X		
Run labor cost this period				X	X	X		
Overhead cost this period				X	X	X		
Operation status code				=n	=n	=n		
Actual start date				=n	=n	=n		

Legend:

Symbol	Meaning
X	Calculate
+	Increase
=n	Set equal to n



Table 11-6. Replenishments file (RPLMNT)

Fields	Transaction Types								
	RL	CL	CN	RM	RM/LT	RO	SM	SC	PS
				(IP)		(IP)	(IP)		
Picked quantity		+							
Return quantity			+						
Backflushed quantity				+	+	+	+	+	
Transfer date		=n							
Transfer time		=n							
All other fields									
Legend:									
Symbol	Meaning								
X	Calculate								
=n	Set equal to n								
+	Increase								

Table 11-7. Allocated quantity file (SLALLO) - Supply location

Fields	Transaction Types								
	RL	CL	CN	RM	RO	SM	SC	PS	
Allocated quantity		-							
Legend:									
Symbol	Meaning								
-	Decrease								

Table 11-8. Allocated quantity file (SLALLO) - Line location

Fields	Transaction Types								
	RL	CL	CN	RM	RO	SM	SC	PS	
Allocated quantity		+	-	-	-	-	-	-	
Legend:									
Symbol	Meaning								
-	Decrease								
+	Increase								

Table 11-9. Stock Location file (SLDATA)

Fields	Transaction Types								
	RL	CL	CN	RM	RO	SM	SC	PS	
Location status		=n	=n						
1st subdivision ind		=n	=n						
2nd subdivision ind		=n	=n						
3rd subdivision ind		=n	=n						
4th subdivision ind		=n	=n						

Table 11-9. Stock Location file (SLDATA)

Fields	Transaction Types							
	RL	CL	CN	RM	RO	SM	SC	PS
5th subdivision ind		=n	=n					
Legend:								
Symbol	Meaning							
=n	Set equal to n							

Table 11-10. Line Location file (SLDATA)

Fields	Transaction Types							
	RL	CL	CN	RM	RO	SM	SC	PS
				(IP)	(IP)	(IP)		
Location status		=n	=n	=n			=n	
1st subdivision ind		=n	=n	=n				
2nd subdivision ind		=n	=n	=n				
3rd subdivision ind		=n	=n	=n				
4th subdivision ind		=n	=n	=n				
5th subdivision ind		=n	=n	=n				
Legend:								
Symbol	Meaning							
=n	Set equal to n							

Table 11-11. Location Quantity file (SLQNTY) - Supply location - Component

Fields	Transaction Types							
	RL	CL	CN	RM	RO	SM	SC	PS
Location quantity		-	+					
Allocated quantity								
QC due date		X						
1st QC indicator		=n						
2nd QC indicator		=n						
Legend:								
Symbol	Meaning							
X	Calculate							
+	Increase							
-	Decrease							
=n	Set equal to n							

Table 11-12. Location Quantity file (SLQNTY) - Receipt location - Component

Fields	Transaction Types							
	RL	CL	CN	RM	RO	SM	SC	PS
Location quantity				+				
QC due date				X				

*Table 11-12. Location Quantity file (SLQNTY) - Receipt location - Component*

Fields	Transaction Types							
	RL	CL	CN	RM	RO	SM	SC	PS
1st QC indicator				=n				
2nd QC indicator				=n				
Legend:								
Symbol	Meaning							
X	Calculate							
+	Increase							
=n	Set equal to n							

*Table 11-13. Location Quantity file (SLQNTY) - Line location*

Fields	Transaction Types							
	RL	CL	CN	RM	RO	SM	SC	PS
				(IP)	(IP)	(IP)		
Location quantity		+	-	-	-	-	-	-
Supply quantity		-						
Line quantity		+	-	-	-	-	-	-
Allocated quantity				-	-	-	-	-
QC due date			X	X	X	X		
1st QC indicator			=n	=n	=n	=n		
2nd QC indicator			=n	=n	=n	=n		
Legend:								
Symbol	Meaning							
X	Calculate							
+	Increase							
-	Decrease							
=n	Set equal to n							

Table 11-14. Component Status file (CMPSTS)

Fields	Transaction Types									
	Prime	Pick	RL	CL	CN	RM	RO	SM	SC	PS
Required quantity	=MODATA					_*				
Issued quantity						-/+	-/+_			
Total issued as of last replenishment		-				-/+	-/+			
Total remaining replenishment	=MODATA	-				_*				
Quantity pending replenishment		+		-/+						
Quantity replenished		+		+/-						
Quantity pending return						-/+				
Quantity returned						+/-				
Quantity scrap expected	=MODATA					_*				
Scrap quantity								+/-	+/-	
Picklist shortage quantity		-/+								
Manual replenishment		-	X							

Legend:

Symbol	Meaning
X	Calculate
+	Increase
-	Decrease
=n	Set equal to n=
*	Last transaction only

Table 11-15. Pending Available Allocation file (PAALLO)

Fields	Transaction Types									
	Prime	Pick	RL	CL	CN	RM	RO	SM	SC	PS

Allocated quantity		+		-						
Required quantity		+		-						

Legend:

Symbol	Meaning
+	Increase
-	Decrease



---

## Backing out entries

If an error is detected after the files have been updated and the REP Transaction Register has been printed, you can make a reversing entry for most transactions by entering the transaction with negative quantities again. You may have to use file maintenance to correct some of the data fields in the master files, such as date fields or completion codes.

## Work station entry using immediate update

If an error is detected and the transaction has not yet been printed on the REP Transaction Register, you can reverse the transaction by changing the reversal code from A (active) to R (reversed). Then you can enter the correct transaction.

## Offline entry

Offline entry updates the master files as the transactions are read. To change an offline batch transaction, use the same process as work station entry.

---

## Additional references

By using Inquiry (Chapter 4) and Reports (Chapter 5), you should be able to verify the actual condition of data in your master files. To determine how data was changed from previous values, you can review previous REP Transaction Registers and reports. Only you can determine which supporting inquiries and reports are needed to resolve questionable values.

## Appendix B. Security areas

The options on the CAS Security Maintenance menu (AMZM38) allow you to protect application tasks from unauthorized users. You can define security areas and then define specific tasks associated with each area.

Security areas protect access to a group of menu options. The following table shows the application security areas and their associated menu options and task IDs. To print a report of all application areas, see the description of the Generate reports option in the Security Maintenance chapter of the *CAS User's Guide*.

### Notes:

1. To perform item balance quantity and standard cost maintenance, you must be authorized to both File Maintenance, and Item Balance Quantity and Standard Cost Maintenance security areas.
2. To add quantities in the Location Detail file, you must be authorized to both File Maintenance and Quantity Maintenance - Location Detail security areas.
3. To perform variable capacity maintenance, you must be authorized to both Item/Line and Variable Capacity Maintenance security areas.

Table 11-17. (Page 1 of 4) Repetitive Production Management security areas

Security area	Menu/option	Description	Task ID
General Inquiries and Reports	AMQM10/1	Item Balance	AMQM1001
	AMQM10/5	Work With Item/Line	WRKILN
	AMQM10/6	Production Facility	AMQM1006
	AMQM10/7	Item Detail by Location	AMQM1007
	AMQM10/8	Transaction History	AMQM1008
	AMQM20/1	Item Balance	AMQM2001
	AMQM20/8	Item Balance Audit	AMQM2008
	AMQM20/9	Item/Line Audit	AMQM2009
	AMQM20/10	Location Audit	AMQM2010
	AMQM50/3	Work With Item/Line	WRKILN
AMQM50/9	Work With Location/Component	WRKLOCCMP	
AMQM70/1	Work With Schedules	WRKSOR	
AMQM70/2	Work With Date Schedules	WRKDTESOR	
AMQM70/3	Work With Item Schedules	WRKITMSOR	
AMQM70/4	Work With Line Schedules	WRKLINSOR	
AMQM70/5	Work With Planner Schedules	WRKPLNSOR	
AMQM70/6	Work With Schedule Operations	WRKSOROPS	
AMQM70/7	Work With Schedule Materials	WRKSORMTL	
AMQM70/8	Work With Schedule Allocations	WRKSORALC	
AMQM70/9	Work With Schedule Descriptions	WRKSORDSC	
AMQM70/10	Item/Line	WRKILN	

Table 11-17. (Page 2 of 4) Repetitive Production Management security areas

<b>Security area</b>	<b>Menu/option</b>	<b>Description</b>	<b>Task ID</b>
	AMQM70/11	Location/Component	WRKLOCCMP
	AMQM70/12	Component Status	WRKCOMPSTS



Table 11-17. (Page 3 of 4) Repetitive Production Management security areas

<b>Security area</b>	<b>Menu/option</b>	<b>Description</b>	<b>Task ID</b>
Costing Reports	AMQM20/5	Item/Line Process	AMQM2005
	AMQM20/7	WIP Cost	AMQM2007
Material Management	AMQM30/1	Prime Production Lines	AMQM3001
	AMQM30/2	Print Pick List	AMQM3002
	AMQM30/3	Print Container Labels	AMQM3003
	AMQM30/4	Print Component Return List	AMQM3004
Material Transaction Entry	AMQM30/5	Enter Transactions	AMQM3005
	AMQM30/6	Enter Transactions from Offline Files	AMQM3006
	AMQM30/8	Print Transaction Register	AMQM3008
Schedule Management	AMQM10/2	Schedule Performance Inquiry	AMQM1002
	AMQM10/3	Schedule vs. Demand Inquiry	AMQM1003
	AMQM10/4	Released Schedules Inquiry	AMQM1004
	AMQM20/2	Schedule Performance Report	AMQM2002
	AMQM20/3	Released Schedules Report	AMQM2003
	AMQM20/4	Production Schedules Report	AMQM2004
	AMQM40/1	Set Schedule Review/Release Horizon	AMQM4001
	AMQM40/2	Maintain Customer/Manufacturing Dates	AMQM4002
	AMQM40/3	Extract Schedule Requirements	AMQM4003
	AMQM40/4	Enter and Maintain Schedules	AMQM4004
	AMQM40/5	Sequence Schedules	AMQM4005
	AMQM40/6	Release Schedules	AMQM4006
	AMQM40/7	Print Schedule Information	AMQM4007
	AMQM40/9	Review Schedule Performance	AMQM4009
	AMQM40/10	Recalculate Schedules	AMQM4010
	AMQM50/2	Released Schedules Maintenance	AMQM5002
File Maintenance	AMQM50/1	Item Balance	AMQM5001
	AMQM50/5	Batch/Lot Quality Control Status	AMQM5005
	AMQM50/6	Batch/Lot Numbers	AMQM5006
	AMQM50/7	Location Detail	AMQM5007
Item/Line	AMQM20/6	Item/Line	AMQM2006
	AMQM50/4	Production Facility	AMQM5004
REP Code File Maintenance	AMQM58/1	Bill of Lading Commodity	AMVA5DFR
	AMQM58/2	Country	AMVAJDFR
	AMQM58/3	Item Class	AMVBADFR
	AMQM58/4	Item Price Class	AMVBDDFR
	AMQM58/5	Item Sales Family	AMVCHDFR
	AMQM58/6	Item Sales Group	AMVCIDFR

Table 11-17. (Page 4 of 4) Repetitive Production Management security areas

<b>Security area</b>	<b>Menu/option</b>	<b>Description</b>	<b>Task ID</b>
	AMQM58/7	Language	AMVBEDFR
	AMQM58/8	Transaction Unit of Measure Class	AMVBJDFR
	AMQM58/9	Unit of Measure Master	AMVBKDFR

---

## Appendix C. Automated job submission for REP

XA provides the ability to execute XA batch jobs from outside of the XA menu structure for Repetitive Production Management (REP) application tasks listed below:

Task	Menu and Option	Command
Print REP Pick List	AMQM30-02	PRTREPPKL
Reprint REP Pick List	AMQM30-02	RPRTREPPKL

You can initiate application tasks in a batch subsystem from sources other than the XA menu system. In order to provide the most flexibility, the Cross Application Support (CAS) portion of this activity uses a series of Application Program Interfaces (APIs). These CAS APIs then can be used by the applications to provide a programmer's interface to each batch job. You cannot execute these APIs at an System i command line; they must be called by a batch or interactive program.

Refer to the *CAS Technical Reference Guide* for more information on the APIs and for a list of all the application tasks available.

---

## Command Guidelines

This section assists you in creating a name for an XA command. XA command names are patterned after the System i Control Language Standard. This provides an action-object naming structure. Command names are usually composed of a series of three-character abbreviations. The maximum length for a command name is ten characters.

It is acceptable to use the XA application abbreviation in a command name even though some applications have two- or four-character abbreviations. Using the application abbreviation may be necessary to distinguish between printing a REP or COM pick list, for example.

The following lists are only examples of the abbreviations you might choose to use. You can define your own abbreviations for your company.

Action abbreviations:

<b>ADD</b>	Add
<b>CHG</b>	Change
<b>CLR</b>	Clear
<b>CRT</b>	Create
<b>DLT</b>	Delete
<b>DSP</b>	Display
<b>MNT</b>	Maintain
<b>OLM</b>	Offline Maintenance
<b>PRT</b>	Print
<b>SBM</b>	Submit
<b>WRK</b>	Work with

Object abbreviations:

<b>CLN</b>	Component/Line Definition
<b>HRZ</b>	Horizon
<b>ILN</b>	Item/Line Definition
<b>ITM</b>	Item
<b>LOC</b>	Location
<b>OPT</b>	Option
<b>PKL</b>	Pick List
<b>PLN</b>	Plan or Planning
<b>PRL</b>	P.O. Auto Release
<b>PST</b>	Product Structure
<b>REL</b>	Release
<b>RTG</b>	Routing
<b>TGL</b>	Temporary General Ledger
<b>TXR</b>	Transaction Register
<b>USR</b>	User
<b>WHS</b>	Warehouse

---

## Application APIs

The application APIs are shipped in the form of System i commands. The application command may be named PRTxxxxyy, where xxxyyy is unique to each job. For example, the Print REP Pick List is named PRTREPPKL.

The Print REP Pick List requires you to enter the identifier of the warehouse to be used. After being automated, the PRTREPPKL command could be used from a menu:

```
PRTREPPKL PROMPT(*YES)
```

The command also can be used as part of an System i job, using a user-written CL program similar to this example that illustrates the PRTREPPLK command. The STRXAENV and ENDXAENV commands are required.

```
PGM
STRXAENV ENDS (NN)
PRTREPPLK PROMPT(*NO) ENDS(nn) WHID(ATL)
ENDXAENV
ENDPGM
```

If the application task being automated supports interactive prompts, the command would support a prompt parameter in addition to the application parameters required to run the job. The prompt parameter has values of \*YES and \*NO. If the prompt parameter is \*YES, the application parameters cannot be specified on the command. The purpose of the prompt parameter is to instruct the application to display the prompt screens or to use the parameter values associated with the command.

Each application command supports a parameter to designate the XA execution environment. The environment designator is used to validate that the function is being executed in the proper XA environment. Requiring this parameter is a precautionary measure to prevent functions from being executed inadvertently in the wrong environment. The environment designator is required and validated only when the application command is executed with a PROMPT value of \*NO.

## PRTREPPKL - Print REP Pick List

Print REP Pick List (PRTREPPKL)

Type choices, press Enter.

Prompt at run-time . . . . .	> *NO_	*YES, *NO
XA environment . . . . .	__	Character value
Warehouse . . . . .		Character value
From production line . . . . .	*FIRST	Character value, *FIRST
To production line . . . . .	*LAST	Character value, *LAST
From line location . . . . .	*FIRST_	Character value, *FIRST
To line location . . . . .	*LAST_	Character value, *LAST
From scheduled item . . . . .	*FIRST_____	
To scheduled item . . . . .	*LAST_____	
From component item . . . . .	*FIRST_____	
To component item . . . . .	*LAST_____	
From schedule number . . . . .	*FIRST_	Character value, *FIRST
To schedule number . . . . .	*LAST_	Character value, *LAST
Priority items only . . . . .	*NO_	*YES, *NO
Print schedule information . . . . .	*NO_	*YES, *NO
From required date . . . . .	*FIRST_	Date, *FIRST

More...

F3=Exit F4=Prompt F5=Refresh F12=Cancel F13=How to use this display  
F24=More keys

Print REP Pick List (PRTREPPKL)

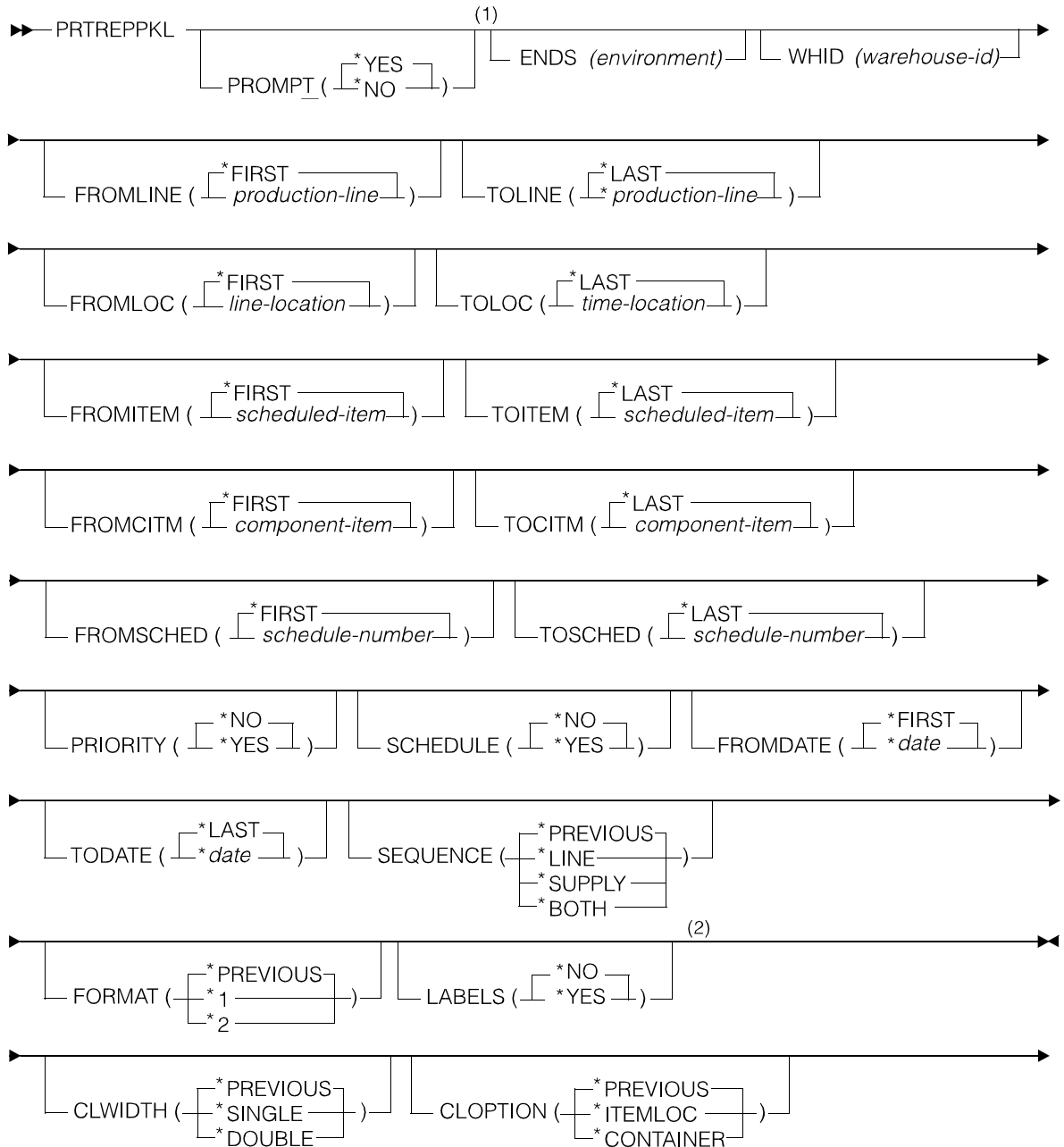
Type choices, press Enter.

To required date . . . . .	*LAST_	Date, *LAST
Print sequence . . . . .	*PREVIOUS	*LINE, *SUPPLY, *BOTH
Report format . . . . .	*PREVIOUS	1 =80 column, 2 = 132 column
Print container labels . . . . .	*NO	*YES, *N

Bottom

F3=Exit F4=Prompt F5=Refresh F12=Cancel F13=How to use this display  
F24=More keys

Pgm: B,I



Note:

<sup>1</sup> All parameters following this point cannot be specified unless PROMPT(\*NO) is specified.

<sup>2</sup> All parameters following this point cannot be specified unless LABELS(\*YES) is specified.

## Purpose

The Print REP Pick List (PRTREPPKL) command is used to print a listing of materials that are needed at a production line. Components appear on this list as a result of priming production lines, reporting replenishment transactions, or manual typing. See "RPRTREPPKL - Reprint REP Pick List" on page C-7 to reprint pick lists.

### Optional Parameters

**PROMPT** Specifies whether the function should prompt for the application values at run-time.

\*YES: Application should prompt user for run-time values.

\*NO: Application should use run-time values supplied by command.

**ENDS** Specify the XA environment designators to be validated when executing the command. If the environment designator specified here does not match the environment designator associated with the current System i job, this function will not execute. This will stop functions from inadvertently being executed against the wrong XA environment.

**WHID** Warehouse identifier.

**FROMLINE** From production line.

\*FIRST: From value will be blank.

production-line: The identifier of the first production line for which you want to print pick lists.

**TOLINE** To production line.

\*LAST: To value will be all 9's.

production-line: The identifier of the last production line for which you want to print pick lists.

**FROMLOC** From line location.

\*FIRST: From value will be blank.

line-location: The identifier of the first line location for which you want to print pick lists.

**TOLOC** To line location.

\*LAST: To value will be all 9's.

line-location: The identifier of the last line location for which you want to print pick lists.

**FROMITEM** From scheduled item.

\*FIRST: From value will be blank.

scheduled-item: The identifier of the first scheduled item number for which you want to print pick lists.

**TOITEM** To scheduled item.

\*LAST: To value will be all 9's.

scheduled-item: The identifier of the last scheduled item number for which you want to print pick lists.

**FROMCITM** From component item.

\*FIRST: From value will be blank.

component-item: The identifier of the first component item number for which you want to print pick lists.

**TOCITM** To component item.

\*LAST: To value will be all 9's.

component-item: The identifier of the last component item number for which you want to print pick lists.

**FROMSCHEd** From schedule number.

\*FIRST: From value will be blank.

schedule-number: The identifier of the first schedule number for which you want to print pick lists.

**TOSCHEd** To schedule number.

\*LAST: To value will be all 9's.

schedule-number: The identifier of the last schedule number for which you want to print pick lists.

**PRIORITY** Specifies whether or not to print only selected items that need to be replenished immediately.

\*NO: Prints all items.

\*YES: Prints only those selected items with priority codes.

**SCHEDULE** Specifies whether or not to print schedule information on the Pick List.

\*NO: No additional schedule information is printed on the Pick List.

\*YES: Prints the schedule date, scheduled item, and the production line for each component reference on the Pick List.

**FROMDATE** From required date.

\*FIRST: From value will be zero.

date: The beginning required date for which you want to limit the Pick List to print component material.

**TODATE** To required date.

\*LAST: To value will be all 9's.

date: The ending required date for which you want to limit the Pick List to print component material.

**SEQUENCE** Print sequence.

\*LINE: Line location sequence.

\*SUPPLY: Supply location sequence.

\*BOTH: Both line and supply location sequence.



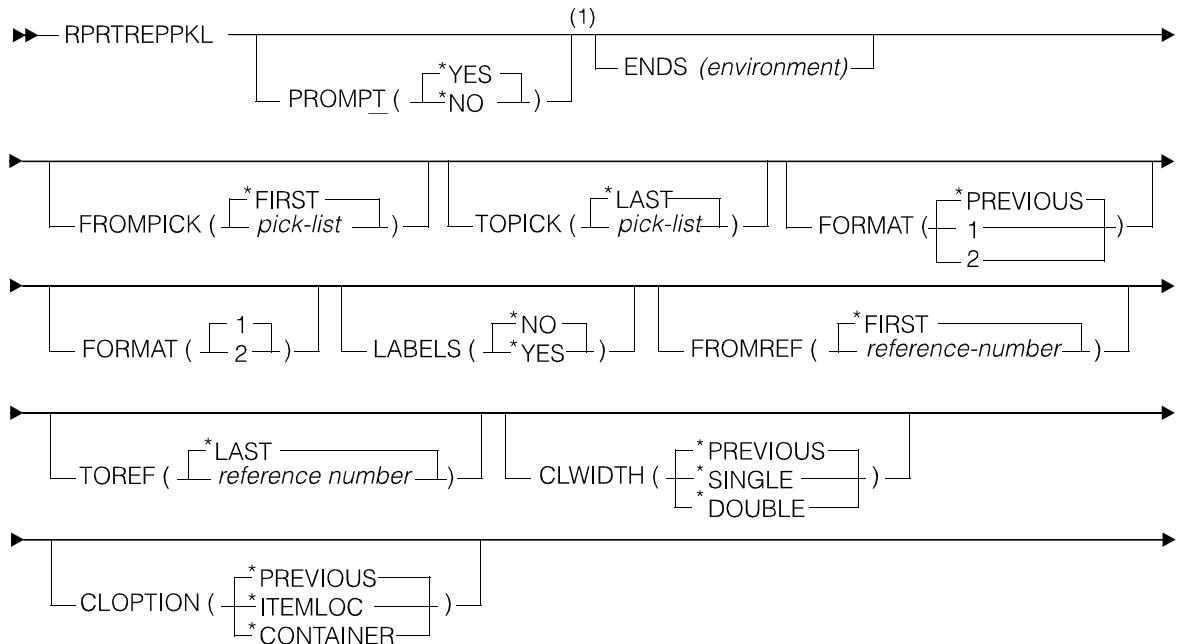
## RPRTREPPKL - Reprint REP Pick List

```

Reprint REP Pick List (RPRTREPPKL)
Type choices, press Enter.
Prompt at run-time . . . . . > *NO_          *YES, *NO
XA environment . . . . . _                  Character value
From pick list . . . . . *FIRST_           Number, *FIRST
To pick list . . . . . *LAST_             Number, *LAST
Report format . . . . . 1                  1 = 80 column, 2 = 132 column
Print container labels . . . . . > *YES    *YES, *NO
From reference number . . . . . *FIRST     Number, *FIRST
To reference number . . . . . *LAST       Number, *LAST
Label width . . . . . *SINGLE              *SINGLE, *DOUBLE
Print labels for each . . . . . *ITEMLOC_  *ITEMLOC, *CONTAINER

F3=Exit   F4=Prompt   F5=Refresh   F12=Cancel   F13=How to use this display
F24=More keys
Bottom
    
```

Pgm: B,I



Note:

- 1 All parameters following this point cannot be specified unless PROMPT(\*NO) is specified.
- 2 All parameters following this point cannot be specified unless LABELS(\*YES) is specified.

## Purpose

The Reprint REP Pick List (RPRTREPPKL) command is used to reprint Pick Lists.

### Optional Parameters

**PROMPT** Specifies whether the function should prompt for the application values at run-time.

\*YES: Application should prompt user for run-time values.

\*NO: Application should use run-time values supplied by command.

**ENDS** Specify the XA environment designators to be validated when executing the command. If the environment designator specified here does not match the environment designator associated with the current System i job, this function will not execute. This prevents functions from being executed against the wrong XA environment.

**FROMPICK** From pick list.

\*FIRST: From value will be 00001.

pick-list: The number of the first Pick List you want to reprint.

**TOPICK**

To pick list.

\*LAST: To value will be all 9's.

pick-list: The number of the last Pick List you want to reprint.

**FORMAT** Report format.

1: 80 column format.

2: 132 column format.

**LABELS** Specifies whether container labels should also be printed.

\*NO: Container labels should not be printed.

\*YES: Container labels should be printed.

**FROMREF** From reference number.

\*FIRST: From value will be 0001.

reference-number: The reference number of the first Pick List you want to reprint.

**TOREF** To reference number.

\*LAST: To value will be all 9's.

reference-number: The reference number of the last Pick List you want to reprint.

**CLWIDTH** Specifies whether you want container labels to be printed one or two to a page.

\*SINGLE: Only one label is printed.

\*DOUBLE: Two labels are printed.

**CLOPTION** Specifies whether you want labels printed for locations or containers.

\*ITEMLOC: Item/supply location.

\*CONTAINER: Container.

---

## Appendix D. Entry and release for orders and schedules

In XA, the term *release* has different meanings in different applications. This appendix describes the entry and release process in the applications using it. This appendix has two parts: an overview and a detailed explanation for each application

Overview.....	D-1
Summary .....	D-6
Details.....	D-7

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### Overview

The following XA applications have order or schedule entry, create, and/or release functions:

- InterSite Logistics (ISL/MISL)
- Inventory Management (IM)
- Material Requirements Planning (MRP)
- Order-Based Production Management (OBPM)
- Procurement Management (PM)
- Production Control and Costing (PC&C)
- Purchasing (PUR)
- Repetitive Production Management (REP)

**Order release** refers to releasing manufacturing orders, purchase orders, and intersite orders. Orders may be created by an application such as MRP or entered through a work station as in IM and then released. The **creation or entry** of the order puts information such as order number, part number, quantity, and due date into data entry batches. When you release the order, the open order files are updated with the information you entered along with other application generated information.

**Schedule release** refers to releasing manufacturing schedules (in REP) similar to the order release process used by manufacturing orders. However, it differs in the way in which schedules are entered and selected for release. The entry process does not use data entry batches, but instead uses a method of processing that bypasses the need for batch control.

Key elements to a manufacturing schedule are warehouse, production line, finished item, the quantity of the item to be built on the line, and the day the quantity is expected to be completed. When the schedule is released, the release process sets up the necessary database records to begin production. In addition to the release, the schedule must also be primed. Priming can be specified at the time of release or done later. Priming must occur before schedules can be reported against.

Releasing a manufacturing order authorizes production to begin on the order; therefore, the shop paperwork is usually produced at this time also. Releasing an intersite order authorizes the supplying warehouse to ship items to you. Releasing a purchase order authorizes a vendor to ship products to you or to perform services for you. Releasing either manufacturing orders, purchase orders, intersite orders, or schedules creates records in the open order files to track and report progress and costs.

The IM application is the cornerstone of order and schedule information. ISL/MISL, MRP, OBPM, PC&C, PM, PUR, and REP all have IM as a prerequisite. The order release functions of MRP and PC&C enhance order releasing in IM by supplying additional release function while REP's release function is all contained within its

application. REP also depends on EPDM or PDM to define production lines, reporting points, and component materials used in the manufacturing process. For IM and PC&C, EPDM or PDM are optional applications.

---

## Manufacturing orders

### Inventory Management

Releasing a manufacturing order in IM creates an order master record and an order detail record to hold the allocation information for each component required to complete the order. If the EPDM or PDM application are activated or interfacing, the allocations can optionally be created at order entry or at order release using bill of material information. If EPDM is activated, you can choose an item process to use with the order. Once the order is released, issues of the components are reported through IM and used to update the order detail records and the master record.

### Material Requirements Planning

MRP recommends that you release a manufacturing order based on the lead time and the future requirements for the item. Using the MRP order/schedule review and release function, you can approve an order for release. If EPDM is activated, you also can change its item process prior to releasing the order. IM is notified then and actually creates the open order records using its order release process.

### Order-Based Production Management

OBPM provides a customizable client interface to creating manufacturing orders. It provides most of the order entry and release function in IM, MRP, and PC&C. In addition, it provides a Reorder Recommendation object that lets you create orders easily for order point items requiring replenishment. It also allows you to copy existing released manufacturing orders or manufacturing history orders to create a new order. OBPM works with either EPDM or PDM.

OBPM also allows maintenance of all types of manufacturing order information, updating the IM and PC&C files.

### Production Control and Costing

By itself, PC&C cannot create or release manufacturing orders; it can, however, complete the order release process begun by IM.

There are four basic types of information about a manufacturing order in XA:

- Master data
- Material (component or allocation) data
- Operation (routing) data
- Miscellaneous charges.

In order release, IM controls the master and material information, and PC&C controls the operation routing and miscellaneous charge information.

During IM order release, you can create routings and enter miscellaneous charges as part of the order release process, or you can defer to PC&C to create routings and

enter miscellaneous charges at a later time. If you choose to create routings as part of the IM order release process, IM either calls a standard routing from EPDM or PDM routing files or allows you to type in an alternative routing. IM then passes the routing and any miscellaneous charges to PC&C programs, which automatically complete order release.

If you choose not to enter routing information or miscellaneous charges during IM order release, perhaps because the data is not available or must be provided by another department, you can create the master and material records through IM and then add the routing information and miscellaneous charges later using PC&C's order release options.

In either case, once order release is complete, you must make any further changes to the files through PC&C's file maintenance.

---

## Purchase orders

## Inventory Management

When a purchase order is released in IM, records are created in the open order files for tracking receipts against the order. IM does not print the actual purchase order. Once PUR or PM is installed, all purchase orders must be entered through one of those applications..

## Material Requirements Planning

MRP recommends the release of purchase orders in the same way that it handles manufacturing orders. Using the MRP order/schedule review and release function, you can authorize the release of a purchase order for an item. IM recognizes this activity and creates the open order records.

If Purchasing is installed and interfacing, you may choose to automatically create purchase orders and requisitions from the MRP planned order file of orders that have been recommended for release. If a requisition is created, the requisition number is posted into the MRP Planned Order file and the order becomes a firm planned requisition order. Then, PUR or PM can use the requisitions to create purchase orders after being reviewed by a buyer.

## Order-Based Production Management

OBPM provides a customizable client interface to creating purchase orders and requisitions from two client objects:

- MRP Recommendations (uses the MRP files)
- Reorder Recommendations (an OBPM file)

OBPM requires PM for these capabilities, and uses PM function to create and maintain purchase orders.

## Procurement Management

PM provides a customizable client interface to creating and maintaining purchase orders and requisitions. It allows you to combine multiple requisitions on one purchase order. It also allows you to copy existing purchase orders or purchase history orders to create a new order.

## Purchasing

When a purchase order is entered in Purchasing, order header and detail records are immediately created in the open order files. There is no separate process to release the purchase order.

---

## Intersite orders

### InterSite Logistics

InterSite Logistics (ISL/MISL) can release orders if MRP is not installed, or in exceptional circumstances, where there is no time to wait for an MRP order release or for an MRP planning run, if there is no planned order to release. The intersite order and the associated COM customer order in the supplying warehouse are created.

## Inventory Management

IM cannot create or release intersite orders. In fact, intersite orders are almost invisible to IM except that, since intersite orders are scheduled receipts being shipped from offsite, ISL/MISL maintains the quantity on order from intersite orders for an item as part of the on order from purchasing field in the Item Balance file. Therefore, the IM total on order for an item includes intersite orders.

## Material Requirements Planning

Typically it is best to release intersite orders in MRP, or in OBPM, the same way manufacturing and purchase orders are released. Minimal data entry is required using the review/approve and release functions, and the MRP files are updated as well. ISL/MISL interfaces with these functions, and creates the intersite order and the associated COM customer order in the supplying warehouse.

## Order-Based Production Management

OBPM provides a customizable client interface to creating intersite orders from two client objects:

- MRP Recommendations (uses the MRP files)
- Reorder Recommendations (an OBPM file)

OBPM requires InterSite Logistics for these capabilities, and uses ISL/MISL functions to create and maintain intersite orders.

---

## Manufacturing schedules

### Material Requirements Planning

Within MRP, you can review planned orders and exception messages related to schedule controlled items. However, you cannot release these planned orders, since this function is done solely from REP's Release Schedules menu option.

To assist you in working with MRP planned orders, REP provides an Extract Schedule Requirements menu option that copies the MRP planned orders to REP. Within REP, the MRP planned orders are shown as demand on the Enter and Maintain Schedules display. From this display, you can view "demand" and create or adjust schedules individually, or accept all demand as is, which automatically creates or adjusts schedules equal to demand. This latter function is known as Accept Proposed Change.

### Repetitive Production Management

Enter and Maintain Schedules is the focal point for determining manufacturing schedules based on an item's demand. Once these schedules are determined and entered, they can be released later through REP's Release Schedules menu option. This option allows a user to select by warehouse, production line, and horizon dates, which schedules are candidates for release. In addition, you can specify if a schedule is to be automatically primed when it is released and if component shortage reports are to be printed.



## Summary

For your daily operations, the applications you have installed and activated determine which entry and release activities you perform and which applications you use for those activities. The following table shows the recommended application in which to start order or schedule release for the various combinations of installed applications.

Orders/schedules	IM	IM MRP	IM PC&C	IM PC&C MRP	IM PUR	IM PUR MRP	IM EPDM/PDM REP	IM EPDM/PDM REP MRP	IM ISL/MISL MRP
<b>Manufacturing orders</b>									
Master data	IM	MRP	IM	MRP	IM	MRP	IM	MRP	MRP
Material data (allocations) <sup>a</sup>	IM	MRP	IM	MRP	IM	MRP	IM	MRP	MRP
Routing data <sup>b</sup>	n/a	n/a	IM or PC&C	MRP or PC&C	n/a	n/a	n/a	n/a	n/a
Miscellaneous charges <sup>c</sup>	n/a	n/a	IM or PC&C	IM or PC&C	n/a	n/a	n/a	n/a	n/a
<b>Purchase orders</b>									
Purchase orders	IM	MRP	IM	MRP	PUR	PUR	IM	MRP	MRP
Receiving routing	n/a	n/a	n/a	n/a	PUR	PUR	n/a	n/a	n/a
<b>Intersite orders</b>									
Intersite orders	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	MRP
<b>Schedules</b>									
Material data	n/a	n/a	n/a	n/a	n/a	n/a	REP	REP	MRP
Routing data	n/a	n/a	n/a	n/a	n/a	n/a	REP	REP	n/a
Replenishment data	n/a	n/a	n/a	n/a	n/a	n/a	REP	REP	n/a

Legend:  
n/a not applicable

- a. If EPDM or PDM is activated or interfacing, you can use the bill of material to create the allocation records in the open order files.
- b. If EPDM or PDM is activated or interfacing, you can use the standard routing to create the operation records in the open order files. With EPDM activated, you can override the default item process with an alternate.
- c. If AP or IFM is installed and interfacing, you can add miscellaneous charge records to the open order files at a later time through AP or IFM.

**Notes:**

1. OBPM is not included in the above table because it provides a customizable client interface as an alternative to creating manufacturing, purchase, and intersite orders using the “base” applications shown in the table. IM and PC&C are always required for OBPM, and ISL/MISL, MRP and PUR or PM are required for certain OBPM functions.
2. PM is not included in the above table because it provides a customizable client interface as an alternative to creating purchase orders using PUR, which is required for PM.

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## Details

### The open order data base

All orders and schedules are stored in the open order data base.

- Manufacturing orders have a record in the Manufacturing Order Master file indicating the item to be made, a record in the Manufacturing Order Detail file for each component that goes directly into making that item, and a record in the Manufacturing Order Routing Detail file where one record per operation is stored.
- Purchase orders have one record in the Purchase Order Item Detail file for each item to be purchased. If the item is to be shipped in several installments through a blanket order, there is a record in the Purchase Order Blanket Release Detail file for each shipment, or release, of that blanket order. If Purchasing is installed and interfacing, each purchase order has a record in the Purchase Order Master file and at least one record in the Purchase Order Item Detail file.
- Intersite orders have a record in the Intersite Order file and an associated COM order in the supplying warehouse for the item being transferred.
- Schedules entered but not released are called unreleased schedules. They are reserved in the MOMAST order master file as status 00 records. These records are created when the schedule is initially entered in Enter and Maintain Schedules. When the schedule is released, the status code changes to a status 10 and component records are created in the MODATA allocation file based on the item's bill of material in the PSTRUC product structure file. In addition, operation records are created in the MOROUT operations file from the routing records for the finished item in EPDM or PDM. If priming is selected, replenishment records are created based on a component's supply rules as defined in the ITMLIN item/line definition file.

### InterSite Logistics order release

Intersite orders can be released either from planned orders in MRP using the review/approve and release functions, or in ISL/MISL using the work orders and release functions. In either case, an intersite order record is created in the Intersite Order file and an associated COM order is created in the supplying warehouse.

### Inventory Management order release

#### Manufacturing orders

If the IM-to-EPDM or PDM interface is activated, IM order entry allows you to bypass the individual entry of each of the components needed on a manufacturing order. If you enter REL or NOW in the manufacturing order entry field **B/M**, IM order release uses the parent item number and, through the Item Master file, retrieves from the Product Structure file all the component items needed to manufacture that item. This is single-level retrieval. If EPDM is activated and the order is associated with a site, the process identifier determines which bill of material is used to retrieve the component items needed.

The parent item is copied, along with other master manufacturing order data, into a record in the Manufacturing Order Master file. Each component item is copied, along with extended order quantity and unit cost data, into a record in the Manufacturing Order Detail file. The method of unit costing to be used is determined during

application tailoring. The Manufacturing Allocated Quantity field (MALQT) for component items and the On-Order Production Quantity field (MPRPQ) for parent items in the Item Balance file are updated at the end of order release.

If the IM-to-PC&C and IM-to-PDM interfaces are activated and PDM has its optional Routing file, IM order entry allows you to bypass the individual entry of each of the operations needed on a manufacturing order. When YES appears in the manufacturing order entry field **RTG**, IM order release uses the parent item number and, through the Item Master file, retrieves from the Routing file all the operations (including inactive) to manufacture that parent item. If EPDM is activated and the order is associated with a site, the process identifier determines which routing is used to retrieve the operations.

Operation times from the Routing file and rates for those operations from the Work Center Master file are copied into a record in the Manufacturing Order Routing file for each operation.

In addition, if the IM-to-PC&C interface is activated, IM order entry allows you to enter miscellaneous data. This includes anything not covered by assigned material or labor, such as consumable supplies or outside operations. Any miscellaneous data from IM order entry is put into the Manufacturing Order Miscellaneous Detail file by IM order release.

At the conclusion of IM order release, you can print shortage reports that indicate shortages on manufacturing orders, if you specified those reports during installation.

## Purchase orders

IM allows you to track purchase orders that you create manually. Data about the purchase order is entered in IM order entry.

You also can enter purchase orders with blanket releases. If you enter YES in the purchase order entry field **BLNKT**, you see a display on which you enter due date and quantity for each blanket release. These orders can be for individual items only; you can have only one item number on any one blanket purchase order.

For each item number/warehouse combination, IM order release copies the purchase order data into a record of the Purchase Order Item Detail file; each of the blanket releases for the purchase order has its own record in the Purchase Order Blanket Release Detail file.

The On-Order Purchase Quantity field for parent items in the Item Balance file is updated at the end of order release.

Consigned or subcontracted orders (where material is supplied to the vendor) should be handled as manufacturing orders.

If Purchasing is interfacing, the IM Reorder Report can generate purchase orders automatically and send them to PUR.

## Split orders

You may need a portion of an existing manufacturing order quantity before it is due, or you may need to start work on a manufacturing order that is short some components. IM allows you to split off a portion of the manufacturing order and send it ahead. You

can have up to nine splits per manufacturing order. IM order release creates one additional record in the Manufacturing Order Master file for each split order while updating the Quantity in Split Orders field in the base (original) manufacturing order's Manufacturing Order Master file record. The materials (components) on a manufacturing order are assumed to be issued to the base order, so no material records are automatically created in the Manufacturing Order Detail file for split orders. If EPDM is activated, you can split an order associated with a site as long as the split is for the same site and item revision.

If the IM-to-PC&C interface is activated, you specify the beginning operation for the split order in IM or PC&C. However, if you decide to split an order after activity has been reported on the original order and you are using milestone reporting, this splitting can be done only before or at a milestone start operation or after a milestone stop operation.

### **Manufacturing order per customer order**

This IM function requires both the IM-to-EPDM or PDM and IM-to-COM interfaces to be activated. If you enter the customer order number on the IM order entry display, each release on that customer order appears for approval. Pressing the **Enter** key causes action identical to that of entering a manufacturing order with B/M = REL or NOW. It also puts the customer order number in the Customer Job Number field in the Manufacturing Order Master file. B/M = KEY is not allowed here if the end item has features and options.

IM order release is the same as for regular manufacturing orders.

Customer orders can be for standard items, items with features/options, or items configured by the Knowledge Based Configurator (KBC). For standard items, you can use any option available regarding the bill of material and routing for the item, depending on whether EPDM or PDM is in use.

For items with features/options, the bill of material that was determined when the customer order was entered (and stored with the customer order) is used for the manufacturing order.

For KBC configured items, the bill of material and routing for the item that were built by KBC when the customer order was entered (and stored in KBC) are used for the manufacturing order.

### **Summary—Inventory Management order release**

- Reads the Order Release Data Entry file for order data entered through IM.
- Completes the creation of master records (started in IM order entry): Manufacturing Order Master records for manufacturing orders and Purchase Order Item Detail records for purchase order items.
- Creates detail records: Manufacturing Order Detail records for manufacturing order component items and Purchase Order Blanket Release Detail records for purchase order blanket releases.
- Prints shortage reports specified in the IM Questionnaire.
- Updates the Manufacturing Allocation Quantity (MALQT) field for component items in the Item Balance file.

- Updates the On-Order Production Quantity (MPRPQ) field and the On-Order Purchase Quantity (MPUPQ) field for purchase order items in the Item Balance file.

**Note:** The orders that are released are only those entered through IM order entry; no planned orders from MRP are handled by order release selected from IM.

At the conclusion of order release, all closed batches in the Order Release Data Entry file have their status changed to finished (if REUSE = NO) or available (if REUSE = YES).

## Material Requirements Planning order release

MRP has no order entry. It generates requirements for components of master level items (MLIs) based on MLI requirements entered, propagated, or accepted from Master Production Schedule Planning (MPSP). The on-hand and on-order quantities by date are subtracted from requirements generated, and the net requirements then are offset by lead time, resulting in dated planned orders. If EPDM is activated, the primary item process that is active on the planned order's start date is assigned to the order. Since planned orders are suggestions only, someone must indicate agreement with MRP through Review/Approve and then run order release from MRP.

### Summary—Material Requirements Planning order release

- If the MRP-to-IM interface is activated, calls the IM order release procedure and copies planned orders from the Order Review file to Batch 999 of the Order Release Data Entry file. Batch 999 is reserved for this purpose. If the MRP to IM interface is deactivated, orders cannot be released using this interface.
- Prints the Order Action Detail report for those planned order exceptions that could not be performed. This report is needed to do file maintenance in IM to existing manufacturing and purchase orders.
- If the MRP-to-IM interface is activated, updates the Planned Order and Order Review files to reflect newly released manufacturing and purchase orders and adjusts in the Requirements file any associated component requirements that were generated by the MRP planning run. These requirements now have been allocated. If the MRP-to-IM interface is deactivated, prints the Planned Order Error List, showing planned orders approved but not released.
- If ISL/MISL is installed, releases intersite orders and associated COM orders in the supplying warehouse, and updates the Planned Order and Order Review files accordingly.
- If the MRP-to-MPSP interface is activated, component-generated requirements will be adjusted based on the quantity of the order that was released and on the amount of the component allocations. Planned and firm planned orders are adjusted in MPSP by the amount of the order released in MRP. Planned and firm planned orders are updated to show that the orders are released.
- If EPDM is activated, you can override the primary item process with an alternative item process before releasing the order.

## Order-Based Production Management order create

- **Manufacturing orders.** OBPM allows manufacturing orders to be created from item warehouse records, customer order line items, MRP planned orders, and from the OBPM Reorder Recommendations object containing order point items requiring replenishment. It also allows you to copy an open manufacturing order

or manufacturing history order to create a new order. While creating the order, you can use bills of material and routings from either EPDM or PDM, or import them from other items or manufacturing orders.

- **Purchase orders.** OBPM allows purchase orders to be created, if PM is installed, from MRP planned orders and from the OBPM Reorder Recommendations object containing order point items requiring replenishment.
- **Intersite orders.** OBPM allows intersite orders to be created, if ISL/MISL is installed.

In all cases, OBPM creates the order directly in the IM, PUR, or ISL/MISL files.

## Procurement Management order create

- Purchase orders. PM allows purchase orders to be created from one or more requisitions and, if OBPM is installed, from MRP planned orders and from the OBPM Reorder Recommendations object containing order point items requiring replenishment.

PM creates the order directly into the PUR files.

## Production Control and Costing order release

PC&C by itself cannot create or release manufacturing orders. Rather, it allows you to split order release between two departments, Inventory and Production Control, so that Production Control can make last-minute decisions on which work centers to use, based on backlog or on the availability of facilities.

Because of this flexibility, you can choose either to release the order entirely through IM or to complete the release of the order through PC&C. The method you use is determined by your company's policy, but the difference is largely a matter of whether you choose to establish routings through IM or through PC&C. You can also enter miscellaneous charges through either application.

- **Order release completed by IM.** If you choose to use standard routings by answering yes to the routing question on display AMI4A4 (RTG=Y), IM automatically releases the order by creating a manufacturing order record in the Manufacturing Order Master file (MOMAST), retrieving standard routing information from PDM's Routing file (ROUTNG), and passing that information to PC&C's order release programs. These programs create a routing record in the Manufacturing Order Operation Detail file (MOROUT). If you have entered miscellaneous charges, records are also created in the Manufacturing Order Miscellaneous Detail file (MOMISC). As far as the operator is concerned, the order is released completely through IM; PC&C's part in order release is not visible. Any changes to the miscellaneous detail or to the routings can be entered later through PC&C's file maintenance.

If you choose not to use standard routings (RTG=N), you can type in alternative routings and miscellaneous charges, if there are any. IM releases the order automatically, using PC&C's programs, but without using PDM's standard routings. Records are created in the Manufacturing Order Master file (MOMAST), in the Manufacturing Order Operation Detail file (MOROUT), and, if there are miscellaneous charges, in the Manufacturing Order Miscellaneous Detail file (MOMISC). Any changes to these files can be made later using PC&C's file maintenance.

- **Order release completed by PC&C.** If you choose not to use standard routings (RTG=N), but do not choose to type in alternative routings or miscellaneous charges through IM, IM passes the order to PC&C for completion of the order release process. In this case, IM creates records in the Manufacturing Order Master file (MOMAST), but not in the Manufacturing Order Operation Detail file (MOROUT) or the Manufacturing Order Miscellaneous Detail file (MOMISC).

Whoever is responsible for decisions about routings, operation sequence, and miscellaneous and labor charges can complete the release of the order using PC&C's order release options.

In PC&C, as in IM, if EPDM or PDM is also activated or interfacing, you can choose standard routings by typing Y in the SELECT ROUTING field on the PC&C Order Release—Summary Selection display (AMC200), or you can enter alternative routings.

You can enter miscellaneous charges in PC&C on the Order Release—Miscellaneous Detail display (AMC202); or, if AP or IFM is installed and interfacing, you can record miscellaneous charges using those applications.

Whether you complete order release through IM or through PC&C, you can release an order only once. Once miscellaneous detail records are written to MOMISC, or operation details to MOROUT, you must make all changes through file maintenance.

### Summary—Production Control and Costing work file release

- Reads the Order Release Data Entry file for operation and miscellaneous data entered.
- Creates detail operation records in the Manufacturing Order Miscellaneous Detail file and connects them to their existing parent manufacturing orders in the Manufacturing Order Master file.
- Prints the Operations Detail Addition report.
- Prints the Miscellaneous Detail Addition report.
- Updates the above-mentioned Manufacturing Order Master file records with the remaining operation/miscellaneous data.

## Purchasing order create

- Purchase orders. PUR allows purchase orders to be created from one or more requisitions and, if MRP is installed, from MRP planned orders, directly from MRP order release. You also can enter a purchase order directly.

## Repetitive Production Management Schedule Release

REP's schedule release process can be divided into three main segments:

- Entering schedules
- Selecting schedules
- Releasing schedules

### Entering schedules

Entering schedules is an online interactive process that allows you to intelligently create a schedule by viewing demand and production line capacity information. It may be ideal to have a production schedule equal demand for a specific date, but if the

capacity to build the schedule is not attainable, then the schedule is not valid. For this reason REP presents both item demand and line utilization information on a single display. This presentation helps a planner develop realistic schedules that meet both criteria.

Before you can enter schedules, you must have created an Item/Line definition of the finished item you want to produce. The Item/Line definition describes an item's manufacturing rates for a specific production line and the component supply technique that it will use. If EPDM is activated, the Item/Line definition considers revisions and item processes.

Schedules are entered using the REP menu option Enter and Maintain Schedules. This option allows you to select the warehouse within which you want to work and then select a sequence of viewing items. You can select to see items by primary production line, planner, or merely in ascending item sequence. If you select by production line or planner, all items having a primary production line or planner specified in their item balance record are shown for the line or planner specified.

Data on the initial Enter and Maintain Schedules display is shown by item and presents a composite of information for all production lines the item is scheduled on. Displayed are total demand quantities, total scheduled quantities, the differences between total demand and what is scheduled, plus total production line utilization for all lines the item is scheduled on. If an item is dedicated to a single production line, then obviously the information shown is a composite of a single item. The purpose of this display is to allow you a view of how schedules are meeting demand and the status of production line capacity in relation to the schedules that have been released.

When you choose one of the dates shown on the initial display, the Enter and Maintain Schedules Detail display appears. The Detail display shows you the total demand for the day, the quantity scheduled to be produced, and the line utilization for each production line on which you currently have a schedule. On the Detail display, you can create schedules or change schedule due dates, quantities, and the production line on which a schedule is run. Schedules that have not been started can be cancelled by changing the schedule quantity to zero.

Using information from the Detail display, you can use function keys to assist in creating or changing schedules. You can create a schedule using the Schedule Add function key. This function key shows a display that allows you to create a schedule for a quantity on a specific date or on a range of dates. If a range of dates is selected, the schedule quantity is prorated over the number of consecutive days you specified. The created schedule is placed in the MOMAST file with a status code of 00.

The Use Proposed Change function key allows you to create or alter schedules to make the scheduled quantity meet the daily demand. Proposed Change is the difference between a day's Net Demand and the quantity scheduled to be produced that day. You can press the function key, after selecting a specific day on the Schedule Entry and Maintenance display, and schedules will be created or altered as needed to meet the daily demand. You also can select a specific schedule on the Detail display and have that schedule's quantity increased or decreased by the proposed change. If you have production constraints that dictate a minimum or maximum production quantity, the schedule quantities are lot sized to fit within the constraints.

Before selecting a schedule for release, the Detail display allows you to navigate to other displays where you can see more information in preparation for schedule release. One display, Material Check, allows you to do an on-line component availability check to help determine if there are any known component shortages.



Another display, Sequence Schedules, allows you to order the sequence in which schedules may be built on a specific date.

### **Selecting schedules for release**

Schedules are selected for release through the Release Schedules menu option. This option allows you to selectively choose schedules for release based on a status code of 00 in the schedules header record. On the Release Schedules Selection display, you can choose the warehouse, the release horizon, the production line you are interested in, and whether a shortage report should print. From this criteria, the application will build a subfile of schedules and display them for your review on the Released Schedules display. Key information shown is planned schedule start date, due date, production line, warehouse, item, description, and reference field. From this list of schedules, you can selectively choose a specific schedule, or all schedules. You can also decide at this time to prime a schedule when it is released.

### **Releasing schedules**

Schedule release merely takes the schedules that you have selected and updates the released schedules data base. The files that are updated were identified previously in the section that describes the open order data base. Any changes to the schedules must be accomplished on the Enter and Maintain Schedules display for date and quantity changes, or the Released Schedule Maintenance display if there are material or operation changes.

### **Summary—Repetitive Production Management Schedule Release**

Schedule entry and release functions can be found on REP's Schedule Management menu. From this menu you can select the following options:

- Extract schedule requirements to bring in schedules from MRP, COM, or the schedule demand interface file
- Enter and maintain schedules to create and change REP schedules
- Select and release schedules to update the released schedules data base.

## Glossary

This glossary defines terms that are important for this application. It does not include all XA terms nor all terms established for your system. If you do not find the term you are looking for, refer to the Index in this book or to glossaries in other XA publications.

This glossary includes definitions from:

- The American National Dictionary for Information Processing Systems, copyright 1982 by the Computer and Business Equipment Manufacturers Association (CBEMA). Copies may be purchased from the American National Standards Institute, 1430 Broadway, New York, New York 10018. Definitions are identified by symbol (A) after definition.
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**active.** (1) The code that designates an operation or component as being active, or inactive. (2) Primed schedules where the last transaction has not been reported against it.

**additional routing operation description.** See routing operation description.

**adjusted quantity per.** The quantity of the component item required to make a standard batch quantity of the parent item. This number includes adjustment for operation yield. See also quantity per.

**adjustment.** A transaction that changes a specific balance in a master file, such as the quantity on hand of an inventory item.

**allocation.** The reserving of available inventory for a requirement.

**alpha factor.** A constant that is used in an exponential smoothing weighted averaging approach. It determines how much weight should be given to current demand in relation to past demand.

**alphanumeric.** Pertaining to a character set that contains letters, digits, and usually other characters, such as punctuation marks. (A)

**alternate routing code.** The code that determines which additional operations are added to the routing.

**application.** A use to which a data processing system is put; for example, keeping a record of a company's inventory.

**application program.** A program that performs a particular data processing task; for example, one that produces an inventory report or payroll checks.

**application tailoring.** The process of selecting application options to satisfy the specific needs of a company, based on user answers to the Install/Tailor questionnaire.

**assembly.** The combination of two or more items to make a new item.

**audit trail.** (1) Data, in the form of a logical path linking a sequence of events, used for tracing the transactions that have affected the contents of a record. (T) (2) Information that allows tracing of the history of things such as a customer account or item record.

**available.** The net quantity not yet committed to a production schedule. (Onhand plus on order minus allocated.)

**average cost.** The cost of each piece of an item in inventory arrived at by dividing the total value of the item by the number of pieces in inventory.

**back order.** An order prepared to cover items which cannot be included in the original shipment, but which will be sent when available.

**backflush.** The relief (issue) of inventory by exploding the bill of material against the production count of an assembled end item. In the Inventory Management application, controlled floor stock components are relieved using the backflush technique when an item is reported as received to stock from production or when manufacturing scrap is reported.

**backup copy.** A copy of a file or library member that is kept for reference in case the original file or library member is destroyed. The backup copy can be stored on disk, diskette, or tape.

**backward scheduling.** The technique of beginning with an order due date and offsetting by operation and setup times (modified by efficiency factor) to determine the last operation's start date. Dates for prior operations are determined in a similar manner, taking into account the wait or queue time at subsequent operations. This is continued until the first operation is scheduled. Contrast with forward scheduling.

**batch/lot control code.** The code <Y/N> indicating if an item requires batch/lot control.

**batch/lot number.** The field allowing unique identification of a specific batch or lot of an item. When an item is defined as having batch/lot control, all transactions involving that item must carry the batch/lot number.

**batch.** (1) A group of records or data processing jobs brought together for processing or transmission. (2) Pertaining to activity involving little or no user interaction. Contrast with interactive.

**batch number.** The sequential number assigned by the application to identify the batch.

**bill of material.** A list of raw materials or components and the quantities needed to make an item, assembly, or end product. See modular bill.

**blow through.** The process, during a bill of material explosion, of incorporating the components of the phantom item (rather than the phantom item itself) into material allocations.

**build to order.** A type of product that is assembled from a menu of standard features and options to meet a customer specification for an end item.

**bulk store area.** An area in a warehouse that is reserved for items that are not QC, batch/lot, or FIFO date controlled; for example, packaging materials or shipping containers. Each warehouse can have up to 99 bulk store areas and each bulk store area can contain up to 999 items. In addition, bulk store area 01 (ST 01) can be defined as a Work-in-Process area for storage of uncontrolled floor stock.

**capacity.** A measure of the ability of existing resources (labor and machines) to absorb orders released to the shop floor.

**carry forward.** The calculated carry forward quantity. (Schedule quantity minus quantity completed from previous day). If the previous day's schedule is part of a summary, the carry forward quantity is a net cumulation of the carry forward function for the summary schedule. If carry forward is not selected, the schedule variance quantity will be shown. The schedule variance is the difference between the number of units scheduled and the number of units completed.

**changeover.** The time required to set up or tear down a production line in order to begin producing the first item of the schedule.

**character.** A digit, letter, or other symbol that is used as part of the organization, control, or representation of data.

**close.** To make a file unavailable for processing.

**completion code.** The code indicating the status of an order. Shows if the order is complete, partially complete, reopened, or has had no activity (receipts).

**component.** The material used in the production of the scheduled item. Contrast with parent.

**configuration.** The combining of features and options with the modular (common) bill of material to produce one variant of an item.

**control log.** A document, generally posted daily with summary totals from other reports, that is used to prove that all entries affecting a master file or ledger have been properly posted and that the master file or ledger itself is correct.

**controlled warehouse.** A warehouse where an item can be stocked in more than one location and can optionally carry quality control codes, batch/lot numbers, and FIFO dates. Controlled warehouses are designated during application tailoring.

**critical item.** In material requirements planning, an item that has a longer than normal lead time, or an item whose scarcity may limit production. See also lead-time.

**cumulative material lead time.** The sum of lead times (to any assembly level) on the longest lead time string in a level-by-level bill. It can vary for each item.

**cumulative yield.** The percentage of the parent item completed through the last operation compared to the quantity originally put into production. See also operation yield.

**current cost.** Latest expected cost derived from engineering standards (material and labor) in association with current labor and overhead rates. Also called current standard cost.

**current operation yield.** A percentage of the expected parent quantity at the end of a routing operation compared to the quantity at the beginning of an operation based on the current environment.

**current standard cost.** See current cost.

**cursor.** A movable, visible mark used to indicate the position at which the next operation will occur on the display surface. (I) (A)

**cycle time.** The length of time between completions of the finished items.

**data.** A representation of facts, concepts, or instructions in a formalized manner suitable for communication, interpretation, or processing by humans or automatic means. (I) (A)

**data base.** A set of data, part or the whole of another set of data, that consists of at least one file, and that is sufficient for a given purpose or for a given data processing system. (I) (A)

**data entry.** The process of putting data onto a machine-readable medium; for example, to enter data into payroll file on a flexible disk from terminal. (T)

**dedicated.** Pertaining to a mode of operation in which a procedure requires all the resources of the system.

**default.** An alternative attribute, option, or value that is assumed when none has been specified by the user.

**delete.** To remove an object or unit of data such as a character, field, or record.

**delivery location.** The location on the production line where the component is normally delivered.

**demand.** The required shipment of an item in a specific time period. (Orders for shipment in some future time period are not considered part of the current period's demand.)

**discrete allocations.** The ability to selectively allocate items to manufacturing or customer orders. Items are allocated by specific batch/lot, location, and/or FIFO date.

**discrete order quantity.** A rule for determining order size using the period's net requirements as a lot size.

**disk storage.** Direct access storage that uses one or more magnetic disks to store data files and programs.

**diskette.** A flexible, magnetic disk enclosed in a protective container. (I) (A)  
Diskettes are a removable medium used to store information until it is required for processing.

**due date.** The date by which the work on a shop order or schedule is to be completed or a purchase order is to be received.

**edit.** To verify the form or format of data; for example, to test a data field such as customer number.

**effectivity date from.** The date an engineering change is designated to become effective.

**effectivity date to.** The date an engineering change is no longer in effect.

**efficiency factor.** The ratio of standard to actual hours of work performed in a facility; for example, 98 standard hours divided by 90 actual hours equals 1.09 efficiency factor. It is used to modify labor standards.

**end item.** The item received from production that corresponds to a level in the bill of material. After final assembly, the end item is a finished good (the product shipped to the customer).

**engineering change.** A change made to an item to reduce its cost or improve its function, serviceability, or safety.

**engineering drawing.** The output from a product's design phase.

**enter.** To type in information on a keyboard and press the Enter key to send the information to the computer.

**entry.** The act of recording a transaction in the master file.

**entry date.** The date on which a transaction is entered into a master file.

**execute.** (1) To perform the actions specified by a program or a portion of a program. (T) (2) To carry out an instruction.

**explosion.** The calculation of how many of each of the items listed in a bill of material are required to produce a given quantity of the item represented by the bill. For example, if 500 of product A are required and A is composed of two Bs, three Cs, one D, and four Es, the explosion determines that 1000 Bs, 1500 Cs, 500 Ds, and 2000 Es are needed.

**exponential smoothing.** A mathematical technique that simplifies calculating historical weighted averages and reduces the need for retaining historical data. It is superior to normal weighted averages because it allows more recent periods to be weighted in the average more heavily than older periods.

**fabricated part.** An item manufactured, made, or worked on as opposed to an item assembled or put together.

**facility.** The equipment and physical structures used for production of finished goods.

**feature.** The options of an end item are grouped by feature. A feature can only have end items as parents and options as components. An end item can have multiple features and a feature usually has multiple options. See also option and S-number.

**field.** In a form, display, or record, a specified area used for a particular category of data. For example, the area on a display that is regularly used to show an item number.

**FIFO.** First in first out.

**FIFO control.** The ability to identify inventory based on the date received.

**FIFO date.** The date the item was received in stock, whether at approved or unapproved status. This field appears on displays and reports only if FIFO control is active. On Transaction Processing audit trails, the FIFO date field defaults to the transaction date if FIFO control is not active.

**file.** An organized collection of related records treated as a unit.

**file name.** An arbitrary symbol created by the programmer or program to identify and refer to a collection of related records.

**finished goods.** Items ready for shipment to a customer, including parts reserved for service.

**first in first out (FIFO).** A method of valuing inventory which assumes that items are consumed in the same sequence in which they are received. Contrast with last in first out (LIFO).

**flow time.** The elapsed time (in hours) required to produce one unit of a scheduled item on a continuously operating production line.

**forecast.** An estimate of customer (independent) demand for an item for a specific period in the future.

**forward scheduling.** The technique of beginning with an order start date and adding planned queue time to determine the start date of the first operation. The subsequent operation start dates are determined by adding setup and run time (modified by efficiency factor) for the previous operation plus queue time at the operation. Contrast with backward scheduling.

**gross requirements.** The required quantity of an item from all sources, such as higher-level subassemblies or the master production schedule.

**historical standard cost.** See standard cost.

**inspect on receipt code.** The code indicating if an item requires inspection on receipt to confirm that it meets design or shelf life standards.

**inspection.** The examining of completed production or purchased items to see that parts meet tolerances and that work has been properly completed. It may or may not be a separate operation.

**interactive.** Pertaining to a program or system that alternately accepts input and then responds. An interactive system is conversational; that is, a continuous dialog exists between user and system. Contrast with batch.

**interface.** The hardware and programs that permit exchange of information between computer systems or among devices. The facility to allow information to pass from one application to another.

**inventory accounting.** The bookkeeping aspect of inventory management. It covers the processing, control, and audit of transactions that affect actual or planned availability of inventory.

**IPL.** Initial program load.

**issue cost.** The transaction cost of the material issues to a schedule.

**issues.** The amount of inventory released for production or sale.

**item.** Any raw material, manufactured or purchased part, subassembly, assembly, or end-item.

**item data.** Data describing products, the component parts and raw materials from which they are made, the bill of material, and the routing indicating the manufacturing process.

**item rate.** The cycle time or number of pieces per hour for the production line/item combination.

**job queue.** A list of jobs waiting to be processed

**kit.** Usually a group of loose components in a bill of material; sometimes handled as an assembly.

**labor cost.** The cost of labor associated with the production schedule.

**last cost.** The cost per unit of an item, taken from the last costed receipt.

**last in first out (LIFO).** A method of valuing inventory using the cost of the goods received last as the cost of the goods consumed. Contrast with first in first out (FIFO).

**lead time.** (1) The number of days, weeks, or months needed to place an order, process it, and receive the material into inventory. (2) An estimate of the time required in the shop from order release to availability.

**level.** A relative point in the bill of material (product structure). Levels help describe assembly dependencies. A level-0 item is shipped to the customer. Raw material is the lowest level (highest level number) in a company's product structure.

**LIFO.** Last in first out.

**line item.** A line of information appearing on a customer or purchase order that identifies the item wanted.



**load.** (1) To enter data or programs into storage; for example, to load a master file.  
(2) The amount of capacity required for manufacturing facilities (usually by time period) based on the master production schedule, the material requirements plan, and standard operating times.

**lot sizing.** The procedure for determining the planned order quantities from a schedule of net requirements.

**MAD.** Mean absolute deviation.

**manufacturing lead time.** The elapsed time from point of order to receipt in the stockroom of a manufactured item. It is calculated by summing the average queue time in each work center and adding setup, run, and move time.

**manufacturing order.** An order issued to the factory to produce a component or assembly.

**master file.** A file that is permanent, even though its contents may change.

**master level.** The level in a structured bill of material at which the master production schedule items appear. It is usually either level 0 or 1, depending on the type of product.

**master production schedule (MPS).** A statement of how many of what items (products and options specified by customers) are planned to be produced and when. It is the major control point for planning the level of manufacturing activity. The master production schedule is one of the major inputs to material requirements planning.

**material requirements planning (MRP).** The technique of planning the acquisition of items required to produce products stated in a master production schedule.

**maximum container.** The maximum number of containers that are planned to be in process at the delivery location.

**mean absolute deviation (MAD).** The average forecast error.

**milestone operation group.** A set of manufacturing operations defined as a single reporting unit. Shop floor activity for all operations in the group is reported as a total when the last operation in the group is finished.

**milestone sub-operation.** Any of the individual operations in a milestone group.

**minimum balance.** The stock required to cover expected customer demand during the time it takes to order and receive new stock, plus safety stock. See also safety stock.

**mode.** A method of operation; for example, enter/update mode.

**modular bill.** A bill of material containing only the parts common to a group of similar end items. Often a bill for a basic product, stripped of any features and options.

**MPS.** Master production schedule.

**MRP.** Material requirements planning.

**multiple items code.** The code <Y/N> that indicates if more than one item can be stored in a location.

**multiple lots code.** The code <Y/N> that indicates if more than one lot can be stored in a location.

**net requirements.** The requirements remaining after on hand and released orders have been subtracted from gross requirements.

**offline.** Pertaining to equipment or devices not under control of the processing unit.

**offline data entry.** A form of data entry in which data is read into the computer from offline files.

**on hand.** (1) Pertaining to stock that is immediately available for shipment. (2) Pertaining to items available in the stockroom and within shelf life. Stock now on the receiving dock or issued to the shop floor is not considered on hand stock.

**online update.** The process of updating master files immediately upon receiving a transaction from a work station.

**open.** To prepare a file for processing.

**open item.** Any active transaction within a file

**open order.** See released order.

**operation.** A manufacturing or assembly procedure performed on an item. A routing defines the sequence of several operations.

**operation sequence number.** A number assigned to an operation which defines the sequence within a routing.

**operation where used.** A field associated with a component showing the first routing operation number where the component is used in production.

**operation yield.** The percentage of the expected parent quantity at the end of an operation compared to the quantity at the beginning of an operation. See also cumulative yield.

**option.** An option is an item that is one of many items directly related to a feature. An end item can have many options, and similar options are categorized in groups called features. For example, the option red could be included under the feature color. When you request an end item on a report, you can also specify the options you want to see by entering them using the S-number. See also S-number and feature.

**order.** (1) A request from a customer for goods to be delivered or services to be performed. (2) An authorization to purchase or manufacture.

**order closeout.** The final processing of an order and removing it from the open order file.

**order priority.** A numeric value, normally calculated by the computer, that is used to sequence events. The due date of the order, or some variation of it, is the most common priority for shop orders.

**order quantity.** The quantity ordered when releasing an order.

**order release.** (1) In customer order processing, authorization to fill a customer's order. (2) In manufacturing, authorization to assemble or fabricate a product identified by a shop order.

**overhead costs.** All costs that cannot be applied directly to an item (shop order).

**overhead rate.** A factor to be applied to direct labor cost; it is used to recover (or distribute) overhead costs.

**overlap.** The sending ahead of part of a shop order to the next operation before the entire order has been processed at the current operation. Contrast with splitting orders.

**paging.** Displaying the records in a file in sequence on a work station. Using this facility, you can read through an entire file rather than see just one record, as when you use inquiry.

**parent.** The item produced at each level of the bill of material by the assembly of its parts and raw materials. The term parent defines a relative hierarchy in a bill. For example, the parent produced at level 3 in the bill is composed of the components appearing at level 4, and the parent produced at level 4 is composed of components appearing at level 5. Contrast with component.

**partial shipment.** The code that determines if a customer will accept a shipment of part of his total order.

**password.** In computer security, a string of characters known to the computer system and the user, who must specify it to gain full or limited access to the system and the data stored in it.

**phantom bills.** Bills of material for subassemblies that are automatically fed to a higher-level assembly without intermediate stocking. Their use is not considered a level of production.

**pick list.** A list of items to be taken from stock.

**planned order.** An order, which specifies delivery date and quantity, developed in a material requirements planning system. It should become a firm order when the order release date on the schedule is within the cumulative material lead time. It is used to plan lower-level component requirements or capacity requirements. A planned order is not committed to the vendor or shop floor until it is released.

**planner.** The person responsible for planning replenishment for manufactured and purchased material.

**planning lead time.** The sum of order handling lead time, plus quoted (vendor) lead time or manufacturing lead time, plus safety lead time. It is used by material requirements planning to offset component requirements from the due date of the higher-level assembly in which they are used. It represents an estimate of the

average elapsed time from the point of recognizing the need to order until receipt in the stockroom. See manufacturing lead time.

**process sheet.** Documentation stored near the work center that describes in considerable detail the operation to be performed. Synonymous with routing.

**product structure** A technique for organizing bills of material on a computer.

**production facility.** A facility can be either a work center, production line, or work station. A facility is a machine or group of machines with similar characteristics that are used to perform a manufacturing process; for example, an assembly area or milling machine center. It describes the area (group of workers or machines) in which the operations contained in the Routing file are performed. You can have run machine, run labor, setup labor, and overhead standard rates associated with it.

**production line.** A series of pieces of equipment dedicated to the manufacture of a specific number of products or families.

**purchase order.** A document sent to a vendor requesting goods or services.

**quality control code.** The code <Y/N> indicating if an item is subject to quality control inspection during its shelf life.

**quantity.** The number of batches of the standard batch quantity. The number is used to extend (multiply by) the quantity per for each product structure relationship.

**quantity per.** The quantity of a component item required to make a standard batch quantity of the parent item. See also adjusted quantity per.

**queue.** (1) A waiting line or list formed by items in a computer system waiting for service; for example, jobs to be performed. (2) In manufacturing planning systems, the backlog of work waiting to be processed at a work center.

**reactivate.** To change the status of a record in a file from suspended to active.

**reason code.** A user-defined code that indicates the reason for a transaction; for example, NR for not to be reworked.

**receipt cost.** The costs associated with completed units that were received on the schedule.

**receipts.** Merchandise or stock that is received in inventory.

**receiving location.** The location in which the finished item is stocked, upon completion on the production line.

**record.** (1) A collection of related data that is treated as a unit. For example, one line of an invoice could constitute a record. (2) To store data on a reusable input/output medium, such as a disk, diskette, or tape.

**reference.** A user-defined field that is used to cross reference one piece of information with another.

**register.** A record for the consecutive entry of a certain class of events, documents, or transactions, with a proper notation of all the required particulars.

**release date.** The date on which a planned order is reviewed for release to the shop floor. See also start date.

**released order.** An order that has been issued to the shop floor or a vendor. Once released, it is a commitment that can only be canceled or rescheduled.

**reporting point.** The code that identifies an operation where transactions can be reported.

**requirements.** The required quantity of an item needed to fill an order. See scheduled requirements.

**requisition.** An authorization to purchase materials or release quantities of items from stock.

**resource unit.** Material that is necessary for the production of a finished item.

**rework.** Defective fabricated parts that are sent through extra operations to correct the defect.

**routing.** A list describing the sequence of operations required to make an item.

**routing operation description.** A record providing descriptive information about a manufacturing routing in addition to that contained in the original routing record. Multiple records can be used.

**run time.** The elapsed time an item is actually being operated on in a work center. It is calculated by multiplying order quantity by time per piece.

**safety stock.** The quantity of an item carried in excess of expected demand to meet unexpected increases in demand.

**schedule.** (1) The quantity of an item to be produced on a production line for a specific date. (2) To determine start dates and due dates for shop orders.

**schedule date.** The date when the item's schedule is due to be completed.

**schedule hours.** The number of hours allocated to the schedule.

**schedule number.** The control number assigned to each schedule in the data base by the system.

**schedule quantity.** The quantity of the item released to production on the schedule.

**scheduled requirements.** The required quantity of a component, calculated from the bill of materials, needed for a manufacturing order.

**scrap.** (1) The unusable by-product from an operation or a ruined part or assembly that cannot be used in later production. (2) To separate ruined or unusable parts from the current production lot and report the quantity set aside.

**scrap cost.** The cost of labor, materials, and overhead incurred in the production of scrapped items.

**scrap factor.** See shrinkage factor.

**service part.** A part, assembly, or kit shipped to a customer for maintenance purposes.

**session.** The elapsed time between operator signon and operator signoff.

**session date.** The date associated with a session. If a session date is not entered, the session date becomes the same as the system date. See also system date.

**setup.** The procedure (costs) associated with getting a production facility (machine) ready to produce a new item. The procedure is not usually dependent on the number of items to be produced. For the sake of simplicity, the costs of removing the setup (teardown) are usually included. Contrast with teardown.

**shop packet.** The necessary documents for processing a shop order or schedule.

**shrinkage factor.** A percentage used to increase the quantity on a planned or released shop order to allow for scrap. An alternate method is to use it to increase gross requirements.

**S-number (Select-number).** Indicates the set of options you want for the end item for this retrieval. One option number for each feature for a specific end item can be entered in the S-number. See also feature and option.

**smoothing code.** The code that specifies if and how smoothing is applied to an item in production.

**smoothing start date.** The date when the production smoothing function is to begin. The smoothing date overrides the smoothing code.

**splitting orders.** The practice of dividing the original order into multiple orders and expediting a smaller quantity than was originally started. It is costly because of additional setup and material handling. It is of limited value unless run times are long. Contrast with overlap.

**staging.** The practice of pulling components from inventory and placing them in special areas well in advance of actual need.

**standard batch quantity.** A quantity of the parent item relative to the quantity of each component item. The product structure (recipe or formulation) is expressed in relation to a batch quantity of the parent item as opposed to a quantity of one stocking unit.

**standard cost.** Costs derived from engineering standards for material and labor.

**standard operation yield.** A percentage of the expected parent quantity at the end of an operation compared to the quantity at the beginning of an operation based on the projected "annual standard."

**start date.** The date work is to begin on an order. This is when materials are picked and delivered to the first work center. See also release date.

**stocking location.** The default location from which parts are taken to supply production line requirements.

**supplier.** See vendor.

**supply location.** The location that supplies components to line delivery locations.

**suspend.** An Item Balance file record can be suspended to limit activity against it. For example, if an item is suspended, no new orders can be processed against it. This might be done if an item is being phased out.

**system date.** The date assigned by the system operator during initial program load. Generally, the system date is the same as the actual date. See also session date.

**teardown.** Dismantling of assembly jigs, cleaning of vats or machines, etc. Contrast with setup.

**tool number.** Items used primarily in fabrication and normally identified with a particular operation on a routing.

**transaction.** An exchange between a work station and another device that accomplishes a particular action or result; for example, the entry of a customer's deposit and the updating of a customer's balance. An item of business, such as receipt of an order or paying a bill.

**transaction code.** A two-character code that identifies inventory activities such as issues, receipts, scrap, inspect, etc.

**transaction date.** The date a particular transaction was entered against an item.

**transaction file.** A file containing relatively transient data that, for a given application, is processed together with the appropriate master file. (I)

**transaction history.** A sequential record of all transactions related to a major accounting activity. For example, an inventory transaction history includes all transactions related to or affecting inventory balances and costs.

**transaction register.** A list of transactions (issues, receipts, and adjustments) affecting the balance of material on hand.

**uncontrolled item.** An item that does not require batch/lot control.

**uncontrolled warehouse.** A warehouse where an item can be stocked in only one location. Quality control, batch/lot control, and FIFO dates are not available. Uncontrolled warehouses are designated during application tailoring.

**unit cost.** The cost per component which the manufacturer is charged to produce a single unit.

**unit of measure.** A code indicating the measurement basis for inventory such as each, pound, tons, gallons, or feet.

**update.** To modify a master file with current information according to a specified procedure.

**user ID.** (1) A special ID assigned to an operator only if you use security. It is not the security password. The ID appears on report headings with the label OPER if you use security. (2) A string of characters that uniquely identifies a user to a system.

**user sequence.** The user-designated sequence number, together with the component item number, is used to establish the sequence of the bills of material.

**variance.** The difference between standard and actual performance. Variance analysis can be applied to costs, labor or machine hours, counts and balances, etc.

**vendor.** A seller of goods or services.

**warehouse.** The warehouse from which components are issued and the finished items are received.

**where-used.** A report or inquiry showing what higher-level assemblies use an item (the next level or all levels) or what operations are performed in what facilities. It is a tool for maintaining the engineering and production data base.

**work center.** A facility, normally a group of machines having similar characteristics, used to perform a manufacturing process; for example, an assembly area or milling machine center. Describes the area (group of workers or machines) in which the operations contained in the Routing file are performed. Can have run machine, run labor, setup labor, and overhead standard rates associated with it.

**work-in-process area** A stock location containing items released to the shop floor and not reported finished; for example, raw materials, subassemblies, and component parts.

**work order.** See manufacturing order.

**work station.** A device that lets a person transmit information to or receive information from a computer, or both, as needed to perform a job.

**yield factor** See shrinkage factor.



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