



QAD Adaptive Applications
Enterprise Edition

User Guide

QAD Production Execution

Overview
Using Production Execution

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Change Summary

Product Name Changes

Starting in September 2019, the new name for QAD’s complete portfolio of products is QAD Adaptive Applications. Additionally, QAD Adaptive ERP is the new name for QAD’s flagship ERP solution. QAD Adaptive ERP includes the functionality previously associated with QAD Cloud ERP and QAD Enterprise Applications - Enterprise Edition, plus the QAD Enterprise Platform and Adaptive UX which resulted from the Channel Islands program. Going forward, the terms QAD Enterprise Applications, QAD Cloud ERP, and Channel Islands will be deprecated but will remain in previous documentation and training materials. QAD’s intention is to—as soon as possible—eliminate the use of the deprecated terms going forward.

Change Summary

The following table summarizes significant differences between this document and previous versions.

Date/Version	Description	Reference
January 2020 /v2019	Initial Release	--

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Chapter 1

Overview

This chapter discusses the following topics:

Introduction 2

Advanced Technology Links 2

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Introduction

Production Execution is a QAD Labs solution that provides shop floor operational capabilities. Activities related to Production Orders, equipment, and operators are brought together in a touch-friendly HMI. The solution can scale from manual production and labor reporting, up to automated reporting from PLCs that is connected to QAD QMS and EAM for end-to-end operational control.

These extensions into operational activity are a continuation of QAD's vision to provide a foundation for enhanced collaboration between planning and execution as well as a contextual data source for analysis and traceability.

Advanced Technology Links

Data Lake

All events in Production Execution are captured in the Cassandra Data Lake, which is a core component of the QAD Enterprise Platform. Benefits include the following:

- Capturing significant events in the Data Lake enables organizations to retain a rich historical view of everything without overloading the transactional ERP database.
- Event-related data becomes a foundation for machine learning.
- Information in the Data Lake unlocks new ways of approaching traceability

Industrial Internet of Things

The Industrial Internet of Things (IIoT) is enabled by Production Execution's ability to connect with PLC through Ignition, a foundational component. Ignition has a cross-platform OPC UA server with an open and pluggable driver system that supports Modbus TCP, UDP, TCP/IP, Allen-Bradley, Siemens, Omron, and more.

QAD Production Execution takes advantage of several core Ignition capabilities:

- HMI (Human Machine Interface)
- Architectural flexibility
- Offline capability

QAD QMS

- Document management
- Training validation

QAD Automation Solutions

- Component Replenishment Requests
- Packaging Requests



Using Production Execution

This chapter discusses the following topics:

Worker Role 4

Supervisor Role 18

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Worker Role

The worker role has access to the Work Centers and Alarms screens.

Work Centers

The Work Centers screen contains the following tabs:

- **Production Orders.** A browse that displays the production orders that have been released to the work center.
- **Order View.** Displays detailed information about a specific production order.
- **Material Request.** Displays the components that have been consumed at the work center as well as the gross requirements. Material replenishment requests can be made from this screen.
- **Inventory.** Displays the inventory (raw materials and finished goods) currently stored at the work center. Workers can scrap or remove inventory and/or print labels for finished goods.
- **Equipment.** Displays detailed information about the equipment at the work center, including the current production state (Production, Paused, Stopped) and the historical records of any events (maintenance requests, material replenishment requests, changes in production state). Workers can request maintenance and can start or stop production from this screen.

Production Orders

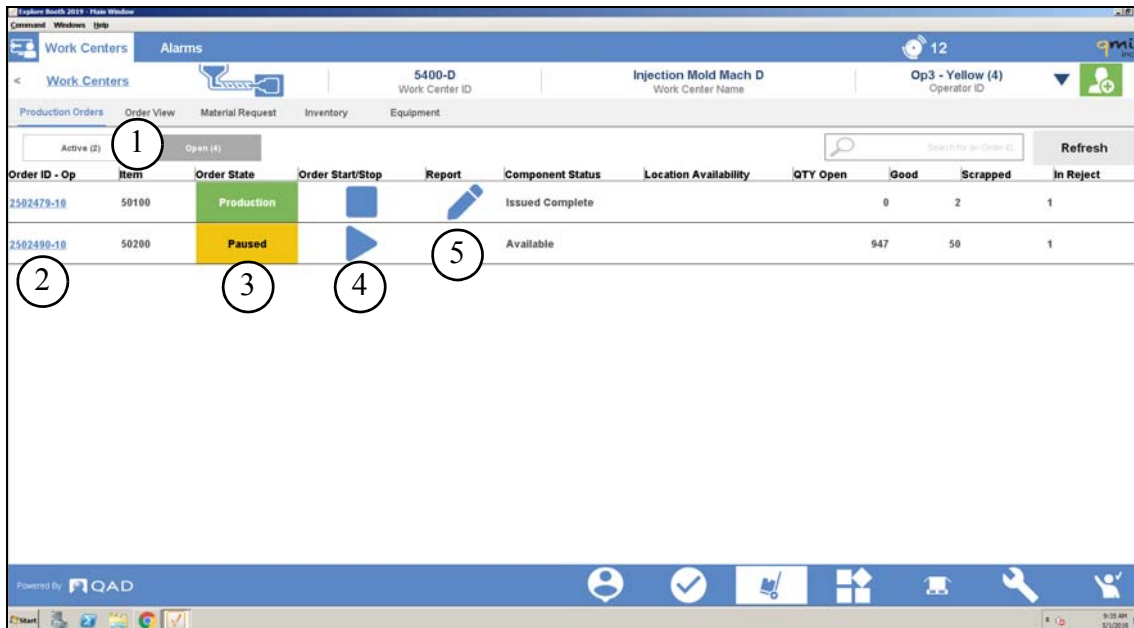
The Production Orders view displays the production orders that have been released to the work center and the current state of those production orders. From this screen, users can:

- Start, stop, or complete work on a production order.
- Report production on an order, including quantities produced, scrapped, or suspect.

This screen is available to both Supervisor and Worker roles.



Fig. 2.1
Work Center - Production Orders Screen



Key	Description
1	Toggle between active and open orders.
2	Click/touch to open Order View. Only orders that are released from MSW are displayed.
3	Displays the current state of the order (Production, Paused, ...). The state is based on the Start/Stop event.
4	Start or Stop an order based on current Order State. Press the Play button to start an order. Press the Stop button to pause an order.
5	Press the Pencil button to report production. The Pencil button is only displayed and active when the order is in Production state.

The production order browse contains the following fields:

Order ID - Op. Displays the production order number. Select this number to navigate to the Order View screen.

Item. Displays the item number on the production order.

Order State. Displays the current state of the production order. Example of order states include Production, Paused, etc.

Order Start/Stop. Select the button to start or stop the production order. Press the Play button to start an order. Press the Stop button to pause an order.

When the Start/Stop button is selected, the Change Order State window displayed where the user can select the specific action that needs to take place (Pause Production, Stop Production, or Complete Order).

Report. Select the Pencil button to report production on the production order at the work center. When the Report Production screen is displayed, where the user can enter how many items have been produced, scrapped, or are suspect. The Pencil button is only displayed and active when the order is the Production state.

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Component Status. Displays the overall status of the part at the manufacturing site.

- Available
- Issue Complete

Location Available. Displays the availability of the component at the work center location against the remaining to issue or backflush.

Qty Open. Displays the open quantity on the order.

Good. Displays the total number of items that have been produced that are considered good.

Scrapped. Displays the total number of items that have been scrapped during the production on this order.

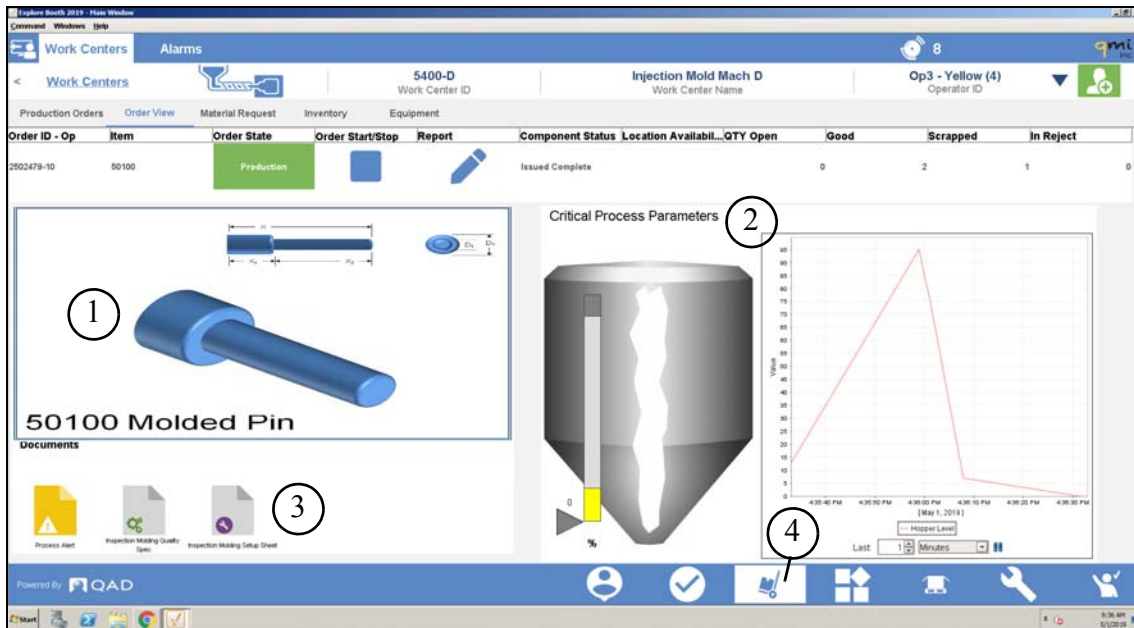
In Reject. Displays the total number of items that have been flagged as suspect during the production on this order.

Order View

The Order View displays more detailed information on a specific order. This view displays the image of the part, which is linked from the item master, as well as a live view of the machine at the work center. From this screen users can perform the following actions:

- Start, stop, or complete work on a production order.
- Report production on an order, including quantities produced, scrapped, or suspect.
- Activate/Deactivate material requests
- Open documents that are linked to the quality documents managed by QAD QMS CEBOS.

Fig. 2.2
Work Center - Order View Screen



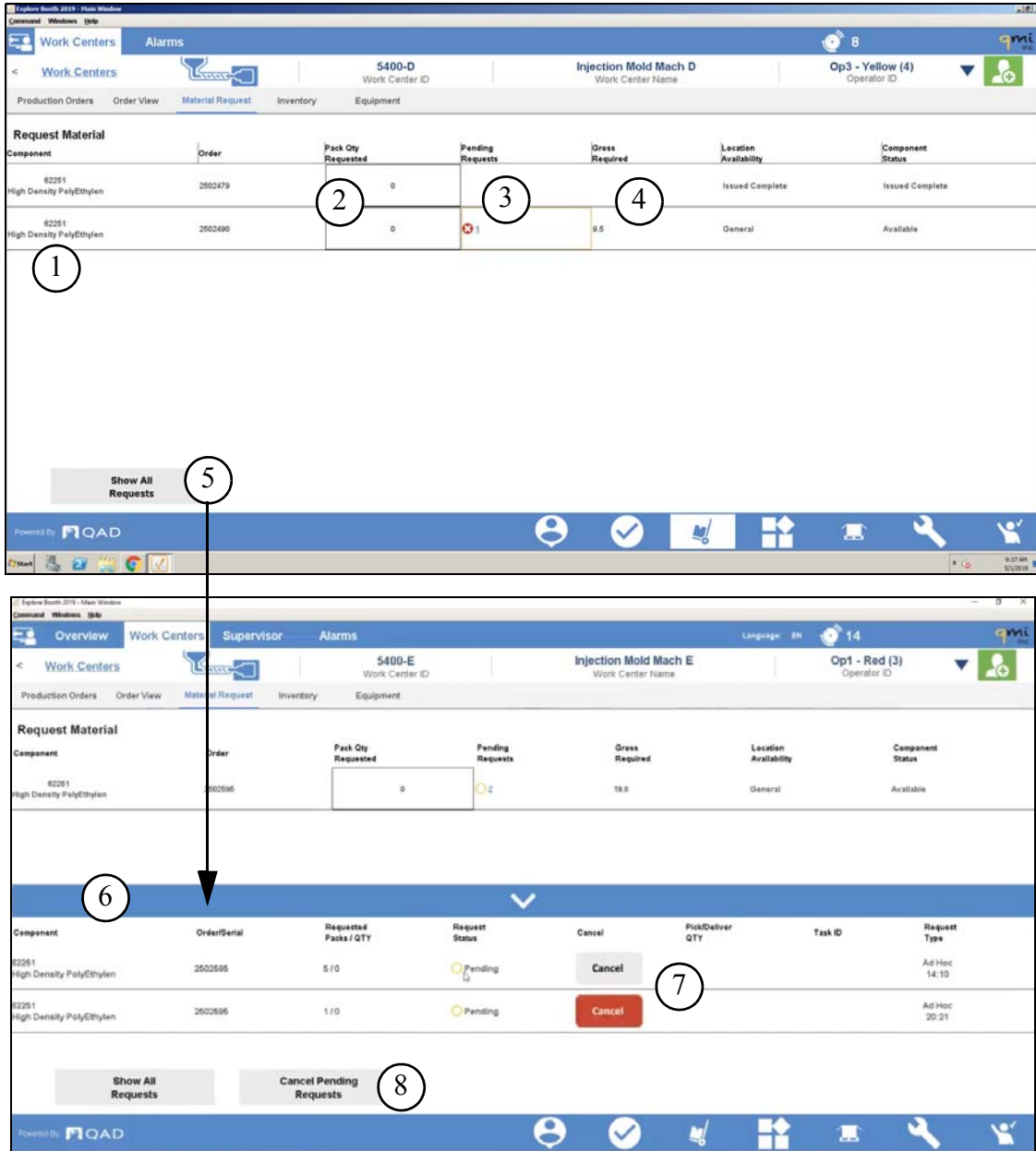
Key	Description
1	Displays an engineering drawing that is linked to the Item Master.
2	Shows critical process parameters that are being pulled from PLCs. This window displays a simulation of the machine at the work center. For example, if this was an injection molded machine, the graphic/animation would display the weight of the pellets that are currently in the hopper, being melted down to produce the finished part. This window shows the live view as well a a historical view.
3	Select any document to open an on screen .pdf view. These documents are linked to the documents managed in QAD QMS (CEBOS). For example, these document could show setup information on the work center or technical information related to the finished product.
4	Select this button to activate/deactivate requests. Far right has summary

Material Request

The Material Request screen displays the components that have been consumed and backflushed at the work center as well as the gross requirements of the components. From this screen, users create material requests or cancel any pending material requests.

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Fig. 2.3
Work Center - Material Request Screen



Key	Description
1	Displays the component item on the material request.
2	Select this box to request material for the production order. When this box is selected, a number pad is opened allowing the user to enter the quantity to be requested.
3	Displays the number of requests that are currently pending.
4	Displays the gross requirements for this component on the production order.
5	Select the Show All Requests button to view the details on any pending requests. When this button is pressed, a browse is displayed giving the user the ability to cancel an requests that were made in error or are not required anymore.



6	The Pending Request browse is displayed when the Show All Requests button is selected. This browse displays detailed information about each material request. It also allows users to cancel an individual material request as well as cancel all pending material requests.
7	Select the Cancel button to cancel a specific material request.
8	Select the Cancel Pending Requests button to cancel all the pending material requests displayed in the Pending Request browse.

Request Material Browse

Component. Displays the component item on the material request.

Order. Displays the production order number.

Pack Qty Requested. Select this box to request material for the production order. When this box is selected, a number pad is opened allowing the user to enter the quantity to be requested.

Pending Requests. Displays the number of requests that are currently pending.

Gross Required. Displays the gross requirements for this component on the production order.

Location Availability. Displays the availability of the component at the work center location against the remaining to issue or backflush.

Component Status. Displays the overall status of the part at the manufacturing site.

Pending Request Browse

Component. Displays the component item on the material request.

Order/Serial. Displays the serial ID that will be delivered, if available.

Requested Packs/Qty. Displays the number of packs or the quantity of inventory that was requested.

Request Status. Displays the status of the request being delivered to the line.

Cancel. Select the Cancel button to cancel a specific material request.

Pick/Deliver Qty. Displays the quantity that has been picked by a material handler to deliver for this request.

Task ID. Displays the specific warehouse task ID that was generated to fulfill this request.

Note This field is only relevant if Automation Solutions: Warehousing Extension is being used in combination with Production Execution.

Request Type. Displays whether the material request was generated automatically or ad hoc.










Inventory

The Inventory screen displays the inventory levels at the specific work center. The browse displays the finished goods and raw materials that are currently stored at the work center location. From this screen, users can:

- Scrap or remove raw materials.
- Scrap, remove, or reprint labels for finished goods.

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Fig. 2.4
Work Center - Inventory Screen

Item	Description	Action	Status	Location	Quantity	Serial ID	Lot/Serial	Reference
00100	Pin Assembly - Star		Pending	5500A	5	10200C000637		
00251	High Density PolyEthylene		Pending	5500A	5			
00100	Pin Assembly - Star			5500A	2	10200C000651		
00100	Pin Assembly - Star			5500A	5	10200C000638		
00100	Pin Assembly - Star			5500A	5	10200C000635		
00100	Pin Assembly - Star			5500A	10	10200C000633		
00100	Pin Assembly - Star			5500A	10	10200C000610		
00100	Pin Assembly - Star			5500A	40	10200C000609		
00100	Pin Assembly - Star			5500A	100	10200C000608		

Key	Description
1	Select the Pencil to perform an action against the raw materials or finished goods located at the work center. For raw materials, users can perform a scrap or remove transaction. For finished goods, users can perform a scrap, remove, or reprint label transaction.
2	When an action is take place against the item at the work center, this field displays the status of that action, such as Pending.

Item. Displays the item number of the raw material or finished good that is located at the work center.

Description. Displays the description of the raw material or finished good.

Action. Select the Pencil to Select the Pencil to perform an action against the raw materials or finished goods located at the work center. For raw materials, users can perform a scrap or remove transaction. For finished goods, users can perform a scrap, remove, or reprint label transaction.

Status. When an action is take place against the item at the work center, this field displays the status of that action, such as Pending.

Location. Displays the work center location ID.

Quantity. Displays the item quantity that is located at the work center.

Serial ID. Displays the serial ID associated with the item located at the work center.

Lot/Serial. Displays the lot/serial ID associated with the item located at the work center.

Reference. Displays reference information associated with the item located at the work center.

Equipment

The Equipment screen shows detailed information about the equipment at the work center. This screen displays the current status of the machine and well as historical data about each event that has been logged against the machine. Users can start or stop production on the machine and submit maintenance requests.

Fig. 2.5
Work Center - Equipment Screen



Key	Description
1	This graphic represents the equipment at the work center. The color and arrows indicate the state of the equipment: <ul style="list-style-type: none"> When the color is green and the arrow is pointed up, the machine is running. When the color is red and the arrow is pointed down, the machine is stopped.
2	This window shows detailed information about the state of the equipment including: <ul style="list-style-type: none"> The current state (Available, Stopped) How long the machine has been in that current state Maintenance requests that have been created for the machine
3	The Event History window displays every event that has been created against this machine, including, start/stop down times, maintenance requests, log in/out times, and so on.
4	The Initiate WC Down Event and Return WC to Available buttons allow users to start and stop the machine: <ul style="list-style-type: none"> Initiate WC Down Event. Press this button to stop the machine. When the machine is paused/stopped, the color of the equipment turns to red and the arrow points down. Return WC to Available. Press this button to start the machine. When the machine is started, the color of the equipment turns to green and the arrow points up.
5	The Equipment State History window shows the start and stop events that have been initiated during a specific period of time.
6	Slide the time bar to view the equipment state history for different time of the day. When the slider is moved back and forth, the Equipment State History window displays the start and stop events that were initiated during that period.

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Event History Window

Description. Displays the description of the event.

User Name. Displays the user who initiated the event.

Qty Produced. Displays the quantity of items produced if the event is associated with reporting production.

Time. Displays the date and time the event occurred.

Equipment State History

Status. Displays the equipment status during the start or stop event.

Reason Description. Displays a description of the event.

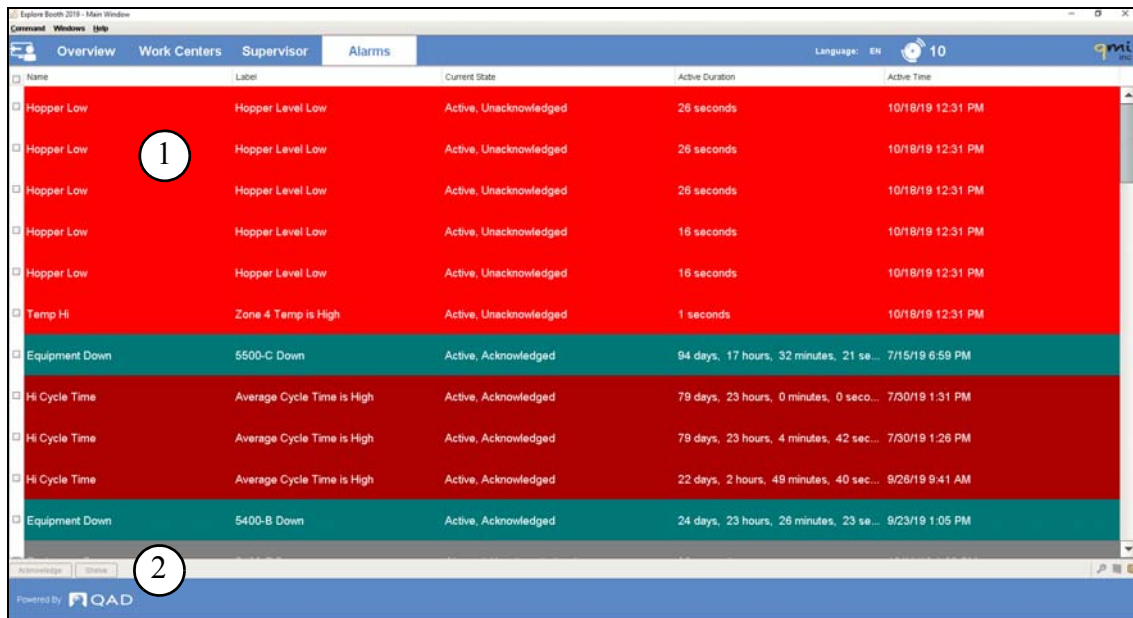
Start Time. Displays the date and time when the event was initiated.

End Time. Displays the date and time when the event was stopped.

Alarms

The Alarms screen displays the alarms that have been triggered the equipment at the work center.

Fig. 2.6
Alarms



Key	Description
1	The browse displays the alarms that have been triggered by the equipment at the work center.
2	Select the Acknowledge or Shelve buttons to address an alarm.

Name. Displays the type of alarm that was triggered by the machine.

Label. Displays a short description of the alarm.



Current State. Displays the current state of the alarm and if any action has been taken to address the alarm. For example, “Active, Unacknowledged” means the alarm is currently in the active state and the alarm is has not been acknowledged by selecting the Acknowledge button.

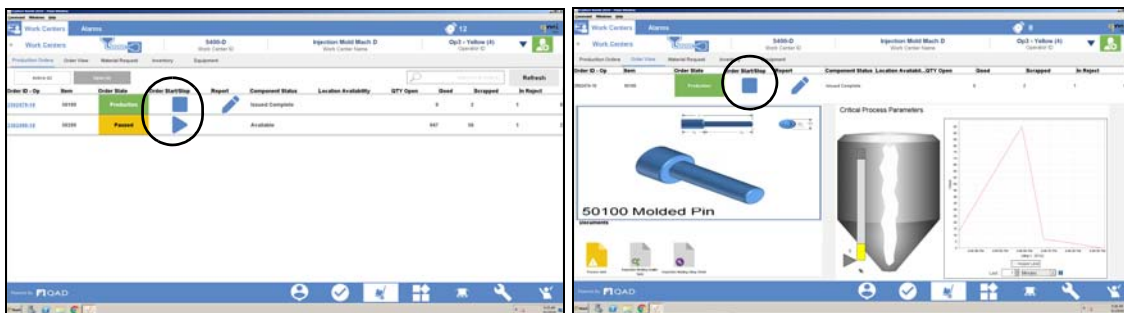
Active Duration. Displays the amount of time the alarm record has been active.

Worker Actions

Changing Order State

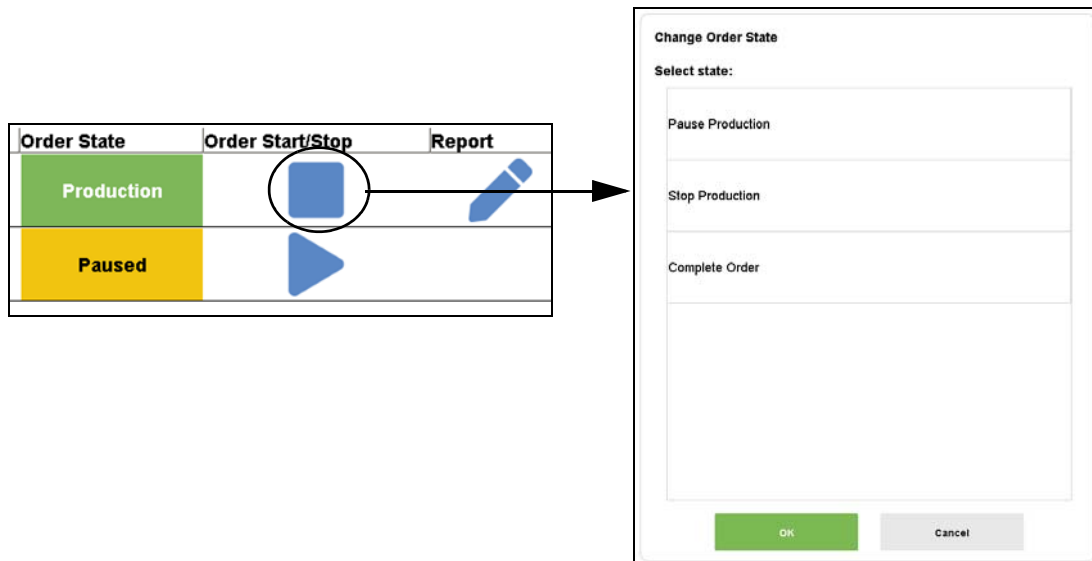
Users can change the order state from either the Production Orders or Order View screens.

Fig. 2.7
Changing the Order State



To change the state, select the Start/Stop button and then select the desired state and select Ok.

Fig. 2.8
Changing the Order State

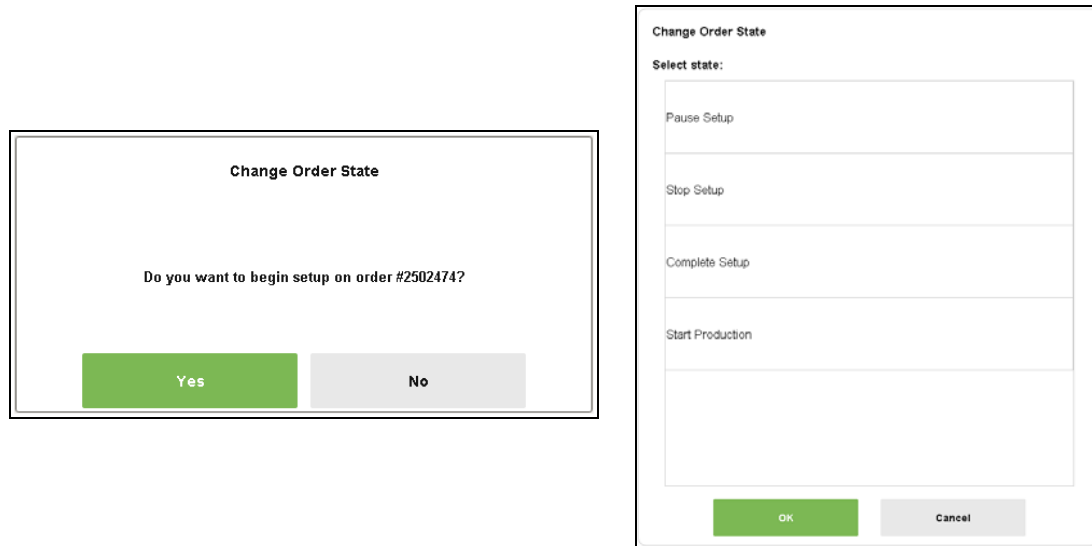


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Setting up a New Order

If there is setup required for this part of the routing, the operator can Start, Pause, Stop, and Complete the Setup steps.

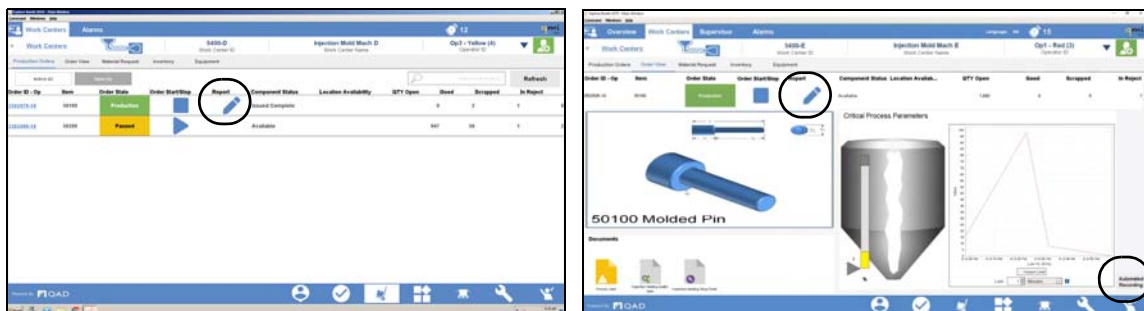
Fig. 2.9
Setting up a new order



Reporting Production

Users can report production from either the Production Orders or Order View screens.

Fig. 2.10
Reporting Production



Automatically Report Production - Scale Integration

Follow these steps to automatically record production on a machine with an integrated scale:

- 1 From the Order View screen, select the Automated Recording button.
- 2 If the equipment measures production using an integrated scale, a Scale Count window displays. Select the Weigh button to calculate the number of units that have been produced.

Note With scale integration, the system uses the item weight from Item Master or the pack weight from the Pack Code and compares that with the current weight in the machine and automatically calculates the number of units that have been produced.

- 3 Select Record to update the amount produced.

Fig. 2.11
Work Center - Reporting Production



Automatically Report Production - PLC Controls

Follow these steps to automatically record production on a machine with PLC controls:

- 1 From the Order View screen, select the Automated Recording button.
- 2 If the equipment measures production using PLC controls, a Production Count window displays.
 - Select Run to start reporting the production.
 - Select Stop to stop reporting production.
 - Select Reset to reset the production count to 0.

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Fig. 2.12
Work Center - Reporting Production

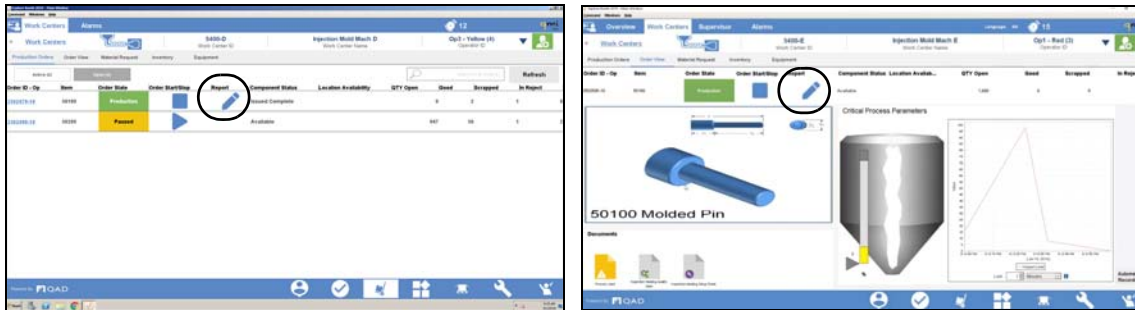


Manually Reporting Production

Follow these steps to manually report production at a work center:

- 1 Select the Pencil button from the Production Orders or Orders View screen.

Fig. 2.13
Manually Reporting Production



- 2 In the Report Production screen enter the Quantity Good, Quantity Suspect, and the Quantity Scrap.

Fig. 2.14
Manually Reporting Production

The screenshot shows the 'Report Production' window in QAD. The window title is 'Eclipse South 2018 - Page'. The navigation tabs are 'Overview', 'Work Centers', 'Supervisor', and 'Alarms'. The current view is 'Work Centers'. The form contains the following data:

- Work Center ID: 5400-E
- Operation: 10
- Operator: Op1 - Red
- Order: 2502595
- Item: 50100
- City Ordered: 2000.0
- City Open: 1990.0
- Quantity Good: 9.0
- City Suspect (Reject): 1.0
- City Scrap: 0.0
- Reason Codes: (empty)
- Quantity Processed: 0.0
- Pack Code: (empty)
- Standard Pack Quantity: (empty)
- Pack ID: (empty)

Buttons include 'Submit', 'Cancel', 'Clear', 'Delete', and 'Ok'. A numeric keypad is on the right with buttons for digits 0-9, a decimal point, and 'Clear'.

- 3 If you entered any quantities that are scrap or suspect, select the Reject Reason field and select the appropriate reason. Then select OK.

Fig. 2.15
Reject Reason

The 'Reject Reason' dialog box is shown. It has a title bar 'Reject Reason' and a message 'Please select a Reject Reason.' Below the message is a list box containing the following options:

- Parts are chipped
- Parts are cracked
- Not functioning properly
- Impurities
- Finish is defective
- Paint is flawed

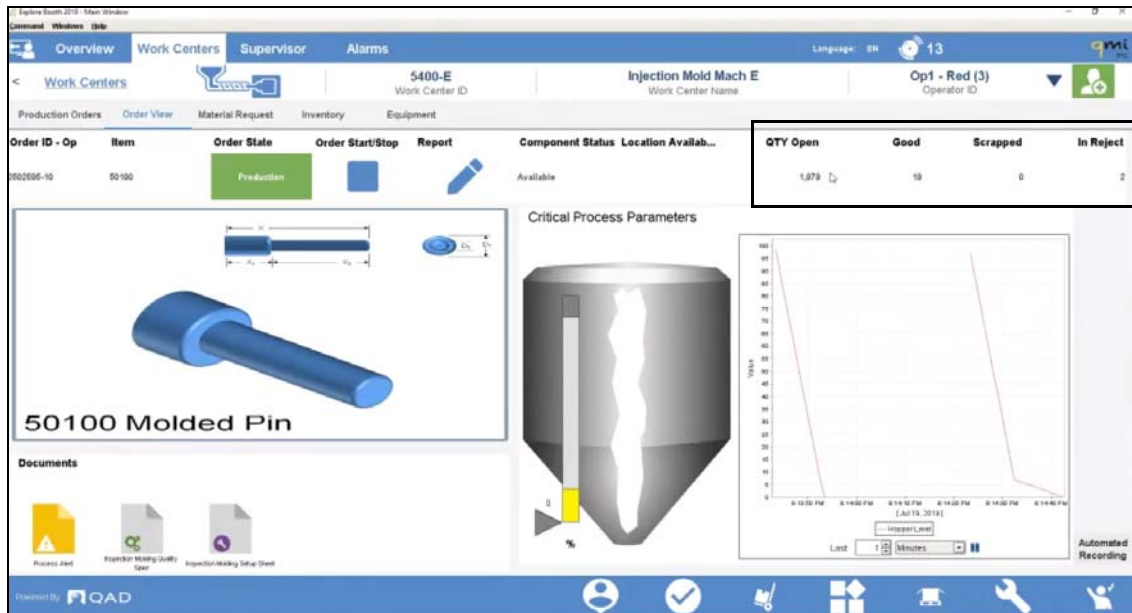
At the bottom of the dialog box are two buttons: 'OK' (highlighted in green) and 'Cancel'.

- 4 Select Submit to confirm the amount produced. The new quantities are displayed in the Order View screen.

Note Reporting production from the Report Production screen performs a backflush transaction in QAD. This transaction will be reflected in the Production Order browse and the Transaction History browse.

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Fig. 2.16
Manually Reporting Production



Supervisor Role

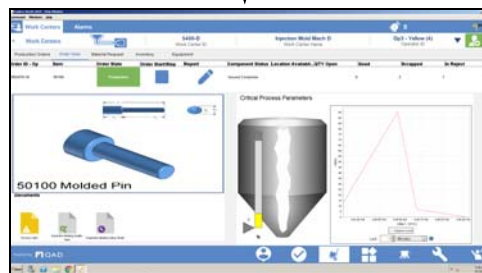
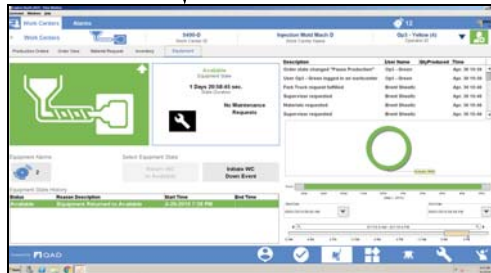
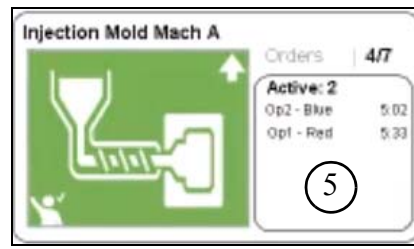
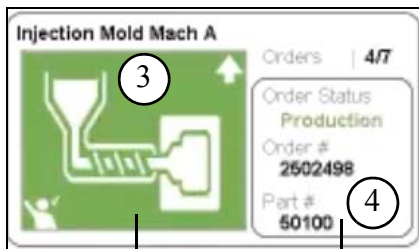
The Supervisor role has full access.

Overview

The Overview screen gives the supervisor a birds eye view of what is happening on the shop floor. Each window represents a work center and in that window the system displays the detailed information about the equipment status and the orders that have been released to the work enter. From this screen users can:

- View which operators have logged into each of these work centers.
- Drill down for detailed information regarding the production order.
- Drill down for more information on the equipment.

Fig. 2.17
Supervisor Role - Overview Screen



Key	Description
1	A graphic representing the work center on the shop floor.
2	Select the Orders and Equipment buttons to view order details or which operators are working in a work center.
3	This graphic represents the equipment at the work center. The color and arrows indicate the state of the equipment: <ul style="list-style-type: none"> When the color is green and the arrow is pointed up, the machine is running. When the color is red and the arrow is pointed down, the machine is stopped. Select the equipment graphic to navigate to the Equipment screen. See “Equipment” on page 11.

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4	When the Order button is selected (#2), this window displays details about the production order, including Order Status, Order Number, the Item Number that is currently being produced, the total number of orders that have been released to the work center, and the number of those orders that are active. Select this window to navigate to the Order View screen. See “Order View” on page 6.
5	When the Equipment button is selected (#2), this window displays the operators that are working in the work center.

Supervisor

The Supervisor screen contains the following tabs:

- **Site Schedule.** Displays a list of all production orders that are in the release state for the associated site.
- **Requests.** Displays a list of requests for the associated site.
- **Material Request Reasons.** Displays the current material requests.
- **Breaks.** Displays information about any breaks that employees have taken

Site Schedule

The Site Schedule screen displays a list of all the production orders that are in the release state for the associated site. The browser shows the Production Order, Item Number, Order Status, the % Complete, Work Center Description, and Equipment Status. User can sort the data in any of the columns. For example, users can sort by the % Complete column to view all the orders that are nearing completion.

Fig. 2.18
Supervisor - Site Schedule Screen

Production Order ID	Item	Order State	% Complete	WC Description	Equipment State
2502492	50200	Setup		5400-C	Available
2502600	50100	Open		5400-A	Available
2502579	50200	Open		5400-C	Available
2502576	50100	Stopped		5400-A	Available
2502570	50100	Order Completed	0%	5400-E	Available
2502569	50100	Order Completed	0%	5400-E	Available
2502500	50100	Production		5400-A	Available
2502554	02200	Production	81%	1000	Down-Power
2502535	02210	Open		1000	Down-Power
2502534	02220	Open		1000	Down-Power
2502533	00102	Production		5500-B	Available

Production Orders. Displays the total number of production orders that have release in the associated site.

Production Order ID. Displays the production order number.



Item. Displays the item number on the production order.

Order State. Displays the current state of the production order. Example of order states include Production, Paused, etc.

% Complete. Displays a the percentage of the order that is complete.

WC Description. Displays the description of the work center.

Equipment Status. Displays the current status of the equipment.

Requests

The Requests browse displays the current requests in the associated site. Users can filter the requests by the Request Type, Site, Department, and Work Center.

Fig. 2.19
Supervisor - Requests Screen

Type	Site	Department	Production Line	Work Center	Machine	Requestor	Time Requested
Container	10-200	0010	5400B	5400	B	Op1 - Red	07/17/2019 1:02 PM
Maintenance	10-200	0010	5500C	5500	C	Op1 - Red	07/17/2019 1:16 PM
Maintenance	10-200	0010	5500A	5500	A	Op1 - Red	07/17/2019 3:11 PM
Maintenance	10-200	0010	5400F	5400	F	Op1 - Red	07/17/2019 3:54 PM
Supervisor	10-200	0010	5400F	5400	F	Op1 - Red	07/17/2019 3:55 PM
Supervisor	10-200	0010	5400C	5400	C	Op2 - Blue	07/17/2019 6:08 PM
Maintenance	10-200	0010	5400A	5400	A	Op1 - Red	07/18/2019 3:18 PM

Type. Displays the request type.

- **Container.** A request for a new package to contain inventory, such as a box, pallet, tote, rack, and so on.
- **Maintenance.** A request for performing maintenance on the equipment at the work center.
- **Supervisor.** A request for the supervisor to come to the Work Center.

Site. Displays the production order number.

Department. Displays the item number on the production order.

Production Line. Displays the current state of the production order. Example of order states include Production, Paused, etc.

Work Center. Displays a the percentage of the order that is complete.

Machine. Displays the description of the work center.

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Requestor. Displays the current status of the equipment.

Time Requested. Displays the current status of the equipment.

Material Request Reasons

The Material Request Reasons browse displays the current material requests. For example, if a worker submits a line side replenishment request, that request will be displayed on this screen. Users can filter the requests by Site, Department, and Work Center.

Fig. 2.20
Supervisor - Material Requests Screen

Component	Order ID	Request Reason	Time Requested	Requestor	Work Center/ Machine	Department	Site
High Density PolyEthylene	2502490		Jul 18, 2019 2:38 PM	Op2 - Blue	5400-C	0010	10-200
High Density PolyEthylene	2502599		Jul 18, 2019 12:46 PM	Op1 - Red	5400-A	0010	10-200
Small Bushing	2502532		Jul 17, 2019 8:10 PM	Op2 - Blue	5500-B	0010	10-200
High Density PolyEthylene	2502491		Jul 17, 2019 5:36 PM	Op1 - Red	5400-C	0010	10-200
High Density PolyEthylene	2502491		Jul 17, 2019 5:36 PM	Op1 - Red	5400-C	0010	10-200
High Density PolyEthylene	2502506		Jul 17, 2019 3:54 PM	Op1 - Red	5400-F	0010	10-200
High Density PolyEthylene	2502595		Jul 17, 2019 2:16 PM	Op1 - Red	5400-E	0010	10-200
High Density PolyEthylene	2502595		Jul 17, 2019 2:10 PM	Op1 - Red	5400-E	0010	10-200
Small Bushing	2502482		Jul 17, 2019 1:27 PM		5500-A	0010	10-200
	2502507		Jul 17, 2019 1:15 PM	Op1 - Red	5000	0010	10-200

Component. Displays the item number and item description on the material request.

Order ID. Displays the production order number associated with the material request.

Request Reason. Displays the request for the material request.

Time Requested. Displays the date and time the material request was made.

Requestor. Displays the user who created the material request.

Work Center/Machine. Displays the work center associated with the material request.

Department. Displays the department associated with the material request.

Site. Displays the site associated with the material request.

Breaks

The Breaks screen displays information for any breaks that employees have taken. Users can filter the break records by Site, Department, Work Center, Shift, From Date, and To Date. If necessary, users can select a break record and change any of the information that was entered.



Fig. 2.21
Supervisor - Breaks Screen

Shift	User	Terminal	Time Out	Time In	Total Time	Date
	Op6 - Orange	gfg-co-rt	2:34 PM		88 day(s) 5:35:43 hrs	Apr 30, 2019
	Op2 - Blue	gfg-co-rt	8:22 PM		85 day(s) 23:47:48 hrs	Apr 24, 2019
	Op6 - Orange	k9l-wr-rt	8:12 PM	3:13 PM	28 day(s) 19:00:11 hrs	Apr 29, 2019
	Op1 - Red	xplor-it42	8:25 PM	3:12 PM	11 day(s) 17:46:16 hrs	May 8, 2019
	Hector Arredondo	xplor-it42	7:55 PM	7:57 PM	2:25 min	May 8, 2019
	Nathan Beste	xplor-it42	11:10 PM	11:10 PM	7 sec	May 7, 2019
	Tonya Wilbur	xplor-it39	9:19 PM	1:18 PM	15:58:57 hrs	May 6, 2019
	Tonya Wilbur	xplor-it39	9:12 PM	9:13 PM	32 sec	May 6, 2019
	New Registrant	xplor-it10	6:54 PM	6:56 PM	2:06 min	May 6, 2019

Shift. Displays the shift associated with the break record.

User. Displays the user who took the break.

Terminal. Displays the terminal used to log the break.

Time Out. Displays the time the user logged out for the break.

Time In. Displays the time the user logged in from the break.

Total Time. Displays the total length of time on break.

Date. Displays the date the break was taken.

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