



QAD Enterprise Applications
Enterprise Edition

User Guide

QAD Planning and Scheduling

Workbenches

Overview
Master Scheduling Workbench (MSW)
Production Scheduling Workbench (PSW)
Component Availability Check (CAC)
Troubleshooting, Tips, and Errors

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Overview

The QAD Planning and Scheduling Workbenches—which include both a Master Scheduling Workbench (MSW) and a Production Scheduling Workbench (PSW) with integrated component checking capabilities (CAC)—provide planners and schedulers with unprecedented, simultaneous visibility to schedules and all supporting data and enable control and collaboration across the production and materials planning space.

The following topics introduce the MSW, PSW, and CAC and discuss basic features, functions, and options available to both workbenches.

Introduction **2**

Introduces the components and features of the Planning and Scheduling Workbenches.

Common Workbench Elements **4**

Describes the elements of both the MSW and PSW and tells you the capabilities and purpose of each element.

Synchronizing MSW and PSW Data **8**

Describes the way to use the MSW and PSW simultaneously to build schedules.

Common Features **8**

Describes features and components that are common to both the MSW and PSW.

Limitations **14**

Describes areas not covered by MSW or PSW.

Performance **14**

Describes performance considerations and tips to improve performance.

Introduction

Successful scheduling deals with analysis, review, and manipulation of all data that impacts production machines, work centers, production orders, production lines, and other related resources of the manufacturing process. It also requires complex calculations that are immediately applied to manipulated schedules or any supporting data. More importantly, it requires immediate display of calculation results, especially when scheduling issues arise.

Previously, you needed numerous QAD Enterprise Edition (EE) menus to effectively view or manipulate schedule data, which could be time consuming and cumbersome. Now, new scheduling tools are provided through the .NET UI that let you effectively plan and schedule resources for a master schedule or a production schedule from a single workbench for each type of schedule.

You can select the Planning and Scheduling Workbenches from the .NET UI's list of applications. When you do, you have access to:

- Master Scheduling Workbench (MSW)
- Production Scheduling Workbench (PSW)
- Component Shortage Report
- Integrated Component Availability Check (CAC)

Initially, building a master schedule, then a subsequent production schedule, was done in a step-wise manner using several reports and maintenance screens, which was a cumbersome process. Now, you can concurrently plan and schedule production in a single process/toolset.

Schedules built through MSW or PSW let you build schedules that assist in doing the right production order in the correct order and consumes less time for you when building them.

Providing tools to build schedules is not enough, though, if you cannot monitor and manage component shortages. For that reason, several shortage-monitoring features are also available when you are building effective schedules.

Master Scheduling Workbench (MSW)

The MSW is a .NET UI application that increases master scheduling efficiency by displaying and manipulating system demand, supply, scheduling, inventory, production order, advanced repetitive, and MRP data from several QAD EE programs into a single workbench.

Note *Production order* is a new term to replace the term work order. It represents both repetitive and discrete orders.

You can use the MSW to interact with production lines, work centers, machines, and production order schedules and make changes where necessary.

Within MSW, you can update the production order status—planned, firmed, allocated, released, closed—as well as create production orders, while considering all demand and supply sources, from this single workbench. You can ensure that items with similar attributes are scheduled together while also ensuring that there is enough capacity to take advantage of running similar items. You can also identify items with demand that have no released production orders or check component availability for each production order to be released.

User-configurable parameters control the number of days you can directly manage a scheduling period, as well as the future and historical periods available for schedule review.

Event-based color coding lets you easily identify areas of concern. You can review and manipulate schedule and production order data in a simulation mode, then save the updated information back to QAD EE as repetitive/discrete production schedules/orders.

Production Scheduling Workbench (PSW)

After you generate a master production schedule over a monthly, weekly, or daily horizon, you may need to refine the master schedule by creating a production schedule for a shorter two-to-five day period for the shop floor to use. Production scheduling entails:

- Sequencing jobs by key attributes/constraints within a day or shift to obtain maximum operational efficiencies
- Verifying that materials are available before releasing the schedule/orders to the shop floor
- Releasing and authorizing production orders

Some companies run a single production order over several days, while others run multiple production orders within a single day. Further, some companies define a production sequence by shift to monitor shift performance or ensure that products are available for a specific shipment time.

The PSW lets you schedule discrete and repetitive items on production lines. You can schedule items within a day and shift (sequencing). You can use the PSW to view and update production line schedules used with the QAD Advanced Repetitive module. You can also use the PSW to view and update production orders used with the QAD Work Order module.

Note You cannot use the PSW to schedule work centers—just production lines. Also, you cannot schedule down to the operational level with the PSW.

Component Availability Check (CAC)

Component Availability Check is another component of the Planning and Scheduling Workbenches and is integrated into both the MSW and PSW workbenches. This lets you verify that materials are available before you release orders and print the orders and schedules. Integrated CAC serves two distinct purposes:

- Schedulers and planners use CAC features to ensure that the jobs they schedule days in advance to production have enough materials.
- Schedulers and planners use CAC features to ensure that the jobs they release to the shop floor have enough materials.

The CAC engine is also leveraged in several user-based collections developed specifically to be leveraged with the Planning and Scheduling Workbenches

All users can use CAC supporting data to analyze component availability. Within the planning and scheduling workbenches, built-in panels at the bottom of the workbench provide supporting data. For more information on the Component Check browse collections, see “Component Availability Check (CAC)” on page 79.

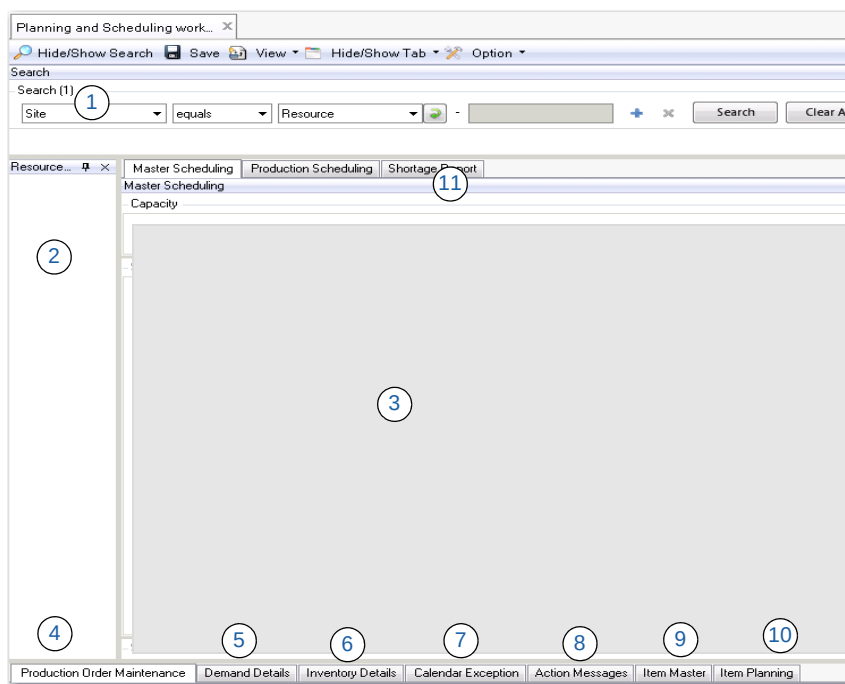
Common Workbench Elements

You can interactively control the workbench behavior and content, such as the panels that display, data filters, and business rules. You can save your customized workbenches layout as a View and invoke it on demand, based on the type of scheduling you are performing.

When you make selections within some panels, the system displays supporting information related to the record selected in the supporting tabs. This information is detail information; for example, demand detail records, supply detail records, item transaction history, item inventory details, bill of material, and routing. Also, when you make changes or create new data in some panels, data in other panels changes to reflect the new data.

The following depicts areas that are common to both MSW and PSW.

Fig. 1.1
Common Scheduling Elements



(1) Search Panel

Use this area to select resources and items to schedule.

The selection results are limited to sites that you can access, based on security records defined in Site Security Maintenance (36.3.15). Additionally, if you are in a multiple-domain environment, the system only displays sites in domains that you can access based on settings in User Maintenance (36.3.1).

(2) Resource Panel

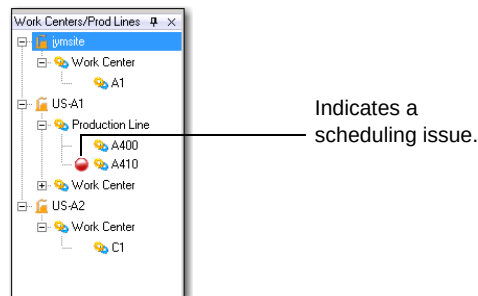
Based on your selection criteria, the Resource Panel displays the sites and resources. Resources are grouped by site and resource type. Resource types consist of two categories:

- Production lines
- Work centers

When you click on a work center/machine or production line resource in this panel, the Schedule Grid displays only those items associated with the selected resource.

The Resource Navigator Panel highlights each resource with a POH shortage icon when one or more items associated with the resource has a POH shortage within the resources's defined scheduling horizon.

Fig. 1.2
Resource Panel



(3) Schedule or Sequence Grid

This area displays the Schedule Grid in MSW or the Sequence Grid in PSW. The MSW, PSW, and Shortage Report content are controlled by the Navigator Panel.

For information on MSW, refer to “MSW Schedule Grid Data” on page 38.

For information on PSW, refer to “Sequence Grid” on page 63.

(4) Production Order Maintenance

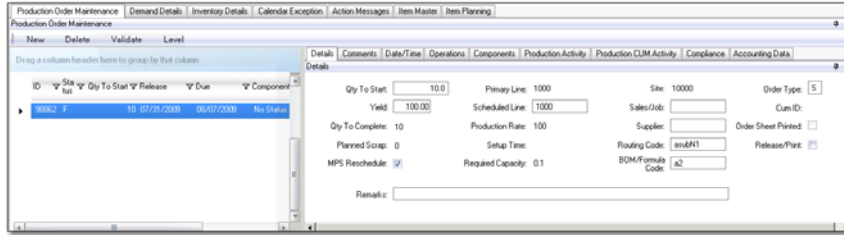
You can access Production Order Maintenance within the workbenches. Production Order Maintenance lets you view individual item production order supply records for items that display in the MSW Schedule Grid or PSW Sequence Grid. Production Order Maintenance uses a horizontal layout and supports scheduling of work centers, production orders, and production lines. You can view, monitor, and interact with details of a production order within the Production Order Maintenance tab.

The left side of Production Order Maintenance displays production order summaries with the order ID, status, quantity ordered, and release date columns. The right side displays production order details, comments, date/time, operations, component availability data, production activity, production CUM activity, compliance data, and accounting data for the order.

Using these tabs, you can view several aspects of data that have an impact on the production order and alter data without leaving MSW/PSW. Production Order Maintenance also lets you to create a new order, delete an order, or validate an order. When you validate the order, the system checks for correct data in production order fields and when errors occur, it indicates which fields require that you correct data.

After you complete production order updates, you can save changes globally by clicking the workbench toolbar Save button. Some validations take place in real time when you modify the order on the workbench; others are performed during the save process. The Validation button invokes the validations that would be performed during the save process.

Fig. 1.3
Production Order Maintenance



Production Order Maintenance auto-selects the first production order on the selected Schedule Grid due date and displays additional production orders in the past and future. Scroll up to view orders with prior due dates; scroll down to view orders with future dates.

When you select an item on the Schedule Grid with a supply/demand issue, Production Order Maintenance displays any planned orders MRP generated to resolve the supply/demand issue and existing production orders of various statuses associated with the item.

For each due date, production orders display by status in this order: P(lanned), F(irm planned), A(llocated), E(ploded), R(eleased), C(losed). Then, for each status, they display by production order ID.

If you select a different production order in Production Order Maintenance, the Schedule Grid does not change.

For field descriptions for Production Order Maintenance, see “Working with Order Summary List Data” on page 47 and “Working with Order Detail Records” on page 48.

(5) Demand Details

When you select an item in one of the daily schedule fields, the system displays information about the components of the demand, such as sales order/line numbers and quantities or seasonal demand under the Demand Details tab. This display is based on MRP detail records.

Special behavior of the MSW Schedule Grid is as follows:

- When you select a specific day on the Schedule Grid, the Demand Details frame displays all demand records with due dates equal to the selected Schedule Grid date column.
- For the item/day selected on the MSW Schedule Grid, the Demand Detail Frame focuses on demand records, starting with the demand records with due dates equal to the selected item/day. If no matches are found, the frame focuses on the first demand record found—the oldest record. You can scroll to see all open demand records in the past or records in the future.

(6) Inventory Details

The Inventory Details Panel displays the item number, site, quantity on hand, inventory master data, location, lot/serial, status, expiration date, and the date created. For all areas, you can choose to display details for all, custom, blanks, or so on.

(7) Calendar Exception

Occasionally, exceptions such as overtime or machine downtime cause changes in productivity and capacity for various shifts. When you set up calendars in Calendar Maintenance, you specify a reference, such as downtime, and the number of hours per day affected. This information displays in the Calendar Exception Maintenance grid within MSW/PSW. Negative numbers can display for downtime or holidays. Holidays are days when no production is scheduled. Holidays differ from site to site.

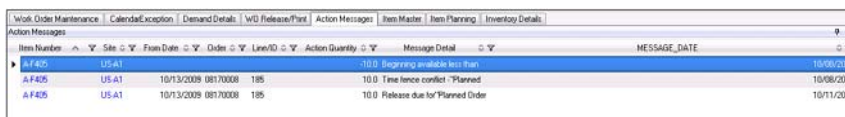
Note You can only create Calendar Exceptions for production lines within the workbench. For the March 2011 release, when you enter calendar exception records, the system multiplies by x number of resources; for example, when you enter -3 hours and have three production lines, the system calculates this as -9 hours.

(8) Action Messages

The Action Messages Panel displays information regarding the item issues generated by the legacy MRP action message logic. The MSW visual alerts depict negative projected on hand and below safety stocks, but the Action Messages Panel can display additional information, such as canceled production orders.

Note For error messages and conditions, refer to Appendix A.

Fig. 1.4
Action Messages



Item Number	Site	From Date	Order	Line/ID	Action Quantity	Message Detail	MESSAGE_DATE
A/F405	US.A1				10.0	Beginning available stock	10/08/2009
A/F405	US.A1	10/13/2009	00170008	105	10.0	Time fence conflict "Planned"	10/08/2009
A/F405	US.A1	10/13/2009	00170008	105	10.0	Release due for "Planned Order"	10/11/2009

(9) Item Master

The Item Master Panel is a browse that displays critical item information leveraged for planning/scheduling purposes and the active field values. The panel lets you view and manage items on multiple resources at once.

Note You can modify the browse view in Browse Maintenance to include information from any field in Item Master Maintenance (1.4.1).

For field descriptions, see “Item Specific Information” on page 56.

(10) Item Planning

The Item Planning Panel displays item master/planning details for a selected item. At any point during the planning or scheduling process, you can refer to the item planning panel to find information to identify lead time, order quantity, and so on. If an item-site record exists, planning data from item-site record display for the selected item-site record.

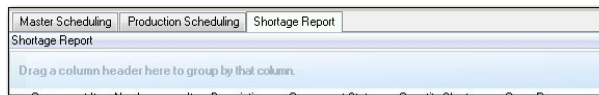
You can modify item details to include information from any field in the Item Master Maintenance.

For field descriptions, see “Item Master and Planning Tab” on page 57.

(11) Shortage Report

Schedulers can use the Shortage Report, generated by component availability check (CAC), to monitor component shortages of manufactured/purchased parts. In the workbenches, you can see the component status at the production order level; however, the Shortage Report allows you to summarize all material shortages for all production orders that were included in your search criteria. You can run a shortage report by selecting the Shortage Report tab in the workbenches.

Fig. 1.5
Shortage Report Tab



Synchronizing MSW and PSW Data

Typically, you work with master schedules in MSW and production schedules in PSW simultaneously. The two workbenches are designed to work together and are aligned as if they were a single workbench.

For example, you select an item on the MSW Schedule Grid and verify the item supply/demand are correct. You can then determine when the item is produced in relation to other items scheduled on the same day by looking at the PSW Sequence Grid.

Or, if you are working on the PSW and move the production order release/due date back, you can then determine the impact to supply/demand by viewing the MSW demand/supply summary panel. This lets you make decisions that are based on displayed data that you can easily verify.

Note If you apply filters to the MSW/PSW, you may not see the synchronization behavior when the system does not display records per your filters.

Common Features

The following topics discuss features common to the workbenches.

Customizing Views

A number of components of the workbenches can be customized:

- Layout of grids and panels

- Repositioning/hiding tabs
- Resizing panels

This section discusses each type of customization as well as saving your view.

Saving Views

You can also save customizations as a View when you change the layout of:

- Grid column settings
- MSW Schedule Grid and Capacity Panel
- PSW Sequence Grid and Production Order Browse Panel

Repositioning/Hiding Tabs

You can move a tab on a workbench to a new location or hide a tab that you typically do not use. Repositioning/hiding the following workbench tabs can be saved as part of a view:

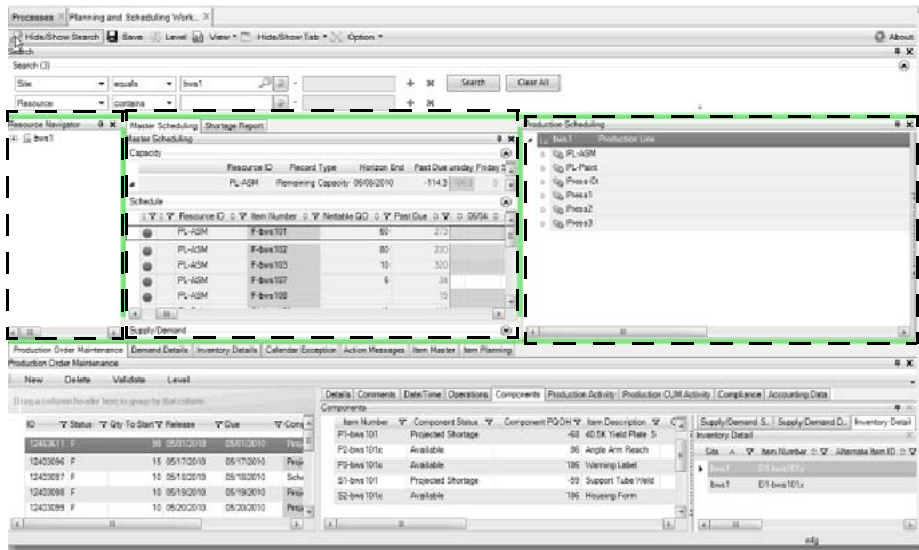
- Supporting panels
- PSW, MSW, or Shortage Report tabs

If you are working in any of the supporting programs that display at the bottom of the workbenches, and the program has multiple tabs, you can right-click on the tab, then select the Auto Hide option to display only the data in that tab. For example, when working in Production Order Maintenance, you want to focus only on the dates and times of operations for a particular order. You select the order on the left side, then select the Date/Time tab on the right side. You right click to select Auto Hide so that only the date and time data for that order displays on the right side. You can save auto-hidden areas as part of your view.

Resizing Panels

You can resize a panel to accommodate viewing by grabbing the panel's perimeter and dragging the panel to the size that you want. You can then save your resized panels as part of your view. The following figure shows panels with dotted lines around them that can be repositioned and saved as part of the view.

Fig. 1.6
Panels to Resize



History Horizon

The history horizon defines how many days in the past you want to review completed or closed production orders. After you set the history horizon, you must perform a search to have data within the set horizon.

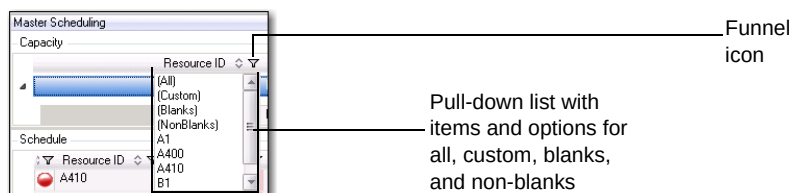
To set up the History Horizon, see:

- “Setting the MSW Schedule Horizon” on page 28
- “Sequence Horizon” on page 64

Filters and Browsers

In the various grids and panels, you can apply filters to the columns that display by clicking the funnel icon. Click the funnel icon to display a pull-down list with items displayed for the column along with options for (All), (Custom), (Blanks), and (NonBlanks). This is a standard .NET UI filtering mechanism.

Fig. 1.7
Filter



- To display all data, choose (All). This is the default.
- To include custom criteria, choose (Custom).
- To include only blank items, choose (Blanks).
- To display everything except blank items, choose (NonBlanks).

- For a particular item, select the item from the list.

To define a custom browse, click the funnel icon, then choose (Custom). The Enter filter criteria pop-up menu displays. By default, the menu includes an initial criteria. You can add additional criteria by selecting Add a Condition, then selecting an operation.

Displayed Records

You can filter records that the system retrieves for either the MSW or PSW. You can display records for individual production lines and work center/machine combinations.

Optionally, you can specify search operators such as equals, not equals, contains, range, starts at, greater than, less than, is null, is not null. This lets you narrow the search criteria, focusing on specific records, or broaden the search so that records for more than one site or resource, for example, displays.

When searching records to display, you can select from site, resource, resource type (production line or work center/machine), and scheduler ID from the Search pull-down menu. You can view items across a single resource or multiple resources by setting resource and search criteria.

Drag and Drop

You can easily modify aspects of a production order by dragging and dropping production orders within the PSW Sequence Grid or to the Resource Panel. You cannot drag and drop orders in the MSW Schedule Grid.

In PSW, when you drop an order onto another order, the order you drop acquires the properties of the targeted order, so, for example, if you drag and drop an unsequenced order onto a sequenced order, it becomes a sequenced order. Use the drag-and-drop method to:

- Change due dates by dragging and dropping a production order from one release date to another production order with a different release date.
- Modify resources by dragging and dropping from the source to the target destination after you select a single or multiple production orders.
- Sequence production orders in PSW by dragging and dropping single or multiple orders after a sequenced production order. After you drop the orders, the system assigns the sequence number to the order(s) as greater than the prior sequenced numbers. Shift numbers are also automatically assigned if an order is dropped on a particular shift.

Note To sequence the first production order for a given release date/shift, you must manually enter the sequence number of (1). From this point on, you can use drag-and-drop to sequence additional orders within the same release date/shift.

- Unsequence an order by dragging a sequenced order and dropping it on an unsequenced order. The system changes the sequence to 0 (zero).

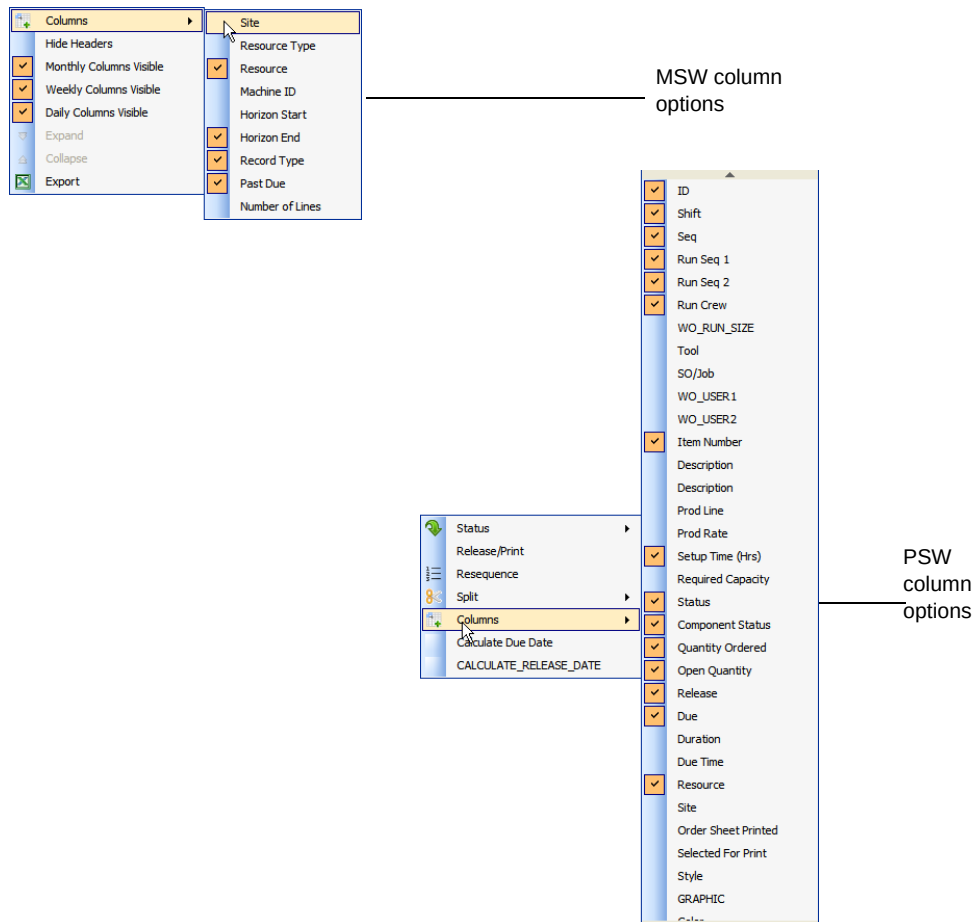
Columns

You can add hidden columns—a .NET UI feature—and select the additional column that you want to display in the workbenches.

To do this, while you are in the Schedule Grid or the Sequence Grid, right-click, then select the Columns option. The following figure depicts options for both workbenches.

You can add columns to the PSW Sequence Grid as well as add or modify column header labels, using QAD EE standard label maintenance programs.

Fig. 1.8
Column Options



Visual Indicators

The MSW displays visual status indicators to direct your attention to potential capacity and item shortage issues. The projected quantity on hand (POH) displays as soon as items display on the Schedule Grid. The system calculates the POH for every item with supply/demand in the scheduling horizon, and applies the POH status indicator to every resource that has quantities scheduled.

Table 1.1
Visual Indicator Summary

Panel/Frame	Object	Indicator	Meaning
Resource Panel	Resources		The resource includes one or more items with a supply shortage (negative POH).
MSW Capacity Panel	Remaining capacity		The planned capacity was consumed from prior days, to satisfy the required capacity needs of the date column highlighted in yellow.
Period Available Capacity			Period available capacity is less than or equal to 0 for every day prior to this date. AND
			- Required capacity is greater than capacity. - Excess capacity for the day is consumed by a future shortage. - The system consumes excess capacity from a prior day.
MSW Schedule Grid and Supply/Demand Panel	Item number		Projected on-hand is less than 0 (zero) within the firm scheduling horizon.
	Projected On-Hand		Projected on-hand is less than safety stock value plus seasonal demand within the firm scheduling horizon.
			Projected on-hand is negative within firm schedule period. Alternate production lines without active orders are not colored for POH. For example, when you have the same item on two production lines, and you schedule quantities on the first production line but not the second line, the system does not display colored schedule grid cells for the second production line.

Projected and Status POH

The repetitive POH calculation is as follows:

$$WO\ Open\ quantity + Nettable\ Inv - Total\ demand$$

Where:

Nettable Inv = From MRP Detail (23.16)

Total Demand = Independent + dependent + forecast + seasonal

WO Open quantity = Schedule Net Requirement Due (SNRD)

Note SNRD is the summation of production order open quantities for all production orders for a specific order due date and production line.

The POH status for both repetitive and production orders derives from the POH calculation. If any POH for that item is below safety stock, then POH status is set to safety stock status. If any POH is < 0 then the POH status is set to below-zero status.

Additionally, the repetitive and production order PAC status derives from the POH calculation. If any POH for that item is below safety stock, then POH status is set to safety stock status. If any POH is < 0 then the POH status is set to below-zero status.

Navigation Shortcuts and Keys

While you can use the mouse to click anywhere within the Schedule Grid, the following keyboard navigation shortcuts are available:

- Press Tab to move forward to the next day or to move across a row to skip the total column.
- Press Shift-Tab to move back to the previous day.
- Press the down arrow to move down to the next item.
- Press the up arrow to move up to the previous item.
- Press Enter to commit your changes without moving from the cell.

Navigation Key Limitations

Shortcuts are available only within the window currently displaying. To display additional days or items, you must click the horizontal or vertical scroll arrows. You can use the Tab key, though, to display additional days within your horizon when they do not display because of the grid size.

You cannot use the Esc key in the workbenches as you might in a spreadsheet.

Limitations

MSW and PSW do not support:

- Co-\by-products
- Standard repetitive functionality
- Integration with the QAD EE Flow Manufacturing module
- Routable items

Note MSW and PSW do support advanced repetitive functionality.

Production Order Browse within the Planning and Scheduling Workbenches displays production orders with a zero open quantity if the production order is a discrete order. Repetitive orders with a zero quantity do not display; however, Production Order Browse still displays both discrete and repetitive orders.

Performance

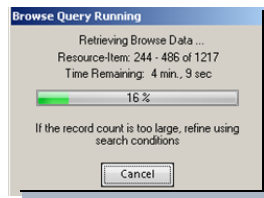
The MSW/PSW and its integrated CAC data retrieval performance can be impacted when the system processes a large number of records. This section discusses features available to mitigate these performance impacts.

MSW/PSW Search Data Retrieval

When you invoke a search in the MSW/PSW, the system displays a dialog box to show that a data retrieval is in process. To display the time remaining to complete the data retrieval in the dialog box, set the Display Search Progress field to Yes in the MSW Search Preferences window in the Options drop-down. Setting this field to Yes, however, can impact performance. Regardless of the setting of this field, you can cancel the search at any time by pressing the Cancel button in the dialog box.

The system displays a message when the number of records you are attempting to display exceeds the maximum.

Fig. 1.9
Maximum Records



Workbenches-Integrated CAC Data Retrieval

The integrated CAC data retrieval runs in a background thread to make the MSW/PSW search data retrieval complete faster. In addition, to minimize the performance impacts of the integrated CAC data retrieval, there are several user preference options within the Component Availability window of the preferences. You selection Options, then Settings, then Component Availability to:

- Disable the CAC calculation.
You can clear the Enable CAC check box.
- Minimize the number of MRP detail records the system processes.
You can set the CAC Horizon field. To decide on a value for this field, consider the interval of time from today into the future for CAC purposes. For example, you may be interested only in the data within the time fence number of days into the future.
- Decide which component items should be included or excluded.
You can select the Components Included component check boxes as needed. For example, you may be interested only in non-floor stock items.

Note These settings do not pertain to the QAD EE CAC browse collections, such as Monitor Material Shortages, Release Production Order By Production Line, and so on.

Finally, when you enable CAC by selecting the Component Availability tab in the User Preferences window (under the Options drop-down menu), MSW performs CAC calculations. If disabled, then CAC is not calculated during data retrieval or after Save, and there is a noticeable improvement in retrieval and save performance.

Master Scheduling Workbench (MSW)

The following topics describe how to use the features of the Master Scheduling Workbench (MSW).

Introduction 18

Introduces the MSW, components, and features.

Accessing MSW 23

Provides procedures to access the MSW in the .NET UI.

Enabling the Workbenches 24

Tells you how to enable MSW.

Synchronize Resource Tables 25

Tells you how to synchronize EE tables for use with the workbenches.

Setting Up Production Lines 26

Tells you how to mass set up production lines, then mass update the setup.

MSW User Preferences 28

Lists fields, describes field input, and presents screens for all windows for user preferences.

Processing Master Schedules 33

Provides a general procedure to create and process a master schedule and describes processing results.

Working with Production Orders 40

Describes the pulled-in QAD EE menu programs and data presented in the MSW, including field descriptions for the various programs. Also, instructions to edit, modify, delete, and manipulate production orders are provided.

Viewing/Editing Order Data 47

Describes ways to view data from the MSW.

Item Specific Information 56

Describes the pulled-in QAD EE programs and data presented in the MSW, including field descriptions for the various programs that let you manipulate and view item data.

Calendar Exception Tab 58

Describes features and functions available through the Calendar Exceptions tab within the workbenches.

Saving Your Changes 59

Provides a procedure to save changes in MSW.

Introduction

Use the Master Scheduling Workbench (MSW) to create master schedules for medium to long periods of time (weeks to months) with supporting data to review on items, operations, demand, supply, capacity, and material.

Features

Functions within the workbench let you concurrently manage work centers and production lines within a single workbench. You can authorize work or schedule due dates for repetitive production orders on the production line and for discrete production orders on work centers. From a single workbench screen, master schedulers can:

- Split production orders.
- Reschedule or change the status of production orders.
- Maintain production order details.
- Manage production order operation lists.
- Move production orders to alternate production lines/work centers.
- Release production orders.
- Export schedules to a spreadsheet (MS Excel).

Note MSW does not support co-/by-products.

You can display:

- Supply, demand, and capacity in daily increments at the item level
- Supply, demand, and capacity in weekly and monthly buckets
- Capacity and demand issues
- A list of items requiring master scheduling attention
- Production orders that are past due, cannot complete on time, have component availability shortages, or are released
- Production order status
- Resources to be scheduled
- Demand details
- Action messages
- Item master or planning data
- Inventory details

The following topics provide more information on MSW elements, the functions they provide, and QAD EE program functions that you can access from within MSW.

Visual Indicators

MSW displays visual status indicators to direct your attention to potential capacity and item shortage issues. The projected quantity on hand (POH) displays as soon as items display on the Schedule Grid. The system calculates the POH for every item with supply/demand in the scheduling horizon. When the resource type is a production line, the system applies the indicator to only the item's primary production line. When the resource type is a work center/machine, the system applies the indicator to any resource associated with the item.

Shortage warning status applies to required capacity, available capacity, part number, scheduled quantity, and projected on-hand (POH) quantity. Shortage warning status indicators can display as a low warning status (yellow shading), which typically applies to non-critical potential shortages; for example, when the quantity on hand does not meet safety stock requirements. A high warning status (red shading) indicates a potentially critical capacity or item shortage problem; for example, when the projected on hand quantity is less than zero. Table 1.1 on page 13 summarizes visual indicators.

Workbench Elements

MSW lets you schedule items and set the production order due/release dates and quantities within a certain daily, weekly, or monthly based horizon.

Fig. 2.1
MSW

The screenshot displays the Master Scheduling Workbench (MSW) interface with three main panels: Capacity, Schedule, and Supply/Demand.

Capacity Panel:

Resource ID	Record Type	Past Due	11/17	11/18	11/19	11/20	11/21	11/22	11/23	11/24	11/25
1000	Remaining Capacity	-250.1	0	0	-242.1	8	-234.1	0	0	8	8
	Planned Capacity		8	8	8	8	40	0	0	8	8

Schedule Panel:

Resource ID	Item Number	Nettable QD	Past Due	11/17	11/18	11/19	11/20	11/21	11/22	11/23	11/24	11/25
1000	100A	11498	7336					0				
100-01	100A	11498	7532.1					0				
100-01	100A-02		7263					0				
100-01	100B	9360	17231					0				
100-01	100C	-60	17385					0				
100-01	100A	2962						0				
100-01	100B							0				

Supply/Demand Panel:

Item Number	Record Type	Past Due	11/17	11/18	11/19	11/20	11/21	11/22	11/23	11/24	11/25
100A	Projected On Han	98.1		11498	11498	22996	11498	11498	11498	11498	
100A	Projected Availabl	98.1		11498	11498	22996	11498	11498	11498	11498	
100A	Supply	8795.1				0					

Capacity Panel

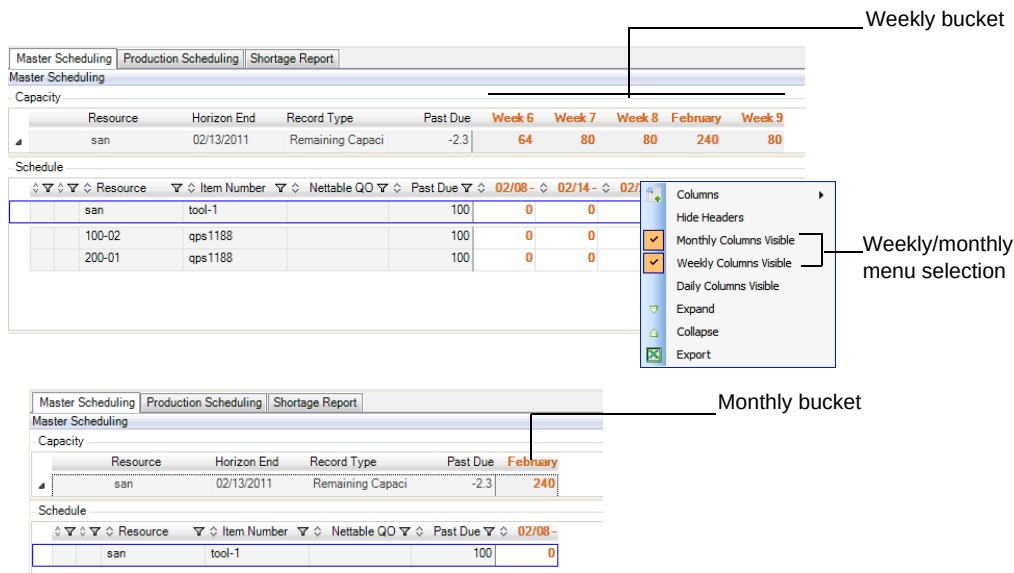
The Capacity Panel displays resource capacity. Use data in this panel to view production order required capacity. The system calculates summaries and displays required capacity and available capacity data in this grid as you enter data in the Schedule Grid. You can expand and collapse the Capacity Panel to show capacity and schedule quantities in weekly and monthly buckets. The weekly and monthly buckets are display only.

You can display capacity information in daily, weekly or monthly buckets by using a combination of User Preference and context menu settings; see Figure 2.2. Weekly and monthly buckets are display only so when you set the Schedule Grid for weekly/monthly buckets, you cannot edit data.

Note When you set up weekly or monthly bucket display for the Capacity Panel, the setting applies to the Schedule Grid and Supply/Demand Panel, too.

You can expand the weekly or monthly buckets to daily buckets. You can only edit daily buckets in the Schedule Grid, not the Capacity and Supply/Demand Panels.

Fig. 2.2
Monthly and Weekly Buckets



When you start to create a schedule in the Schedule Grid for the item you selected, the system shows you the capacity impact in real-time. For information on field descriptions, see “Consume Prior Remaining Capacity” on page 30.

Schedule Grid

The Schedule Grid displays item supply records; that is, production orders, with bucketed quantities of the production order supply records for the item. The records represent the master production schedule for a given period. The summarized quantity values within the Schedule Grid are production order quantities.

You can expand the Schedule Grid to display capacity in weekly and monthly buckets. The weekly and monthly buckets are display only, though, so you can only edit in daily buckets; see Figure 2.2.

For more information, see “MSW Schedule Grid Data” on page 38.

Daily Buckets

Each supply record is associated with one or more resources. For production orders, resources can be work centers or production lines; for repetitive orders, the resource is the production line. However, you can schedule discrete production orders on both production lines and work centers. Schedule data bucketed by day is appended on the right for the range of days identified in the data selection criteria; see Figure 2.3. You enter data in this right-hand area.

Fig. 2.3
Data Bucketed by Day

Capacity		Resource	Horizon End	Record Type	Past Due	Tuesday	Wednesd	Thursday	Friday	Saturday	Sunday	Monday
		san	02/13/2011	Remaining Capaci	-2.3	16	16	16	16	0	0	16

Schedule		Resource	Item Number	Nettable QO	Past Due	02/08	02/09	02/10	02/11	02/12	02/13	02/14
		san	tool-1		100							

Data bucketed by days

Descriptive and transactional item attributes identify items in the Schedule Grid. Descriptive item attributes are those found in the item master/detail tables; transactional item attributes include scheduled quantities past due and nettable on-hand inventory. Because the system calculates the net past due quantity remaining for an item, you can view item past due quantities as your day begins. This lets you check results of prior shifts. As you scan items, you can monitor inventory levels and easily determine the nettable inventory on hand. You can easily spot inventory levels of concern.

You can make updates to existing quantities in the Schedule Grid. When you do, the system performs POH, required capacity, and other calculations and displays changes. Also, when you make changes to some fields in the Production Order Maintenance Details tab, it can cause changes to capacity. For more information, see “Details Tab” on page 48.

Planned orders within the scheduling horizon are not included in the POH and resource required capacity calculations in MSW, so planned orders do not display in the Schedule Grid. To view planned orders, drill down to data in the Demand/Supply Grid.

Note You can also view the orders in the Production Order Maintenance window within MSW.

Supply/Demand Panel

Use the information in the Supply/Demand Panel to view the item’s total demand and total supply data over a period of time. Total demand is from sales, DRP, forecast, seasonal demand, or dependent demand. Total supply is from planned, firm, released production orders, or purchase orders.

The Supply/Demand Panel displays the record type and past due quantities. You can also view cumulative ATP, demand, projected available balance, POH, receipts, seasonal/safety stock, and supply as the record type.

When you enter or update a scheduled quantity in the Schedule Grid, the Supply/Demand Panel is updated to show the remaining open quantity due for the item. Whether the resource selected is a production line or work center, the Supply/Demand Panel displays the quantity and due data from production orders.

When you want more details related to the demand information that shows in the Supply/Demand Panel, you can select the Demand Details tab within Production Order Maintenance to view demand details for the item selected in the Schedule Grid. For more information, see “Working with Supply/Demand Panel Data” on page 38.

Seasonal Demand

The system performs the following calculation for each date when a Master Scheduled receipt is due or a seasonal build quantity is made available, causing a net increase in supply. It takes into account all sales order and required ship schedule demand and gross requirements up to the next increase in available supply.

$$\text{Master Scheduled Receipt} - \text{Sales Orders and Required Ship Schedules} - \text{Gross Item Requirements} - \text{Seasonal Build Net Increases} + \text{Seasonal Build Net Decreases} = \text{ATP}$$

Past due is not calculated.

Independent/Dependent Demand

Repetitive independent and dependent calculations are based on the following function:

summarize mrp_quantity

Where:

For independent demand, mrp_dataset = sod_det, cs sch_mstr, ds_det, sob_det, pb_sold, pbo_sold

For dependent demand, mrp_dataset = jp_det, wod_det, wo_scrap

The past due independent demand calculation is as follows:

Summarize mrp_quantity prior to the beginning date

Schedule Horizon

MSW gives you user-configurable control over where the MPS schedule horizon ends and where the future window begins. MSW calculates data differently in the scheduling horizon display than in the future window. Visual indicators only apply to the defined scheduling horizon.

Fields in Work Center Maintenance (14.5) are also available in Production Line Maintenance (18.1.1) and help control the schedule horizon. Specifically, you set the Horizon End field to either Day, Week, or Month, then set the number of periods for the increment in those programs. The system displays a read-only calculate date. The system calculates the date from period and period number, so if you set Horizon End to Day and Period to 5, the Calculate Date is five days starting with today. If you set Horizon End to Week and Period to 4, then the Calculate Date is four weeks from now including today.

Figure 2.4 shows a sample time line in the MSW Schedule Grid. The left side shows the Schedule summary, while the right side shows individual dates, starting with today's date of October 19.

Fig. 2.4
Scheduling Period Example

Resource ID	Record Type	Past Due	10/19	10/20	10/21	10/22	10/23	10/24	10/25	10/26	10/27
A410	Remaining Capacity		24	24	129	24	24	24	10	0	24
	Planned Capacity		24	24	130	24	24	24	10	0	24

Item ID	Item Number	Past Due	Nettable QO	10/19	10/20	10/21	10/22	10/23	10/24	10/25	10/26	10/27
A-F410				10								
A-F411		-10										
A-F412		12										
A-F413		5										
A-F414		10										
A-F415		10										
A-F400												
A-F401												
A-F402												
A-F403												

Move the sidebar to the right to see future dates.

Even though your future horizon may not fit into the .NET UI window on your screen, you can use the sidebar to display day-by-day future dates. When you scroll into future days, the day-by-day regions of the Capacity and Supply/Demand Panels are also scrolled.

Within MSW, only production orders with a status other than P within the MPS Scheduling Horizon impact these calculations:

- POH
- Available to promise
- Required capacity

MSW does not calculate for planned orders inside the scheduling horizon; however, you can view planned orders using supporting data in other programs within the MSW. To view a planned production order, view data in:

- Demand Details tab
- Production Order Maintenance tab
- Supply row in Supply/Demand Panel

The scheduling horizon impacts the color logic, POH, auto firm, and resource required capacity within the Schedule Grid.

Accessing MSW

You access the MSW through QAD .NET UI. You can enter the full name—Master Scheduling Workbench—or a partial name in the Applications field. You can also add MSW to your list of favorites.

Enabling the Workbenches

You must set the Use Plan/Sched Workbenches field within QAD EE Site Maintenance (1.1.13) so that your site is enabled to run the workbenches.

Fig. 2.5
Site Maintenance (1.1.13), Use Plan/Sched Workbenches Field

Select this field to enable the Planning and Scheduling Workbenches at this site.

Use Plan/Sched Workbenches. Select this field to enable the Planning and Scheduling Workbenches for this site.

No: You cannot run the MSW or PSW workbenches for this site. Use Work Order (16) and Repetitive Menu (18) programs as usual.

Yes: Setting this field to Yes lets you use the MSW or PSW for this site.

When a site is enabled to run MSW or PSW, you run MRP for the site to create planned orders; then within MSW, you run a search to retrieve the orders for the item/site.

So, when a site is enabled to run the MSW and PSW workbenches, Capacity Requirements Planning (CRP) runs as part of MRP for orders that have a P status. When CRP runs as part of MRP, the system:

- Explodes planned orders as they are created
- Lets you access the orders using the work center schedule resource in MSW

Setting this field to Yes also disables the following programs:

- Schedule Maintenance (18.2.1 and 18.22.2.1)
- Schedule Explosion (18.2.4)
- Cumulative Completed Maintenance (18.6)
- Line Schedule Workbench (18.22.1.10)
- Line Allocation Maintenance (18.22.1.11)
- Schedule Explosion (18.22.2.4)
- Cumulative Completed Maintenance (18.22.2.6)
- Planned Repetitive Schedule Approval (23.8)

When you enable the workbenches, the system recalculates schedule consumption that was calculated in these programs:

- Backflush Transaction (18.22.13)
- Reject Transaction (18.22.16)
- Rework Transaction (18.22.17)
- Scrap Transaction (18.22.18)
- Move Transaction (18.22.19)
- WIP Adjust Transaction (18.22.21)

Synchronize Resource Tables

Use Synchronize Resource Tables (16.25.14) to build or rebuild resource master (prs_mstr) and item/resource detail (prsd_det) tables. These tables hold production line, work center, and item information that the QAD Planning and Scheduling Workbenches use to determine which production lines, work centers, and items to retrieve as a result of a workbenches search.

You must run Synchronize Resource Tables:

- Before you run the planning/scheduling workbenches.
- For your domain if your company has multiple domains and use the planning and scheduling workbenches for each domain.

To run the program, you enable the Synchronize field to start the resource table synchronization. Once you do, the system deletes existing table records, then builds the table records again based on the latest data in the database.

For each production line, the system creates:

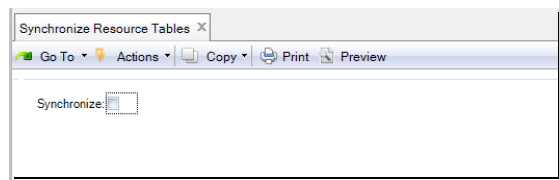
- A resource master record for every production line you define in the system.
- An item resource detail record for each production line item record attached to the production line.

For each work center, the system creates:

- A resource master record that links every work center in the system with each site you define in the system. The system skips work center/site combinations when the site has no production orders defined for it.
- An item resource detail record that associates the work centers on the routing records with the site and item on the production order.

Fig. 2.6

Synchronize Resource Tables (16.25.14)



Synchronize. Enter Yes to enable the synchronization of resources—work centers, production lines, and items—for use by the QAD Planning and Scheduling Workbenches.

Setting Up Production Lines

You can set up items on production lines to be updated in a mass update method within QAD EE:

- Use Production Line Item Create (18.22.1.20) to set up items on production lines in a mass setup method.
- Use Production Line Item Update (18.22.1.21) to update the production lines/item in a mass update method that you previously set up using Production Line Item Create.

Production Line Item Create

If you have used QAD EE for scheduling, you probably have production orders, but you may or may not have items on production lines set up. To create a repetitive master and production schedule for production lines, and not work centers, you must have items tied to a production line or lines. To avoid manual re-entry of setup data, you can use Production Line Item Create to:

- Mass set up items on primary production lines.
- Mass set up items on alternate production lines.

This ensures that the MSW/PSW displays data and alerts the scheduler of all items requiring attention.

Since this program automates the setup of items on production lines, it also reduces the chances of newly introduced items not being added to a production line, which would prevent you from scheduling the item.

The program locates sites where the item routing contains a specified work center/machine, and for those items, associates the items with a specified production line. If the item has no routing (no item/resource record), the program does not find the item to associate with a production line.

The output report contains the following information:

- For each item, the current primary production and alternate production lines
- For each item, the new target production line

Fig. 2.7
Production Line Item Create (18.22.1.20)

Process items for this Work Center/Machine:

Work Center: Machine:

Assign items to this Site/Production Line:

Site: Production Line:

Update: ☐

Process Items for this Work Center/Machine:

Work Center. Items processed by this work center within the routing.

Machine. Items processed by this machine within the routing.

Assign Items to This Site/Production Line:

Site. The site to process.

Production Line. The production line to associate items to for the update.

Update. Specify Yes to update according to criteria you set here.

Production Line Item Update

You can use Production Line Item Update to mass update the setup. Use the program to:

- Apply the default production line run rate against all items on a production line.
- Apply run rates to production lines.
- Make a production line the primary line.
- Delete items from a production line.
- Update the Pur/Mfg code for all items on a production line when you have not historically maintained the Pur/Mfg code. The following table shows you the Pur/Mfg codes for production orders and order types. This information is useful when you have not maintained Pur/Mfg codes before.

Table 2.1
Pur/Mfg Codes for Production Orders

Pur/Mfg Code	Production Order Status	Production Order Type
N/A	P	Generic
Blank	F	Discrete
M	F	Discrete
L	E	Repetitive
All others	F	Discrete

Fig. 2.8
Production Line Item Update (18.22.1.21)

Production Line Item Update

Go To Actions Copy Print Preview Attach

Site: 10000 Production Line: 001a

Site: 10000

Production Line: 001a

Delete Items: ☐

Make Primary Line: ☐

Change Pur/Mfg Code: ☐

Update Run Rate: ☐

Effective Date:

Update: ☐

Site. The target site for the production line/items.

Production Line. The target production line/items for applied actions.

Delete Items. Lets you remove all items from production lines.

Make Primary Line. Lets you change the primary line of the existing item/production line target relationship.

Update Run Rate. Lets you apply the production line run rate against all items assigned to the target production line.

The Effective Date field associated with the Update Run Rate field informs the system of the starting point at which to update production line records. For example, you may only want to update recent records to reflect the new run rate but not older records because your company retains older records for historical purposes.

Change Item Pur/Mfg Code. Lets you change the item master and site master (if it exists) Pur/Mfg code on all items associated with the production line.

MSW User Preferences

The following topics discuss options available to you when configuring MSW:

- Setting the MSW Schedule Horizon
- MSW Display Preferences
- MSW Consume Prior Remaining Capacity
- MSW Scheduling Preferences

Setting the MSW Schedule Horizon

You can configure the scheduling horizon so that you work with the number of days that make up your company's master schedule.

You can change the schedule horizon dynamically through the Preferences pull-down menu. You select Options, then Preferences, then Search to set the future and history horizon.

Note Before you search, you need to set the schedule horizon; see “MSW Scheduling Preferences” on page 32.

Note Fields in Work Center Maintenance (14.5) also display in Production Line Maintenance (18.1.1) and help control the schedule horizon end and the number of periods within the schedule horizon. The Preferences settings control how far out in time you can view dates on the Schedule Grid; see Figure 2.9.

Fig. 2.9
Preferences

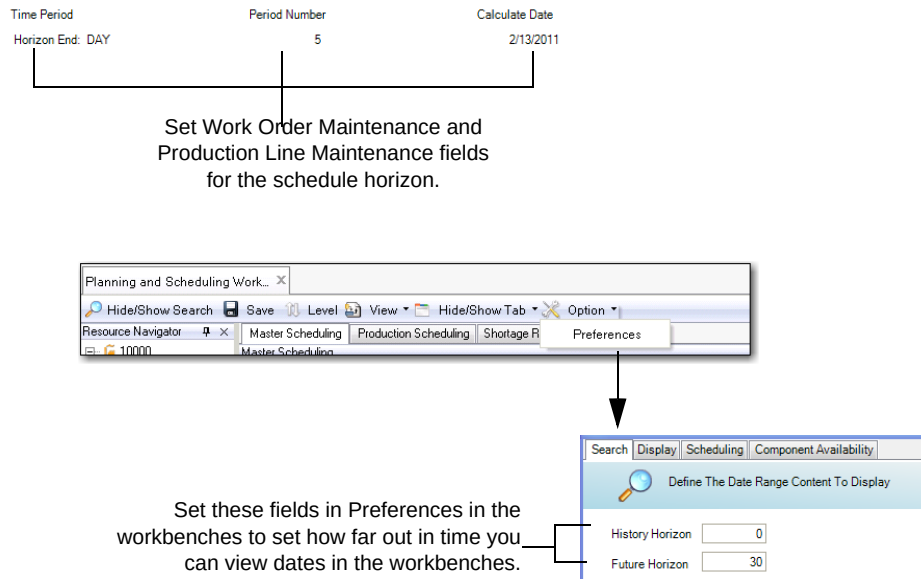
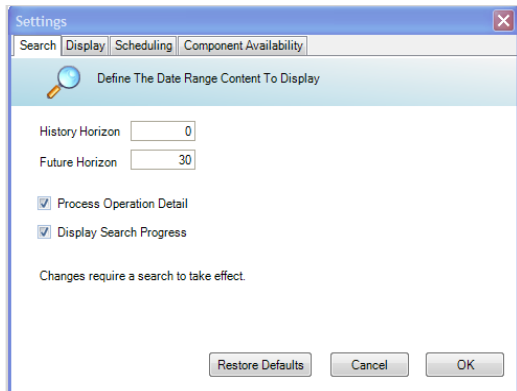


Fig. 2.10
MSW, Search Preferences



History Horizon. Enter the number of days that constitute the past days of your history horizon. Once you set the History Horizon, you must perform a search to have data within the set horizon.

Future Horizon. Enter the number of days that constitute your future horizon.

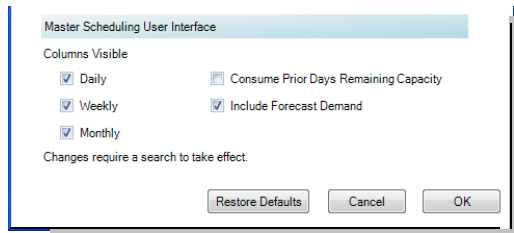
Process Operation Details. Indicate Yes for MSW to retrieve and display operation details for production orders.

Display Search Progress. Specify Yes or No to have the system display its progress when retrieving records. Depending upon search criteria that you set, the number of records that the system retrieves can be quite large. If you set this field to Yes, the system informs you of its progress in minutes to retrieve the records. For more information, see "Limitations" on page 14.

MSW Display Preferences

Use the Display tab of the Settings window to define the increment by which MSW calculates totals. Select Option, Preferences, then the Display Tab.

Fig. 2.11
MSW, Display Preferences



Columns Visible. Specify Daily, Weekly, or Monthly as the increment by which scheduling totals are displayed in the Schedule Grid. When you enter a value, the totals in the Supply/Demand Panel, Capacity Panel, and Schedule Grid display by the increment you enter. You still view data by daily increments in the Schedule Grid. When you select weekly or monthly, you must expand those increments to access the daily display. MSW uses the calendar definition of a month and the GL calendar period for the week.

Include Forecast Demand. Specify Yes to include the forecast demand in the Demand row in the MSW Supply/Demand Data grid as part of the POH calculation.

For forecast demand, the system displays the net balance of current forecast demand from QAD EE for the selected item. Master production scheduling and MRP use the net forecast and sales order demand to calculate total demand. The net forecast is calculated as follows:

$$\text{Net Forecast} = \text{Forecast} - \text{Sales Order Demand}$$

Note When the shipment forecast is oversold—that is, the quantity sold exceeds the forecast amount—the net forecast will not go below zero.

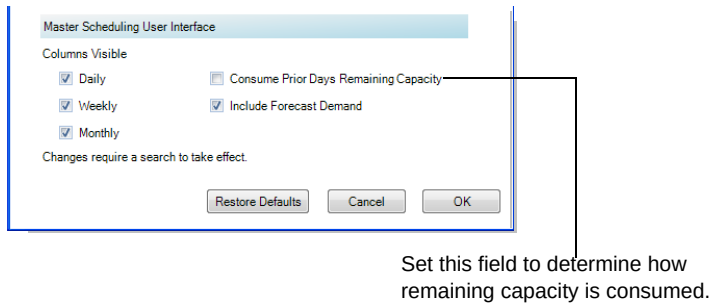
Past due is not calculated.

Consume Prior Remaining Capacity. For information on the Consume Prior Remaining Capacity field, refer to “MSW Consume Prior Remaining Capacity” on page 30.

MSW Consume Prior Remaining Capacity

You can specify whether capacity is consumed by future required capacity or not by setting the Consume Prior Remaining Capacity field in the Display Window of User Preferences. Color coding extends beyond the firm scheduling horizon for visibility of capacity shortages. When you set the field to Yes, the cell displays with yellow shading when the system uses available capacity from prior days to satisfy the required capacity. It displays with red shading when there is not enough available capacity on or in days prior to the required capacity date.

Fig. 2.12
Display Window, Remaining Capacity Setup



Consume Prior Remaining Capacity. Specify whether prior days remaining capacity is consumed by future required capacity.

Yes: The prior days remaining capacity is consumed by future required capacity. In Figure 2.13, on Tuesday, 7/13, 12.5 hours of capacity are required; however, only 8 hours of capacity are available. When this field is set to Yes, the system looks at remaining capacity before Tuesday to determine whether the Tuesday work can be completed on time. The system finds 8 hours of available capacity on Monday 7/12. So, if the Tuesday work starts on Monday, then 4.5 hours can be used from Monday, and all Tuesday work can be completed on time.

No: The prior days remaining capacity is not consumed by future required capacity.

Fig. 2.13
Capacity Example 1

Master Scheduling													
Capacity													
Resource ID	Horizon Start	Horizon End	Record Type	Past Due	Tuesday	Wednesday	Thursday	Friday	Saturday	Sunday	07/05 - 07/	Monday	Tuesday Wednesday
pl-asm	7/12		Remaining Capacity	-18	0	-18	6	8	7	4.7	15.7	3.5	0.3
			Planned Capacity		0	8	8	8	7	8	39	8	8
			Required Capacity	18	18	0	2	0	0	3.3	23.3	0	12.5
			Scheduled Quantity	180	180	0	20	0	0	33	233	0	125

Figure 2.14 shows results when the field is set to No. In the figure, the number of remaining capacity hours for Tuesday shows as -18. Tuesday 7/12 displays -4.5 hours remaining and the system did not consume prior remaining capacity available on Monday. The system displays colors beyond the firm scheduling horizon for the capacity frame.

Fig. 2.14
Capacity, Example 2

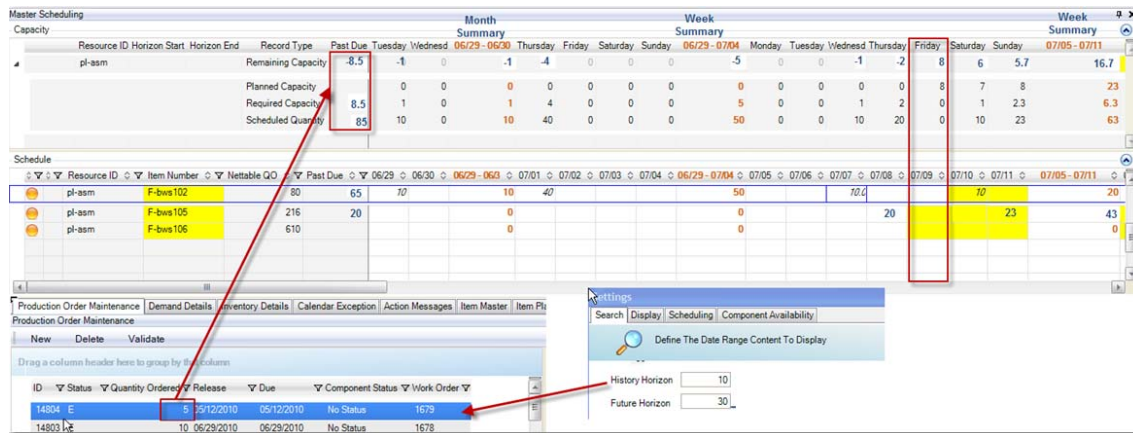
Master Scheduling													
Capacity													
Resource ID	Horizon Start	Horizon End	Record Type	Past Due	Tuesday	Wednesday	Thursday	Friday	Saturday	Sunday	07/05 - 07/	Monday	Tuesday Wednesday
pl-asm	7/12		Remaining Capacity	-18	-18	8	6	8	7	4.7	15.7	8	-4.5
			Planned Capacity		0	8	8	8	7	8	39	8	8
			Required Capacity	18	18	0	2	0	0	3.3	23.3	0	12.5
			Scheduled Quantity	180	180	0	20	0	0	33	233	0	125

The remaining capacity row displays a daily delta between the required capacity and planned capacity with no consumption of remaining capacity of prior days. For the daily delta calculation:

- The firm scheduling horizon still excludes planned orders.
- The future horizon includes all open orders.

In the following figure, the history horizon was set to 10 days, the future horizon was set to 30 days, and the current date is Friday, 07/09. The past due column totals display past due records; however, the history horizon columns display past due requirements in the Monthly and Weekly Summaries categories. The past due quantity of 5 from 5/12/2010, as shown in the Production Order Maintenance window below the grid, is summarized in the Past Due column. Even though the history horizon is 10 days, the system pulls in all past due supply/demand records.

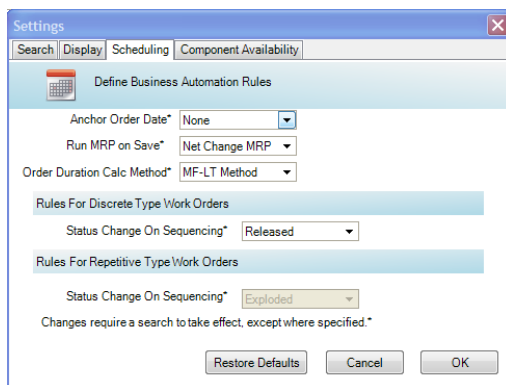
Fig. 2.15
History Horizon, Daily Net Calculations



MSW Scheduling Preferences

QAD EE applies a set of rules based on the production order status. You can set preferences for the rules under the Option menu in the toolbar. Select Preferences, then Scheduling.

Fig. 2.16
MSW, Scheduling Window



For MSW, you can set options to:

- Run MRP on save.
- Select the method for duration calculations.

Run MRP on Save

Run MRP on Save. Optionally, you can run MRP when you save your changes in MSW. Choose from:

Select Net Change MRP: The system runs MRP for all changes made within MSW.

Selective Change MRP: The system runs MRP for only selected portions of the schedule that you changed in MSW.

None: MRP is not run when saving changes.

There are additional steps required to run MRP:

- Set up a batch in Batch ID Maintenance (36.14.1). Set the following fields:
 - Set Permanent to Yes.
 - Set the Priority to your desired priority.
- Run Net Change Materials Plan (23.1) with the Batch ID and the set of values that you want to run for MSW / PSW.
- Run Batch Request Processor (36.14.13) in the background. Set the following fields:
 - Set the Batch ID.
 - Set Repeat Processing to Yes.
 - Set Pause Seconds before Report to your preference.

The system checks whether there is a batch request after the number of seconds you entered pass, then it runs a batch when it exists.

Select the Method for Duration Calculations

You can set the Order Duration Calc Method in the Scheduling tab. This sets the method to calculate the order duration when the order is firmed, created, and modified (future). For more information on order duration, see “Projected Duration” on page 51.

Order Duration Calc Method. Enter the calculation method for duration. The default is MF-LT. You can change the duration calculation method during the scheduling process; the change is effective immediately.

MF-LT: Calculates with manufacturing lead time.

Order - Release Date: Calculates the release date using the order duration hour.

Order - Due Date: Calculates the due date using the order duration hour.

Processing Master Schedules

This section tells you how to process your master schedules using MSW. A generic procedure is provided, along with descriptions of the fields within each grid. Individual tasks for the production orders that display follow the grid and field explanations.

MSW General Procedure

Before you begin, you should have set fields in Options under the Preferences pull-down menu; this includes setting history/future horizon, scheduling total options, and other scheduling options.

There are many different ways to access resource and scheduling data within MSW, and many different functions that you can perform using the data for a master schedule. The following provides instructions that tell you how you can leverage the MSW for master scheduling purposes using key information in the MSW:

- 1 From the Search Grid, select Scheduler ID for the first field, equals to in the operator search field, then your user ID in the third search field.

Note Scheduler ID is a method to group resources. This is not the same as the Planner or Scheduler ID within QAD EE programs.

The system displays resources and items related to the Scheduler ID. The system retrieves all transactional, demand, and supply records for items with dates that also match the History and Future Horizon values that you set in Options.

- 2 From the Views pull-down menu, select Save or Save As to save the view. If you select Save As, name your view, then save the view.

- 3 Identify resources and items that require scheduling intervention.

In the Scheduling Grid, items with scheduling issues have the item number field colored red or yellow depending on the issue at hand.

- Locate resources that have items with negative POH for every item with supply/demand within the scheduling horizon. The system reveals a visual indicator showing that one or more items on the resource have POH issues.
- Locate resources that have items with safety-stock issues within the scheduling horizon.
- Locate completed scheduled quantities and open scheduled quantities.
- Consider both static data and transactional data pertaining to the item. View any of the supporting data in the Supply/Demand Panel and view other details in the secondary tabs/browses, such as production orders, item planning, demand details, action messages, calendar exceptions and so on

- 4 Identify and correct capacity issues.

The Capacity Panel displays visual indicators for period available capacity issues through the scheduling horizon. If the daily required capacity is greater than planned capacity for a given day, the daily required capacity field for that day is highlighted in yellow. If the period available capacity is less than zero for a given day, that day is highlighted in red.

If the capacity is insufficient for the primary resource an item is produced on and you have set up alternate production lines for the item, you can assign the item to an alternate production line in Production Line Maintenance (18.1.1). You can select the alternate production line or work center from the Resource Panel when you select the Site in the Resource Panel.

You can adjust capacity, for example, through the Calendar Exception tab in the Workbenches. You can also use QAD EE menus to add or subtract workday hours as needed for a work center. You can adjust the required capacity by modifying order due dates.

- 5 Schedule items by:

- Changing the quantity of items in the daily buckets in the right side of the Schedule Grid. When there is more than one production order behind a cell in the Schedule Grid, that cell's quantity displays in gray text, indicating that the cell cannot be directly updated. In this case, you can modify the quantities related to the cell using the Production Order Maintenance tab.

- Retrieving the production order in Production Order Maintenance within MSW, then modifying the quantity, dates, or status of the order.
 - Modifying order operations, setup, or runtime
 - Aligning order dates
 - Creating a new production order
 - Deleting, copying, or splitting orders
 - Identifying and correcting capacity issues
- 6 Monitor a production order by displaying:
 - Order supply summary or history
 - Order details or attributes
 - Production rates or comments
 - Order dates, times, shop floor activities
 - Basic and detailed routing data
 - Inventory details
 - 7 Save your changes and optionally run MRP automatically upon the save.
 - 8 Repeat the process until issues have been resolved for all resources.
 - 9 Report production.

MSW Capacity Panel Data

This panel includes required capacity and capacity information for the selected resource on each day of the schedule horizon, starting with the current day. Also, you can expand and collapse the Capacity Panel to show schedule quantities in weekly and monthly buckets. The weekly and monthly buckets are display only.

Capacity calculations start from the current system date and include the daily capacity. If the capacity results in a negative value, the system attempts to consume the excess capacity available from previous days and continues the consumption until either the available capacity is zero or all previous days' excess capacity is consumed. The capacity calculation runs from the system date until the last day of the schedule horizon. When past due, the period available capacity is zero minus the past due required capacity.

In the Capacity Panel, you can optionally display the daily delta of required and planned capacity in the MSW. You can set the Consume Prior Remaining Capacity to No; you can see a daily delta calculation in the Remaining Capacity field. For more information, see “MSW Consume Prior Remaining Capacity” on page 30.

The following figure show how you can see capacity trends across resources—production lines and work centers—at the same time by selecting Site in the resource navigator. Or, you can see capacity trends across only your production lines, only your work centers, or only a particular resource.

Fig. 2.17
Capacity Panel

Resource ID	Horizon End	Record Type	Past Due	Thursday	Friday	Saturday	Sunday	07/23 - 09/07	Monday	Tuesday	Wednesday	Thursday	Friday
bmb1	08/31/2010	Remaining Capacity	-22.6	-10.5	12	0	0	1.4	2	12	12	12	12
		Planned Capacity		12	12	0	0	24	12	12	12	12	12
		Required Capacity	22.6	0	0	0	0	0	10	0	0	0	0
		Scheduled Quantity	226	0	0	0	0	0	100	0	0	0	0
san	07/23/2010	Remaining Capacity	-10	-10	0	0	0	-10	0	0	0	0	0

You can toggle the Capacity Panel to show only remaining capacity. You can optionally hide fields within the grid. When you collapse or hide aspects of the grid, however, you may lose sight of the firm schedule horizon dates that display in the grid. The panel includes the following fields:

Resource ID. The valid system identifier for the resource.

Record Type. The following are the different record types:

- Planned Capacity

This row displays the daily calculated capacity (in hours) based on production line or work center capacity parameters. It does not include past-due capacity; the Past Due column is always set to 0 (zero) and shows no hours.

The workbenches determine the planned capacity of a production line by considering the capacity defined for shifts in Shift Maintenance (18.22.1.22) and the number of production lines/machines available to the shift per the production line. The capacity defined in Shift Maintenance is always defined as the hours of operation for the production line with 24 hours maximum, regardless of the number of lines/machines the production line represents.

Example You define the production line capacity in terms of the operating hours within a day, maximum 24 hours. You also define the number of lines/machines the production line represents that the system uses to compute the total planned capacity of the production line. The system:

- Calculates the planned capacity on the MSW by taking the capacity defined in Shift Calendar Maintenance times the number of production lines, defined on the production line header record.
- Calculates the planned capacity on the PSW by taking the capacity defined in the Shift Calendar Maintenance for each shift times the number of production lines defined on the production line header record.
- Adjusts the current computation that calculates the weighted and shift level productivity to consider the number of lines on the production line header record.

For the workbenches, the planned capacity formula is:

*Working hours * Number of Lines*

Where:

Number of Lines is the number of lines/machines the system uses to process the production order. The system uses the Number Of Lines field also to calculate the production order duration by dividing the production run time/resources.

For standard capacity, the formula is:

Standard capacity = Working hours per week / working days per week

The repetitive formula for planned capacity is as follows:

*Planned capacity = shift hours (shift_hour[1-4]) * shift efficiency (shift_load[1-4]) / 100 + shift adjustments (cal_det)*

Where:

hd_mstr = holiday master

shft_det = shift detail

cal_det = calendar detail or non-work hours/days

The production order formula is as follows:

capacity = WC capacity + Sum of adjustments (cal_det)

The calculation for a production line is as follows:

Capacity per day = [Repetitive shift hours available - Downtime + /- Holiday Calendar]

The calculation for a work center is as follows:

Capacity per day = [Shop Calendar hours - Holiday Calendar]

The past due calculation is always 0 (zero).

- Remaining Capacity

Identifies the resource required capacity overages and shortages based on a period calculation to help you isolate scheduling issues; see “Consume Prior Remaining Capacity” on page 30.

- Required Capacity

Identifies the capacity required for this resource (the *load* for the resource). Capacity shortage is calculated as capacity minus the load.

The repetitive and production order period available capacity is as follows:

If capacity – DailyLoad < 0, then PAC = (capacity – DailyLoad + previous day capacity if > 0).

Previous day consumption continues until today.

If capacity – DailyLoad > 0 then PAC = (capacity - DailyLoad)

This calculation can be affected by future day consumption.

The past due period available capacity is as follows:

*Past due DailyLoad * -1*

The value is negative because it represents load that was due in the past. The calculation consumes just enough of the previous days’ available capacity to cover the current day’s gap. Since the calculation consumes previous days’ capacity, both previous and current days’ values are adjusted.

- Scheduled Quantity

Identifies the capacity, in terms of quantity, scheduled for this resource.

Horizon End. Displays the date that indicates the end of the schedule horizon.

Past Due. This field displays past due capacity requirements.

MSW Schedule Grid Data

The Schedule Grid displays item supply records—production orders—with bucketed quantities of the production order supply records for the item. The records represent the master production schedule for a given period. When you select an item by clicking a daily schedule cell, the entire row is highlighted within blue lining. Additional visual indicators call your attention to potential issues.

Also, you can expand and collapse the Schedule Grid to show schedule quantities in weekly and monthly buckets. The weekly and monthly buckets are display only.

When you make a change that remedies the problem, the system updates the cell to remove the color indicator.

Fig. 2.18
Schedule Grid

Master Scheduling											
Capacity											
◇ Production Li ◇ ▼ Record Type ◇ ▼ Past Due ◇ 11/08 ◇ 11/09 ◇ 11/10 ◇ 11/11 ◇ 11/05 - ◇ 11/12											
▶	A410	Remaining Capaci	-137.2	0	0	-113.2	24	-89.2			
Schedule											
◇ Production Li ◇ ▼ Item Number ◇ ▼ Nettable QO ◇ ▼ Past Due ◇ 11/08 ◇ 11/09 ◇ 11/10 ◇ 11/11 ◇ 11/05 - ◇ 11/12											
●	A410	A-F411	-10						0		
●	A410	A-F412	12						0		
●	A410	A-F413	5	20					0		
	A410	A-F410		927		5			5		
	A410	A-F414	10	180					0		
	A410	A-F415	10	245					0		

The following topics describe fields unique to the Schedule Grid. Other fields also found in other QAD EE programs are not described below:

Item Number. The valid system item number.

Nettable QOH. This column displays the nettable inventory on-hand. Nettable is an inventory status attribute that determines whether MRP includes items in its planning. As you scan items, use the data in this column to monitor inventory levels and easily identify inventory levels with issues or concerns.

Past Due. The MSW Past Due field displays past due scheduled quantities.

You can also display the run sequence of an item in the grid. If multiple items are produced on a single production line, efficiency can be improved by producing the items in a certain order. Run sequences let you control the order, or sequence, in which items are scheduled on a production line.

Working with Supply/Demand Panel Data

When the Schedule Grid displays the scheduled quantity for an item, the Supply/Demand Panel displays the remaining open quantity due for the item. Sources of demand can include forecasts, safety stock requirements, sales orders, customer scheduled orders, component requirements from manufacturing, and so on. Sources of supply include nettable QOH, production orders, production/purchase orders, supplier scheduled orders, and so on.

Fig. 2.19
Supply/Demand Panel

	Projected On Hand	100	100	100	100	100	100	100	100	100	100	100	100
Projected On Hand	100	100	100	100	100	100	100	100	100	100	100	100	100
Projected Available Balance	100	100	100	100	100	100	100	100	100	100	100	100	100
Supply	100												
Demand													
Cumulative ATP	100	100	100	100	100	100	100	100	100	100	100	100	100
Seasonal/Safety Stock													
Receipts													

When an item is highlighted, the system displays the following associated data in the Supply/Demand Panel:

- **POH**

The system displays the real-time projected inventory on hand for the item.

The projected on-hand calculation includes firm scheduled quantities from alternate resources for the item. So, for example, if you schedule item A on production lines 1 and 2, and item A has:

- Demand for 100 outstanding
- A production order for 50 on production line 1
- A production order for 100 on production line 2

Then, the system displays a POH of 50 for production line 1.

The repetitive projected QOH calculation is as follows:

$$WO\ Open\ quantity + Nettable\ Inv - Total\ demand$$

Where:

Nettable Inv = From MRP Detail (23.16)

Total Demand = Independent + dependent + forecast + seasonal

WO Open quantity = SNRD

The POH status for both repetitive and production orders derives from the POH calculation. If any POH for that item is below safety stock, POH status is set to safety stock status. If any POH is < 0, the POH status is set to below-zero status.

Additionally, the repetitive and production order PAC status derives from the POH calculation. If any POH for that item is below safety stock, POH status is set to safety stock status. If any POH is < 0, the POH status is set to below-zero status.

Past Due (Demand). The system displays past-due totals by demand type.

Note This includes all past-due demand for the item—not just demand from the specified historical period.

Record Type. The following are examples of the types of records that display:

- Independent demand

The system displays independent demand from QAD EE for the selected item.

This quantity includes confirmed sales orders, DRP orders, and type 3 (required ship schedule) customer schedules.

All demand values match quantities shown in MRP Detail Inquiry (23.16).

- Dependent demand

The system displays additional demand from QAD EE based on dependent demand from parent-level items for the selected item.

- Forecast demand

The system displays the net balance of current forecast demand from QAD EE for the selected item.

QAD EE stores forecasts by week. The workbench shows the entire forecast for the week on one day.

The system displays the net balance of current forecast demand from QAD EE for the selected item. Master production scheduling and MRP use the net forecast and abnormal sales order demand to calculate total demand. The net forecast is calculated as follows:

$$\text{Net Forecast} = \text{Forecast} - \text{Sales Order Demand}$$

When the shipment forecast is oversold—that is, the quantity sold exceeds the forecast amount—the net forecast will not go below zero.

- Seasonal/safety stock

The system displays seasonal build quantities as well as safety stock.

The system performs the following calculation for each date when a master scheduled receipt is due or a seasonal build quantity is made available, causing a net increase in supply. It takes into account all sales order and required ship schedule demand and gross requirements up to the next increase in available supply.

$$\text{Master Scheduled Receipt} - \text{Sales Orders and Required Ship Schedules} - \text{Gross Item Requirements} - \text{Seasonal Build Net Increases} + \text{Seasonal Build Net Decreases} = \text{ATP}$$

- Receipts

The system displays supply from order receipts, such as production order receipts.

- Production Forecast

When you establish planning bills and forecast and master schedule at the family-item level, the system automatically calculates the derived demand for components of the family or upper-level item. These calculations are based on the ATP quantities for the family-level item and the quantity per and forecast percentage for the components of that family item. The result is called a *production forecast*, since it derives from the master production schedule and the forecast percentage specified in the planning bill.

- Planned Scrap

The number of items planned as unusable while producing the quantity.

Scrapped quantity displays on work order history and cost reports. The total GL cost of the rejected items posts to the scrap account.

Working with Production Orders

MRP generates planned orders, balancing supply and demand; however, when scheduling issues arise, you can manually adjust production order quantity, status, dates, and so on when you need to:

- Reduce the quantity to account for a capacity constraint.
- Increase the quantity by merging production orders into a single order.
- Increase the quantity because of an increase in demand during the scheduling horizon.

Important If you do not do not save your changes, the production order reverts back to its prior condition.

The following topics describe production order tasks that you can perform in MSW.

Scheduling Items

After you select the resource and item, you can make changes to production orders either in the Schedule Grid or under the Production Order Maintenance tab. Within the Schedule Grid you can:

- Update quantities directly in the daily buckets by entering new values.
- Create a new production order by entering the desired quantity.
- Delete an order by overwriting a quantity with a 0 (zero).

Modifying Production Order Quantities

Even though MRP generates planned orders, balancing supply and demand, in some cases, you may need to manually adjust the production order quantity. You can use MSW to do this. You can modify quantities directly in the Schedule Grid in any horizon period.

When you make a quantity change against a production order, the quantity change applies to the entire order, not just a specific operation. For example, if you change the quantity on work center A for operation 10, MSW applies the quantity change to the order and, subsequently, all operations related to the production order in question.

You cannot modify the value in Schedule Grid:

- If the Schedule Grid cell value represents more than a single production order
- If the order is closed

1 Select an item on the Schedule Grid.

2 Modify the value in the quantity column.

The system validates the quantity change can be made.

MSW updates all calculations. Color indicators may change.

Note You can also change the quantity using Production Order Maintenance within MSW.

Creating Production Orders

You may need to create a new production order from within MSW. For example, for repetitive scheduling, MRP may create a planned order to cover weeks' worth of requirements; however, you may need to level the supply by entering daily production quantities. For a discrete environment, sales representatives can enter new sales orders into the system, and if the current demand for the sales order exceeds supply, MSW displays a visual indicator depicting the shortage. Since MRP has not run yet, there is no planned production order to firm and so you can decide to create a new order.

Use the following procedure:

- 1 In the Schedule Grid, for the work center/machine/production line selected, enter a scheduled quantity for an existing item where no production order currently exists.

The system:

- Determines the order ID
- Obtains the default BOM/routing
- Sets the order status to F for a discrete order and E for a repetitive order
- Calculates operation load

Note The actual scheduling of operation due and start dates occurs after you save the order, while planned orders already have calculated operation load and due/start dates.

- Updates the workbench calculations
 - Updates Production Order Maintenance within the workbenches with new data.
- 2 Use Production Order Maintenance within MSW to complete other fields for the new production order.
 - 3 Click the Save button to save your changes.

You cannot create a production order from the work center resource on the Schedule Grid. The system does not backward calculate work order dates, so the operation date for that work center is the date you specify. For example, if you enter a quantity for date1 on the MSW Schedule Grid, the system creates a work order with a start date of (date1 – x) where x is the number of days for the preceding operations that need to complete. The order would have the operation for that work center on date1.

Calculating Dates for New Orders

When you create a new production order, the system needs to calculate the projected release and due dates of the production order and the operations.

You can select an item/date and enter a new quantity in the Schedule Grid. When you do, the system:

- Sets the due date to a date entered on the Schedule Grid
- Calculates the operation due date of all operations
- Calculates the order release date, which is based on MRP lead time days
- Updates the workbench with the resulting calculation

When you change the due date, the normal duration calculation rules apply. Normal duration is the default setting (MF-LT) for the duration calculation method that you set in the Scheduling tab of user preferences in the workbenches; refer to “Projected Duration” on page 51.

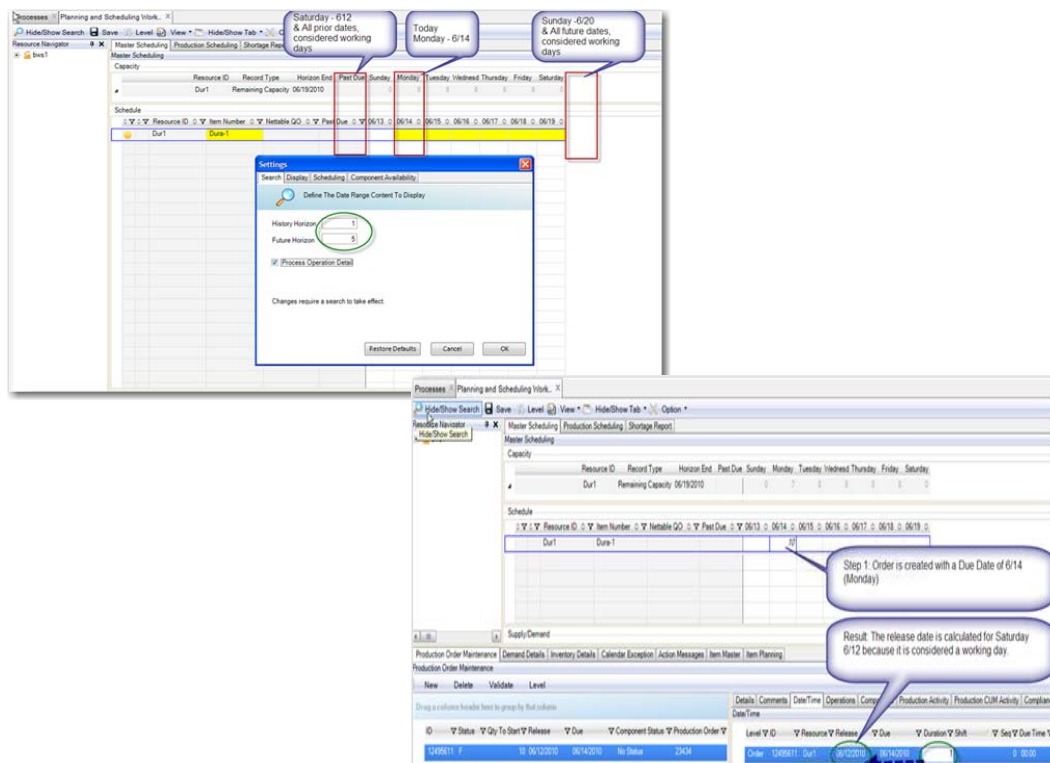
Setting Dates Prior to Horizon Dates

When you create a production order where the production order release date is calculated prior to the History Horizon dates, the system calculates the release dates.

Example Today is Monday 6/14. You set the History Horizon field for one day and the Future Horizon field for five days, then create an order with a due date of 6/14 for an item with a manufacturing lead time of 1 day. The system calculates the release date for Saturday 6/12 because it is considered a working day.

When determining dates in the past, MSW considers working days in the past; however, if you set a date that is beyond the history horizon, MSW treats every day beyond the history horizon as a working day. This also is true for dates beyond the future horizon. The Schedule Grid shows all dates between the start of the history horizon and the end of the future horizon, including working and non-working days.

Fig. 2.20
Example Dates Prior to Horizon Date



Scheduling Discrete Production Orders on a Production Line

You can use Work Order Maintenance (16.1) in QAD EE or the Production Order Maintenance function that displays inside the MSW to schedule a discrete work order on a production line.

To report production, you should use the normal discrete shop floor production reporting programs in the Shop Floor Control menu (16.20). A production order is defined as discrete or repetitive by:

- Discrete order: Type is blank or standard.
- Repetitive order: Type is S(scheduled).

If the item you specify on the order is line scheduled (Pur/Mfg is L) in Item Master Maintenance, Item Planning Maintenance, or Item-Site Planning Maintenance, and the status of the order is not Released or Closed, then the system automatically changes the:

- Production order type to S

- Status to E

Otherwise, for a discrete order the Type is blank, and the Status is F. This occurs when Pur/Mfg code is blank or M(anufactured) for the item.

Modifying Production Order Status

You can manually change production order status to accomplish scheduling goals.

For repetitive environments, a production order can have a P, E, or C status.

For discrete environments, a production order can have a P, F, R, or C status.

You cannot change the status of an order with issued materials or reported production.

To modify production order status:

- 1 In the Schedule Grid, select an order and modify the order by changing quantity, date, and so on.
If the discrete order status is P, MSW sets the status to F.
If the repetitive order status is P, MSW sets the status to E.
MSW updates all workbench calculations. Color adjustments are made.
- 2 Click the Save button to save your changes.

Note You can also change the order status using Production Order Maintenance within MSW and update QAD EE records.

Auto-Firming Orders

In many businesses, MRP output is the starting point for master production scheduling. You can use the auto-firm function to quickly adjust orders and expedite your scheduling tasks. For discrete orders, you no longer need to approve planned production orders to change the status to F; for repetitive orders, you no longer need to approve planned production orders to change the status to E. Auto-firming is based on the order due date.

You cannot auto-firm these item types:

- Purchased (items with a P code in Item Master Maintenance (4.1.1))
- Configured
- Routable
- Phantom

You can run the auto-firm process daily in batch mode to avoid missing orders that require a status change.

You can auto-firm orders using programs that are external to the workbenches. The programs firm planned orders for your work centers and production lines for a specific horizon or a range of dates. The program can run in batch mode nightly.

Use the following procedure:

- 1 Use Batch ID Maintenance (36.14.13) to define a batch ID.
- 2 Use Batch Request Processor (36.14.13) to run the batch ID you created, or you can use the `qpsbatch` ID that is supplied with the system.

Note To run the batch daily, ensure that you set Repeat Processing to Yes.

- 3 Use any of the following to auto-firm planned orders:
 - Set Process All Planned Orders in Scheduling Horizon to Yes in Auto Firm Planned Orders (22.13.3).
 - Optionally, set a date in the Last Auto Firm field.

Note You must set Auto Firm to Yes in both Production Line Maintenance and Work Center Maintenance if you auto-firm for production line and work center resources. If Auto Firm is set to No in these programs, the system does not firm any planned orders. You can see the Auto Firm field status and the date of the last auto-firm in work center and production line browses in QAD EE.

- 4 View the firm orders in MSW.

Planned production orders for items scheduled on production lines display as firmed on the primary production line once you auto-firm them. For discrete production orders, that status changes to F. For repetitive production orders, the status changes to E.

Modifying Production Order Dates

You can modify production order header dates in MSW to help you manage the due and release dates of production orders. Use the following procedure:

- 1 Select the Production Order Maintenance tab within MSW.
- 2 In the order summary list, modify dates in the Due Date or Release Dates field; see Figure 2.21.

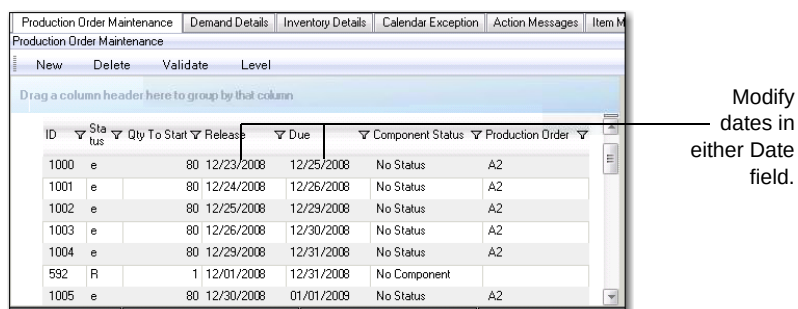
When you modify the due date, MSW updates workbench calculations and other calculations impacted by order due date and quantity.

When a due date is changed, the system changes the corresponding release date so that the lead time from item planning remains the same.

If changing dates for a production line, MSW updates the production line required capacity; if changing dates for a work center, there is no impact.

- 3 Click the Save button to save your changes.

Fig. 2.21
Production Order Maintenance, Date Fields



ID	Status	Qty To Start	Release	Due	Component Status	Production Order
1000	e	80	12/23/2008	12/25/2008	No Status	A2
1001	e	80	12/24/2008	12/26/2008	No Status	A2
1002	e	80	12/25/2008	12/29/2008	No Status	A2
1003	e	80	12/26/2008	12/30/2008	No Status	A2
1004	e	80	12/29/2008	12/31/2008	No Status	A2
532	R	1	12/01/2008	12/31/2008	No Component	
1005	e	80	12/30/2008	01/01/2009	No Status	A2

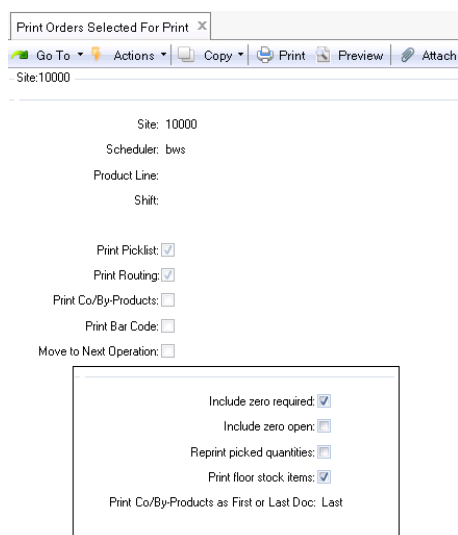
Releasing and Printing Production Orders

You can print production orders from the MSW. To do this:

- 1 Select orders for print.
- 2 Save the production orders you want to print.
- 3 Use QAD EE Print Orders Selected For Print (16.5); see Figure 2.22.

The orders selected on the MSW/PSW print. The Selected for Print field is cleared in MSW's Production Order Maintenance.

Fig. 2.22
Print Orders Selected for Print (16.5)



Print Orders Selected For Print

Go To Actions Copy Print Preview Attach

Site: 10000

Site: 10000

Scheduler: bws

Product Line:

Shift:

Print Picklist: ☒

Print Routing: ☒

Print Co/By-Products: ☐

Print Bar Code: ☐

Move to Next Operation: ☐

Include zero required: ☒

Include zero open: ☐

Reprint picked quantities: ☐

Print floor stock items: ☒

Print Co/By-Products as First or Last Doc: Last

Note You can only print released orders with the Print Orders Selected for Print function.

Deleting Production Orders

You can delete a production order from within MSW, using the Production Order Maintenance tab.

You cannot delete an order that has production reported for it.

Use the following procedure:

- 1 Select the Production Order Maintenance tab within MSW.
- 2 Select the order from the summary list.
- 3 Click the Delete button.
- 4 Click the Save button to save your changes.

Viewing/Editing Order Data

The following topics discuss the data that displays in the MSW. Field explanations are included.

Working with Order Summary List Data

When you select items in the Schedule Grid, you can manipulate order data through two-sided Production Order Maintenance functions. The left side includes a summary list, while the right side includes details.

The summary list starts with orders that have operation due dates on the selected day. To view past-due orders, click the up arrow in the summary list. To show additional records for the current day or for future days, click the down arrow. The sequence in which orders are listed is based on the due date of the order and the production order ID.

You can update some fields directly in this panel. Changes applying to the production order itself update QAD EE when they are saved.

Fig. 2.23
Summary List

ID	Status	Qty To Start	Release	Due	Component Status	Production Order
1000	e	80	12/23/2008	12/25/2008	No Status	A2
1001	e	80	12/24/2008	12/26/2008	No Status	A2
1002	e	80	12/25/2008	12/29/2008	No Status	A2
1003	e	80	12/26/2008	12/30/2008	No Status	A2
1004	e	80	12/29/2008	12/31/2008	No Status	A2
592	R	1	12/01/2008	12/31/2008	No Component	
1005	e	80	12/30/2008	01/01/2009	No Status	A2

Production Order. The production order identifier. This can be the system-generated order ID from QAD EE. If you enter a new order, the system retrieves the next available number from QAD EE or you can optionally enter your own production order value.

ID. A production order lot identifier. The production order number and lot ID work together to identify a specific production order. The same production order can be used with different lot IDs.

St(atus). The current status of the order. With some restrictions—for example, you cannot change a firm order back to planned—you can update the status as needed. When you save your changes, the system updates the QAD EE order with the new status.

Release. The date this production order is scheduled to be released to production. The date you enter here changes to the actual release date when you release and print the production order. Release dates also determine the date components are required. Normally components are picked when an order is released.

The system calculates either release or due date, creating, in effect, forward or backward order scheduling.

Due. The due date defaults to today's date plus the manufacturing lead time for the item. The due date is the date this order is due to be completed. This is the date you plan to have product available for shipment to the customer or issue to another manufacturing order. All MRP plans are based on this due date.

Working with Order Detail Records

When you click a cell in the daily supply grid, the system lists production orders for the associated item.

Field explanations are organized by tabs in the Order Detail portion on Production Order Maintenance, starting with the Details tab and ending with the Accounting Data tab.

Details Tab

The following topics discuss fields in the Details tab. Field explanations are summarized. For full field explanations, refer to the field help for Work Order Maintenance (16.1) for QAD EE.

Fig. 2.24
Production Order Maintenance, Detail Window

Quantity Ordered. The quantity to be produced on this production order, expressed in the item unit of measure.

Quantity Open. This field is display only and shows the scheduled order quantity that the system uses to calculate the duration of a production order. The system uses this quantity to calculate run time.

Yield. Enter the percentage of the number of items built on this production order expected to be in usable condition. Yield defaults from item-site or item planning data.

Primary Line. This field displays whether the line is the primary production line. You set up a primary production line in Production Line Maintenance (18.22.1.1). You can use Production Line Item Update (18.22.1.21) to view primary production lines. You can also update a production line and make it the primary line with Production Line Item Update (18.22.1.21).

Site. The site associated with this production order.

Order Type. This field is display only and depicts the type of order. For most production orders it is blank. In addition to the blank type, other production order types include the following:

- **R(ework).** No routing. The only item in the bill is the item being reworked. To calculate variances, manually enter bill and routing standards.
- **E(xpense).** No routing or bill. As with rework orders, enter a bill and routing to calculate variances.
- **F(inal Assembly).** Generated from sales orders. The standard item-site routing is used. The bill matches the sales order bill.
- **S(cheduled).** Generated by Schedule Maintenance (18.22.2.1). Not normally processed using Work Order Maintenance (16.1), but they can be changed to standard production orders by changing the status from Exploded to Allocated or to Released. After you do this, the system changes the type to blank. Also, the system updates the repetitive schedule to exclude it.
- **C(umulative).** Generated by repetitive feedback transactions to collect costs. Not accessed by production order functions.
- **W(ork Flow).** Generated by Flow Schedule Maintenance when you enter a flow scheduled order that does not reference an existing production order. Not accessed by production order functions.

Scheduled Line. Enter the scheduled line for the order. You can use the drop-down list to select a scheduled line.

Sales/Job. This is an optional code associating this order with a specific sales/production order. For a new order, the default is blank.

Production Rate. Enter the standard run rate for the production line. When you update the value here, the system recalculates the production order run time.

Supplier. The supplier associated with this order.

CUM ID. This field is display only and shows the system cumulative identifier.

Run Time (Hrs). This field informs you of the amount of run time that is required to produce the production order. When you update the production rate, the system recalculates the run time. It calculates the new required capacity (run time + setup time).

The calculation for run time is:

$(Open\ quantity / Run\ Rate) * Production\ Line\ Productivity\% * Run\ Crew\ Productivity\%$

Where:

$Run\ Crew\ Productivity\% = 1 + ((WO\ run\ crew\ size - PL\ run\ crew\ size) / PL\ run\ crew\ size) * 100$

Note The system only calculates this if the Run Crew Enabled field is Yes on the production line header record; otherwise, the value is always 100%.

$Production\ Line\ Productivity\% = Shift\ productivity\%$ if the order is assigned to a shift, otherwise it is a calculated weighted average %.

Run Crew Size. Enter a number that reflects the size of the run crew. The number affects the order run time if you set Run Crew Enabled to Yes on the production line header record. When you update the run crew size, the system recalculates run crew productivity, run time, and

required capacity of the production order. The standard run rate is based on a run crew of two people as the standard.

When you change Run Crew Size in Production Line Maintenance, it only affects orders created after that change has been made—not existing orders.

Note You can run a conversion for existing item records to populate the Run Crew Size field. See *Administration Guide: Planning and Scheduling Workbenches* for more information.

Number of Lines. Enter the number of lines/machines the system uses to process the production order. The default is 1 (one). The system uses it to calculate the production order duration by dividing the production run time by the number of lines/machines the production line represents. Changes to this field recalculate duration hours and duration days.

Run Crew Productivity. This field is display only and depicts the percentage of productivity for the run crew.

Duration Buffer (Hrs). Enter the number of hours for the duration buffer. This field also exists in Production Line Maintenance (18.1.1). Changes to this field recalculate duration hours and duration days. You can use this field to add miscellaneous time required to a production order.

Projected Duration Hours. This field is display only and represents the number of hours required to produce a production order. The workbenches calculate projected duration hours as:

(Required Capacity / Number Of Lines) + Duration Buffer

The system overrides the standard duration calculation with projected duration when you enable projected duration in the workbenches User Preferences or when you apply it to an order. The standard duration calculation is as follows:

Defaults = ML-LT for planned orders

The system calculates this planned capacity per delta of order release/due dates for non-planned orders when the orders are pulled into the workbench.

Projected Duration (Days). This field is display only and represents the number of days required to produce a production order. If you apply projected duration, the system determines a new order release/due date. When you update any of the following fields, the system recalculates the projected duration:

- Number of Lines
- Duration Buffer (Hrs)
- Run Crew
- Qty Ordered
- Production Rate
- Setup Time

Applying the projected duration in days helps you monitor production activity against the scheduled due date. As the production order is processed and you report against the order (daily), the quantity open is reduced; therefore, the required capacity is reduce. The Projected Duration reflects the current required capacity for the order, providing a projected remaining days the order requires to complete. You can then compare this value to the scheduled due date to validate that the order is on schedule.

Routing Code. This field depicts the routing code associated with the production order. BOM/routing codes default as they do in QAD EE programs.

Order Sheet Printed. Indicate Yes if you want to print the order sheet for this order.

Setup Time (Hrs). Enter the standard time in decimal hours required to prepare the work center to carry out the operation, independent of order quantity.

BOM/Formula Code. The identifier for the BOM/formula. Each BOM/formula consists of a parent and component. BOM/formula identifies the parent, usually an item number that has been predefined in Item Master Maintenance.

Release/Print. Indicate Yes to release or print this order; see “Releasing and Printing Production Orders” on page 46.

Required Capacity (Hrs). Identifies the capacity required or the total required capacity required to fully produce this production order.

Production Rate, Run Crew Size, and Required Capacity

When you change the Production Rate (run rate) or the Run Crew Size fields in the Production Order Maintenance Details tab in the workbenches, the system recalculates the production order required capacity.

The calculation for required capacity is:

$$\text{Run Time} + \text{Setup Time}$$

When you modify the Run Crew Size field, the system recalculates the Run Crew Productivity field value, Run Time field value, and the required capacity of the production order.

The calculation logic is as follows:

- The system verifies whether the field is set to activate the run crew size relationship to the run rate. If No, the run crew productivity remains a constant 100%.
- If Yes, the system calculates the run crew productivity by calculating the difference between the production line standard run crew size and the modified order run crew size and then dividing by the production line standard run crew size to get the percentage value.

Projected Duration

In the workbenches, you have two ways to apply the projected duration to the production order:

- Automatically

The system applies order duration automatically when you modify any field on the work order that recalculates an order's required capacity and/or projected duration hours. This includes such fields as Quantity Ordered, Production Rate, Run Crew Size, Setup Time, Number of Lines, and Duration Buffer in the Details tab of Production Order Maintenance in the workbenches as well as in Production Line Maintenance.

- Per user action in the workbenches grid

The system applies order duration when you change production order status from P(lanned) to any other status.

- When you right-click on a production order in the grid, and the system displays options to Calculate Release Date or Calculate Due Date from the pull-down menu

When the system calculates the order release and due date, the calculations are based on actual, not planned, input values for each production order. These calculations are only applicable within the workbenches and do not apply to planning/scheduling QAD EE functions outside of the workbenches.

The system calculates the production order dates based on User Preference settings:

- When User Preferences indicate to calculate the release date, the following rules apply:
 - From the order due date, working backward, the system determines the required release date by taking the projected duration hours and factoring in the available capacity hours in each working day until projected duration hours are met.
 - When the calculated release date pushes the release date in the past, the system sets the release date to today.
 - When the order release is in the past, the system sets the order release date to today and instead recalculates the due date of the order.
- When User Preferences indicate to calculate the due date, the following rules apply:
 - From the order release date, working forward, the system determines the required due date by taking the projected duration hours and factors in the available capacity hours in each working day until projected duration hours are met.
 - When the system calculates the order due date to a date beyond the future horizon, it sets the order due date equal to last day of the future horizon.

The system uses the method you specify to use for calculations through the Scheduling tab of the Preferences window; see “Order Duration Calc Method” on page 33.

Date/Time Tab

The following topics discuss fields in the Date/Time window.

Fig. 2.25
Production Order Maintenance, Date/Time Window

Level	ID	Description	Resource	Release	Due	Duration	Shift	Seq	Due Time
Order	tool-a	san	11/12/2010	11/12/20	0	0	00:00		

Level. This field displays either the order or operation.

ID. The routing operation number from the QAD EE production order routing detail record. If you create a new production order, the system determines the operation based on the routing. In addition to operation number, it can also refer to the production order number at the order level row.

Resource. The work center or production line identifier.

Release. The date this routing operation is scheduled for the item release. It can also refer to the production order release date when at the order level row.

Due. The date this routing operation is scheduled to complete work on this order. It can also refer to the production order release date when at the order level row.

The system validates that this date falls within the overall scheduling horizon defined by Historical Schedule Days and Future Schedule days in the site Configuration record.

Duration Days. The time, in days, between the release date and due date. Duration is calculated only at the order level and takes into account working and non-working days in its calculation. This is a decimal field that you can update.

Shift. This field depicts the shift defined for the resource. Shift schedules define how many days a week and how many hours the work center or production line is run. When you change the shift, it may change the production productivity percentage, which in turn may change the production order required capacity, and ultimately, change the projected duration days and hours.

Seq. This is the production sequence for the order. This field tells the system in which order to process orders as part of the production schedule that you create in PSW. You can set the Sequence value here manually, set it within PSW manually, or use the drag-and-drop method in PSW to set it.

Due Time. Optionally enter the time of day that this order should be completed.

Enter the time in HH:MM:SS format based on a 24-hour clock. For example, enter 1:30 pm as 13:30:00.

This field is for reference. It appears on some reports and inquiries, and can be used to introduce a greater level of detail into the sequence of activities on a production line.

Operations Tab

The following topics discuss fields in the Operations window. Only those fields not previously described for other MSW windows are described. You cannot change values in the Operations fields.

Fig. 2.26
Production Order Maintenance, Operations Window

The screenshot shows the 'Operations' window in the Production Order Maintenance system. On the left, there is a list of operations with 'Op' 10 and 20. The main area is divided into three sections: Standard Operation (bmb2a), Operation Duration Control (Run Time: 1.000, Setup Time: 0.000, Machines per Operation: 1.000, Required Capacity: 11.00), and Interoperation LT Control (Queue Time: 0.000, Wait Time: 0.000, Move Time: 0.000, Overlap Units: 0.000).

Op. The number identifying the operation in the routing or process.

Standard Operation. The valid standard operation code that identifies a process operation common to several products or applicable to different routings in different sequences.

Status. This field displays the production order status codes correspond to stages in the order's life cycle:

- Planned

- Firm planned
- Batch
- Exploded
- Allocated
- Released
- Closed

The status of an order determines how much control you have over its bill, routing, inventory allocations, inventory transactions, and labor feedback. An order progresses from one status code to the next and, unless prematurely released, does not return to an earlier status.

Work Center/Machine. A valid work center identifier for an individual machine, group of similar machines, or subcontract supplier. Work center and machine code work together to identify a work center, which is a basic production unit used in manufacturing and control.

Tool Code. Optionally, enter the code for a tool normally used during this operation. This is for reference only. To standardize tool codes, set them up in Generalized Codes Maintenance (36.2.13) for field ro_tool.

Setup, Run, and Move Time. Enter the standard times, in decimal hours, to process items during this operation. Run time is per unit; setup and move time are independent of order size.

Machines per Operation. The number of machines per operation. As the number of machines increases, work center capacity and the number of hours a work center is available for work also increase. The number of machines per operation is also used for calculating the lead time and machine burden cost for an operation.

Queue Time. The standard time, in decimal hours, a production order normally spends waiting at this work center before it is set up and processed.

Wait Time. The standard time in decimal hours that a production order normally spends waiting at this work center after processing has completed.

Overlap Units. The number of units that must be completed at this operation before work can begin at the next operation.

Components Tab

When you click the Components tab, you can view a summary list of components for the order, then view supply/demand summary, supply/demand detail, and inventory detail by site data.

Note The components you view only go one level down in the BOM, except for phantom items where the system displays components in the BOM until it finds a non-phantom component.

This information is useful when you use the Component Availability Check features; for more information, see “Component Availability Check (CAC)” on page 79.

Production Activity Tab

Use the Production Activity window to track production order activity. For an order, you can view the operation and description, open completed, rejected, and reworked quantity; the actual run time; and the actual setup time. The actual time shows the time required to manufacture a single unit. Run time for an operation is a function of total run time, work center or shop calendar hours, and the machines per operation. Run time is expressed in terms of an hourly production rate.

This time is differentiated expected run time. The actual time is the time required to set up a resource.

Fig. 2.27
Production Order Maintenance, Production Activity Window

Production Activity									
Level	ID	Open Quantity	Actual Qty Completed	Actual Qty Rejected	Rework	In Queue	Out Queue	Actual Run	Actual Setup
Order	151110	4	2	0					
Operat	20	11	1	0	0	0	0	0	0
Operat	10	11	1	0	0	0	0	0	0

Production CUM Activity Tab

Use the Production CUM Activity window to track cumulative order activity. For an order, you can view the CUM ID, the quantity processed, rejected, or in the reject queue; the number scrapped, reworked, and the number in and out of the queue. You can also see the actual run time and the actual setup time.

Fig. 2.28
Production Order Maintenance, Production Cum Activity Window

Production CUM Activity									
Level	Cum ID	Open Quantity	Actual Qty Completed	Actual Qty Rejected	Rework	In Queue	Out Queue	Actual Run	Actual Setup
Order		4	2	0					
Operat	20	11	1	0	0	0	0	0	0
Operat	10	11	1	0	0	0	0	0	0

Compliance Tab

Some features of production orders are affected when you use the Regulatory Attributes module. When Regulatory Attributes is active, you can assign batch numbers, restrict items issued to an order, restrict items received, and enforce stricter lot/serial control rules. The Compliance window of the workbenches lets you view Regulatory Attributes data.

The following topics discuss fields in the Compliance window. Only those fields not previously described for other MSW windows are described.

Assay Percentage. The presence, absence, or quantity of one or more components, usually expressed as a percentage.

Grade. Identifies the quality or physical properties of an inventory quantity. Graded products include raw materials, intermediates, and finished goods.

Expire Date. The expiration date for items that eventually spoil, and for pharmaceuticals that lose potency over time.

Receipt Status. The default receipt status for the order.

Active. Indicates whether the inventory status code entered in Receipt Status should override status assigned in item, site, and location data.

Batch. An arbitrary number for tracking a quantity scheduled to be produced or in production.

Single Lot. Determines whether each receipt from a production order should be assigned to a single lot. This is a default setting you can change at receipt.

Lot Number. The lot number for this production order. Enter a lot number in this field.

Accounting Data Tab

The following topics discuss fields in the Accounting window. Only those fields not previously described for other MSW windows are described.

WIP Account. The general ledger account code used to track work in progress (WIP) inventory values for the order.

Material Usage Var. Material usage variance is calculated as the difference between the actual and expected quantities issued, extended by the cumulative order operation component cost. The expected issue quantity is the cumulative order operation standard quantity required per unit multiplied by the quantity processed at the operation.

Material Rate Var. When you issue components to a production order, material costs post to WIP as the quantity issued and multiplied by the GL cost of the material. Rate variance is calculated as the difference between the GL cost of materials used and the GL cost of materials required.

Subcontract Usage Var. Usage variance is an efficiency variance, calculated as the difference between the subcontracted quantity received and the standard subcontract quantity needed to make this order quantity complete.

Subcontract Rate Var. Rate variance is calculated as the difference between the order cost and the standard subcontract cost.

Mix Variance Acct. Mix variance is calculated as the difference between the standard or expected quantity and the actual quantity received, multiplied by the GL cost of the item.

Floor Stock Account. The GL account code used to track WIP stock adjustments for bulk issue items on this order.

Item Specific Information

The following topics discuss the types of items with which you can work in MSW and explains item data that is presented in MSW.

The system displays a Schedule Grid including each item that can be produced on the selected resource—sorted by item number, scheduled due date, or item status—including the current quantity on hand and any past-due quantity. Vertical scroll arrows let you display additional items.

Note Items without supply/demand are not included in the workbench.

Color coding in the item field reflects the highest-priority situation for a day within the firm scheduling period. For example, if the projected on-hand for the item is negative for one day in the period, while another day's quantity is just less than safety stock, the item number cell is shaded red to reflect the more critical issue versus yellow for the less critical issue of being below the item's safety stock level.

When you select an item in the Schedule Grid, the system provides you with supporting information related to the resource and item combination in the form of several types of item and production information, as well as messages related to status indicators and sources of demand.

Use additional tabs within MSW for more item information as described in the following topics.

Item Master and Planning Tab

This section explains fields in the Item Master tab. Only those fields not previously described for other MSW windows are described.

Fig. 2.29
Item Planning Window

MRP Required	Safety Stock	Minimum Order	Order Multiple	Yield Percent	Order Policy	Order Period	Time Fence
Yes	100	0	0	100.00%	POQ	7	

MRP Required. The current value of the system-maintained MRP Required field in the QAD EE item master or item-site record. When this is Yes, the system has detected a change in such things as product structure, inventory, or transactional records that requires the item to be replanned.

Safety Stock. The safety stock quantity for the selected item defined in QAD EE item-site or item master records.

Minimum Order. The minimum quantity that can be placed on a single order for this item, as specified in QAD EE item-site or item master records.

Order Multiple. The order multiple specified for the item in QAD EE item-site or item master records. When Order Policy is POQ (period order quantity) or LFL (lot for lot), MRP rounds net requirements for the item up to the next multiple of this number.

Yield Percent. The yield percentage specified for the item in QAD EE item-site or item master records.

Order Policy. The order policy specified for the item in QAD EE item-site or item master records. This value determines the method MRP uses to plan orders for this item.

Order Period. The order period specified for the item in QAD EE item-site or item master records. This is the length of the planning period MRP uses when Order Policy is POQ (period order quantity).

Time Fence. The time fence specified for the item in QAD EE item-site or item master records. This is the number of days inside of which MRP does not replan this item.

Safety Time. The number of days of safety time specified for the item in QAD EE item-site or item master records. MRP adjusts actual need dates by this value as protection against late deliveries.

Manufacturing Lead Time. The manufacturing lead time defined in QAD EE Item-Site Planning Maintenance (1.4.17) or Item Master Maintenance (1.4.1).

Cumulative Lead Time. The total cumulative lead time for the item from QAD EE item-site or item master records.

Buyer/Planner. The user ID of the buyer/planner specified for the item in QAD EE item-site or item master records.

Purchase/Manufacture. The code indicating how this item is typically processed by the system. This code controls how the system explodes forecasts, plans and creates orders, and calculates costs for the item. It affects MRP and DRP.

Phantom. This field indicates whether an item is normally stocked or simply put together as part of a higher level assembly. When Yes, the item and its product structure are phantoms, typically used for transient assemblies or intermediate products.

Order Quantity. The standard production quantity defined in QAD EE item-site or item master records.

Alternate. An alternate item should the original item become unavailable.

Inventory Details Tab

Use the data in the Inventory Details window to help you track attribute information entered on production orders. This helps you control the tracking of materials through manufacturing and into inventory. This section explains fields in the Item Details tab. Only those fields not previously described for other MSW windows are described.

Fig. 2.30
Inventory Details Window

Item Number	Site	Qty On Hand - Inv Mstr	Qty On Hand - Inv Detail	Location	Lot/Serial	Reference	Status	Expiry Date	Date Created
AFS13		10000	60.0	55.0	K/S1	10	OK01/2003		05/26/2003

Quantity On Hand - Inv Mstr. The current on-hand inventory balance for the item from the inventory master table.

Quantity On Hand - Inv Detail. The current on-hand inventory balance for the item from the inventory detail table.

Expire Date. The expiration date associated with this specific inventory quantity. The system calculates this date when an item is received into inventory.

Calendar Exception Tab

Use the fields in the Calendar Exception tab to review or change calendar exceptions. You set up the calendar in QAD EE Calendar Maintenance (36.2.5). When you do, you specify a reference, such as downtime, and the number of hours per day affected. This information displays in the Calendar Exception tab within MSW.

In the Calendar Maintenance tab within the workbenches, you can create a new calendar exception, save an exception, or validate an exception. When you click New, the system fills in zeros for each shift; see the following figure.

When you click Validate, the system verifies that the data in Calendar Exception is correct; it also makes the data available for use in the workbenches.

Fig. 2.31

Calendar Exception, New Exception

Production Order Maintenance Demand Details Inventory Details Calendar Exception Action Messages Item Master Item Planning											
Calendar Exception											
New Delete Validate											
Production Line: san											
		Shift1		Shift2		Shift3		Shift4			
Reference	Date	Capacity	Productivity	Capacity	Productivity	Capacity	Productivity	Capacity	Productivity	Planned Capacity	Weighted Productivity
	01/05/201	0.00	100.0%	0.00	100.0%	0.00	100.0%	0.00	100.0%	0.00	100.0%

You define shifts in Shift Maintenance (18.1.22) for the production line. For each production line, Calendar Exception displays the reference, date, the capacity (in decimals), and the percentage of productivity for each shift. It shows the planned capacity and weighted productivity for the production line, too.

Saving Your Changes

To save modified and new production orders to QAD EE, click Save.

You can make changes across items or sites in the workbench without saving first. You should save, though, before you run a new search when you want to save existing changes to the database before retrieving data from the new search.

Production Scheduling Workbench (PSW)

The following topics describe how to use the features of Production Scheduling Workbench (PSW).

***Introduction* 62**

Introduces the PSW, components, and features.

***Enabling PSW* 64**

Provides procedures to access the PSW in the .NET UI

***Synchronizing Resource Tables* 64**

Tells you how to synchronize QAD EE resource tables for use the workbenches.

***Setting Up Production Lines* 64**

Tells you how to enable PSW for a site.

***Setting Up Production Lines* 64**

Tells you how to mass set up production lines.

***PSW User Preferences* 64**

Describes user preferences for PSW, including field descriptions for all user preferences

***Processing PSW Schedules* 68**

Provides a general procedure to create and process a production schedule and describes processing results.

***Working with Sequence Grid Data* 69**

Describes various ways to manipulate dates, data, and other items within the PSW Sequence Grid.

***Dispatching and Printing* 75**

Provides instructions to dispatch and print PSW-built schedules.

Introduction

Use the Production Scheduling Workbench (PSW) to prioritize/sequence production orders within a day and, optionally, a shift. You can use the PSW to view and update production line schedules used with the QAD EE Advanced Repetitive module.

Note Operation-based scheduling and work center production scheduling are not available in the PSW in the current release.

Features

Using PSW, you can build production schedules with full knowledge and visibility of resources, production orders, items, the shop floor, and more. Besides just scheduling items, you can:

- Determine production order status and whether they are sequenced or nonsequenced.
- Determine production progress by displaying shop floor activity
- Define the sequence horizon and configure the display.
- Modify orders and order quantities.
- Create, delete, copy, and split production orders.
- Modify production order status or duration.
- Calculate order dates.
- Define defaults, shifts, and sequences.
- Sequence/unsequence production orders.
- Dispatch production to the shop floor by printing dispatch lists, picklists, production orders.

Drag and Drop

You can easily modify aspects of a production order by dragging and dropping production orders within the PSW Sequence Grid and from Production Order Maintenance to the Sequence Grid. When you drop an order onto another order, the order you drop acquires the properties of the receiving order, so, for example, if you drag and drop an unsequenced order onto a sequenced order, it becomes a sequenced order. Use the drag-and-drop method to:

- Change due dates by dragging and dropping a production order from one release date to another production order with a different release date.
- Change status by dragging and dropping a selected order. When you do, PSW updates the production order status to F if the status is P.
- Modify resource capacity by dragging and dropping from the source to the target destination after you select a single or multiple production orders.
- Sequence production orders in PSW by dragging and dropping single or multiple orders after a sequenced production order. Once you drop the orders, the system assigns the sequence number to the order(s) as greater than the prior sequenced numbers and assigns the appropriate shift number if shifts are being used.
- Unsequence an order by dragging a sequenced order and dropping it after an unsequenced order. The system changes the sequence to 0. When you do not have unsequenced orders, you can unsequence by changing the sequence number to zero.

PSW Workbench Elements

Figure 3.1 displays the PSW workbench. The text following the figure describes how each panel is used.

Fig. 3.1
PSW

Master Scheduling

Production Scheduling

Shortage Report

Production Scheduling

aps723

line1

09/22

Required: 20 Hours (300)

Remaining: -20 Hours (-500)

00:00

Required: 20 Hours (300)

Remaining: -20 Hours (-500)

ID

Shi

Seq

Run Seq 1

Run Seq 2

Run Crew

Item Num

Setup Time (Hrs)

Sta

Component Status

Quantity Ordered

Open Quantity

Re

723a

0

723a

0

R

No Component

300

300

09/22

1 00:00

Required: 0 Hours (0)

Remaining: 8 Hours (200)

Carry Over: 20 Hours (500)

01/06

Required: 0 Hours (0)

Remaining: 8 Hours (200)

1 00:00

Required: 0 Hours (0)

Remaining: 8 Hours (200)

01/10

Required: 0 Hours (0)

Remaining: 8 Hours (200)

Carry Over: 12 Hours (300)

1 00:00

Required: 0 Hours (0)

Remaining: 8 Hours (200)

01/11

Required: 0 Hours (0)

Remaining: 8 Hours (200)

Carry Over: 4 Hours (100)

Cum Remaining: 4 Hours (100)

1 00:00

Required: 0 Hours (0)

Remaining: 8 Hours (200)

line2

09/22

Required: 12.5 Hours (500)

Remaining: -12.5 Hours (-500)

01/06

Required: 0 Hours (0)

Remaining: 8 Hours (320)

Carry Over: 12.5 Hours (500)

1 00:00

Required: 0 Hours (0)

Remaining: 8 Hours (320)

01/07

Required: 0 Hours (0)

Remaining: 8 Hours (320)

Carry Over: 4.5 Hours (180)

Cum Remaining: 3.5 Hours (140)

01/08

Required: 0 Hours (0)

Remaining: 8 Hours (320)

Cum Remaining: 8 Hours (320)

Resource Panel

Based on your selection criteria, the Resource Panel displays records that match your search criteria. For detailed information, refer to “(2) Resource Panel” on page 4.

Sequence Grid

The Sequence Grid lets you concurrently view a list of both sequenced and non-sequenced production orders. In the Sequence Grid, you can view sequenced and non-sequenced orders that you move from Production Order browse. Production Order Browse lets you view all sequenced and unsequenced orders across the board.

The Sequence Grid displays item supply records—that is, production orders—with daily bucketed quantities of the production order supply records for the item. The quantities shown within the Sequence Grid are production order quantities.

PSW shows capacity in hours and units. The unit reflection is for required capacity; that is, that x units are needed per the schedule. There is also a unit reflection for remaining capacity; that is, you can produce x more units based on the current schedule entered for the release date. In the PSW, the unit that displays is based on an average. There are two types of values for hours that display: one pertains to remaining capacity, while the other pertains to required capacity.

You can add columns to the PSW Sequence Grid as well as add or modify column header labels, using QAD EE standard label maintenance programs.

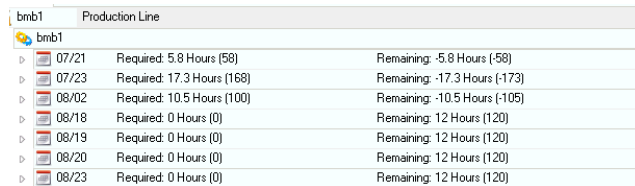
Supporting Data/Information Tabs

Similar to the MSW, additional data/information for production orders and items is provided in various supporting tabs that display at the bottom of the PSW. For information on updating data or field descriptions in these windows, refer to “Common Features” on page 8.

Sequence Horizon

The sequence horizon determines the number of sequencing daily buckets that show in the PSW. If the horizon is three days, for example, then you see today plus two more days in the PSW. Past due orders always display in the Sequence Grid even if they are not within the current sequencing horizon. For information on setting the sequence horizon, see “Defining PSW Sequencing Horizon” on page 65.

Fig. 3.2
Sequence Horizon



bmb1 Production Line		
07/21	Required: 5.8 Hours (58)	Remaining: -5.8 Hours (-58)
07/23	Required: 17.3 Hours (168)	Remaining: -17.3 Hours (-173)
08/02	Required: 10.5 Hours (100)	Remaining: -10.5 Hours (-105)
08/18	Required: 0 Hours (0)	Remaining: 12 Hours (120)
08/19	Required: 0 Hours (0)	Remaining: 12 Hours (120)
08/20	Required: 0 Hours (0)	Remaining: 12 Hours (120)
08/23	Required: 0 Hours (0)	Remaining: 12 Hours (120)

Enabling PSW

You must enable PSW by setting the Use Plan/Sched Workbenches field in Site Maintenance 1.1.13); see “Enabling the Workbenches” on page 24.

Accessing PSW

You access the PSW through QAD .NET UI. You can enter either of the following in .NET UI Applications field. to access the PSW:

- Master Scheduling Workbench, or part of this name
- Production Scheduling Workbench or part of this name

Synchronizing Resource Tables

You must synchronize QAD EE resource tables for use with the PSW before you use the workbench; see “Synchronize Resource Tables” on page 25.

Setting Up Production Lines

You can mass setup production lines and items for a production line in preparation to use PSW; see “Setting Up Production Lines” on page 26.

PSW User Preferences

The following topics discuss the following setup parameters for PSW:

- Defining PSW Sequencing Horizon
- Configuring Schedule
- Defining Defaults

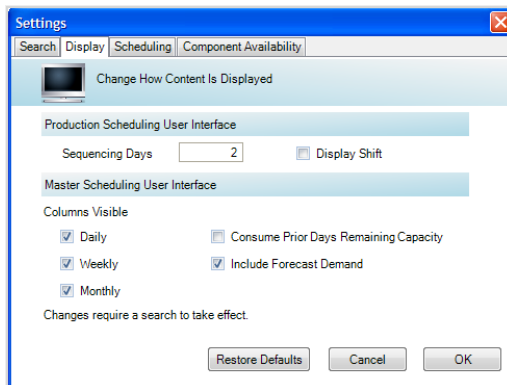
Defining PSW Sequencing Horizon

The PSW horizon setting is based on calendar days, not the shop calendar. Regardless of their status, past due production orders on the production schedule that have not been completed by the current date always display. Past due production orders do not have to be in status Released to show on the PSW.

For manageability, the PSW should contain a small data set so that you can easily view and manage production lines, release date buckets, and release date details. So, for example, if you set the horizon for one day, you can see all production lines and easily schedule from one to ten lines in a single view. You can also see the production schedule across several production lines.

You define the sequence horizon dynamically through the Options pull-down menu. You select Option, then Preferences, then the Display tab to set the sequence horizon.

Fig. 3.3
Settings Window, Display Tab



Sequencing Days. Enter the number of days for the sequence horizon. When working on a production schedule, the typical horizon is 24 hours to 5 days.

During production sequencing—that is, prioritization of production orders within the sequence horizon—you can view supply and demand, and any potential issues for sequence schedules, then drill down to determine the problem and possible resolutions.

Display Shift. Set this field to Yes to display shifts in the Sequence Grid. Shift buckets display:

- When orders exist for the item/shift/release date
- When capacity exists for a shift.

Note The shift still displays when its remaining capacity is zero or less than zero because when remaining capacity is zero or less than zero, production orders have been scheduled against that shift and therefore, display in the PSW. Shifts do not display when no work orders have been scheduled against the shift and the planned capacity for the shift is zero, indicating the shift is not in use.

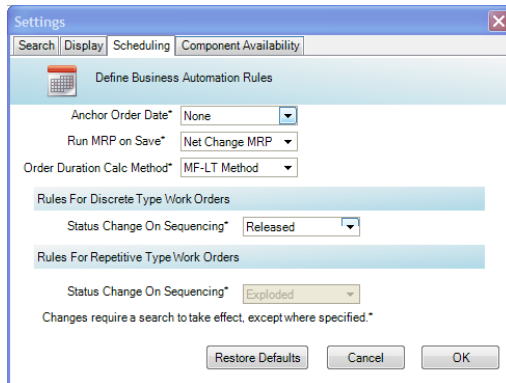
- For standard capacity
- For exception capacity

You set the shift start time in Shift Maintenance (18.1.22).

Configuring Schedule

Use the fields in the Scheduling tab of the Settings window to set options for PSW.

Fig. 3.4
Settings, Scheduling Tab



Anchor Order Date. Enter either None or Due Date to anchor the order date.

None: The system does not anchor dates.

Due Date. Choose Due Date when you want production order due dates to stay intact; for example, when you need to start a production order earlier than planned, but you want the due dates to remain. Anchoring a due date lets you lock in the production order due date so that it does not change during the production schedule process.

Example As the master scheduler, you provide the shop floor with a schedule that shows production orders due by Friday. You must determine upon which date the production orders run, but only the Master Scheduler can change the Friday due date; therefore, you anchor the Friday due date.

Status Change on Sequencing. Indicate the status to which you want to change the order status when sequencing orders. Setting this field for either repetitive or discrete orders managed on production lines helps you to specify order rules. Select from Firm, Exploded, Allocated, Released, and Closed statuses.

PSW Forward Consumption. Specify Yes to consume capacity for future release dates. For more information, see “PSW Forward Consumption”.

Yes: If a production order runs for more than one day, capacity beyond the release date is consumed.

Example A release date of today has a capacity of eight hours. Tomorrow’s release date has a capacity of eight hours. You place an order under today’s release date, and the order requires 12 hours to run. The PSW release date for today shows 0 remaining hours capacity but the capacity for tomorrow’s release date shows four hours.

No: If a production order runs for more than one day, capacity beyond the release date is not consumed.

PSW Forward Consumption

You use the MSW to create a master schedule for the medium-to-long term range—week, month, or longer—balancing demand, supply, and capacity, typically at the departmental level. You use

the PSW for the short-term range—one day to few days—sequencing and prioritizing production orders at the production line level. As such, it is critical at the production scheduling level to forward consume capacity when production orders run longer than a day and therefore, require the consumption of future capacity.

With the PSW forward capacity logic, you can see two new columns within the PSW Sequence Grid:

- Carry Over: The sum of load remaining from previous days.
- Cum Remaining: Any excess capacity for that day.

Schedulers can take advantage of the data that displays in these columns. Cum Remaining, which only shows when it is positive, is an opportunity to add load to a shift or release date, while Carry Over is indicative of overloading. So, for jobs that run for more than a day, the apparent overloading is managed by balancing over those days.

Example Available capacity for today's release date is 8 hours. The same amount of capacity of 8 hours is available for tomorrow's release date. You place Production Order A under today's release date and the order requires 12 hours to run. The PSW release date for today shows 0 (zero) remaining capacity and four hours of remaining capacity for tomorrow's release date. When you have 12 hours of load on a day that has 8 hours of total capacity, then, you have -4 hours that show in the Cum Remaining for that day. Those -4 hours plus a carry over—that is, the excess load from the preceding day—display for tomorrow's carry over. When only 4 hours remain on tomorrow, the scheduler realizes that another job that takes only 7 hours and would normally complete, cannot be done tomorrow since there are 4 hours remaining after doing the carry over load. The other balance of 3 hours spills into the day after tomorrow. Figure 1 shows the two new columns in the PSW Sequence Grid.

Fig. 1
PSW Forward Capacity-Related Columns

Item	Required	Remaining	Carry Over	Cum Remaining
ASSY-01				
02/02	Required: 1.8 Hours (18)	Remaining: -1.8 Hours (-18)		
02/03	Required: 6.1 Hours (61)	Remaining: -6.1 Hours (-61)	Carry Over: 1.8 Hours (18)	
02/04	Required: 5.5 Hours (55)	Remaining: 2.5 Hours (25)	Carry Over: 7.9 Hours (79)	
02/05	Required: 9.9 Hours (99)	Remaining: -1.9 Hours (-19)	Carry Over: 5.4 Hours (54)	
02/06	Required: 4.5 Hours (45)	Remaining: 3.5 Hours (35)	Carry Over: 7.3 Hours (73)	
02/07	Required: 16.5 Hours (165)	Remaining: -8.5 Hours (-85)	Carry Over: 3.8 Hours (38)	
02/08	Required: 7.7 Hours (77)	Remaining: 0.3 Hours (3)	Carry Over: 12.3 Hours (123)	
Cast-G				
02/04	Required: 0 Hours (0)	Remaining: 9 Hours (180)		Cum Remaining: 9 Hours (1)
02/05	Required: 0 Hours (0)	Remaining: 9 Hours (180)		Cum Remaining: 9 Hours (1)
02/06	Required: 30.7 Hours (554)	Remaining: -21.7 Hours (-434)		
02/07	Required: 0 Hours (0)	Remaining: 9 Hours (180)	Carry Over: 21.7 Hours (434)	
02/08	Required: 0 Hours (0)	Remaining: 9 Hours (180)	Carry Over: 12.7 Hours (254)	
Dept				
Dept-M1				

Defining Defaults

You can define defaults for:

- Shift scheduling behavior
- Sequencing behavior

For shifts, you can enter a blank shift to indicate that production orders do not have a shift. This is useful, for example, when you have planned orders that are not firm and you do not want the planned orders defaulting to shift 1, which may cause unauthorized items to be produced on the shop floor.

You can remove the display of shifts through the Options pull-down menu.

Processing PSW Schedules

The following topics describe a generic procedure to produce a production schedule. Specific tasks follow this section.

Procedure

There are many different ways to access resource and scheduling data within PSW, and many different functions that you can perform using the data when creating or modifying a production schedule. The following steps let you perform a complete production order scheduling business cycle from the PSW:

- 1 From the Search Grid, select Scheduler ID in the first field, equals to in the operator search field, then your user ID in the third search field.

The system displays records of items related to the Scheduler ID. The system retrieves all transactional, demand, and supply records for items with dates that also match the History and Future Horizon values that you set in the Option Window.

- 2 If you have a view, you can optionally apply your View.

- 3 Click on the resource in the Resource Panel.

Determine which production orders should be released and sequenced over the next few hours or days.

The production orders may not be assigned to the resource in view; they may be assigned to a default resource. Uses Production Order Browse to find items and production orders that you can move to the selected resource.

- 4 Schedule items.

Focus on finalizing the details of the production schedule for your sequencing horizon. In addition to changing resources, dates, or status, you can:

- Sequence production orders.
- Schedule using shifts.
- Drag and drop scheduled production orders.
- Retrieve the production order in Production Order Maintenance, then:
 - Modify order setup.
 - Align order dates.
 - Create a new production order.
 - Delete, copy, or split orders.

- 5 Monitor a production order by displaying:

- Order supply summary in the Production Order Maintenance summary list
- Order details or attributes
- Production rates
- Comments
- Order dates, times, shop floor activities
- Routing data

- Inventory details
- 6 Save your changes.
 - 7 Optionally, export data to a spreadsheet.
 - 8 Report production.

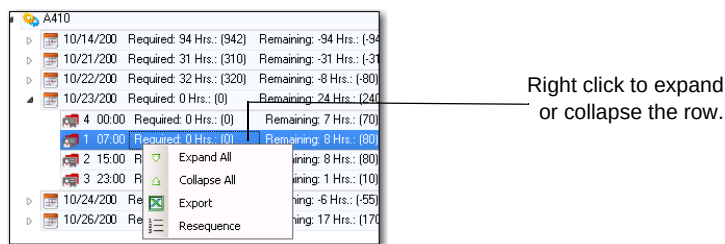
Working with Sequence Grid Data

The following topics explain the data within the Sequence Grid and describes ways that you can interact with the data.

Expanding/Collapsing Data

You can expand or collapse data within the Sequence Grid. To do this, click on the release date header row.

Fig. 3.5
Expand Options



Viewing Capacity

You can view the required capacity and remaining capacity of a production line by release date.

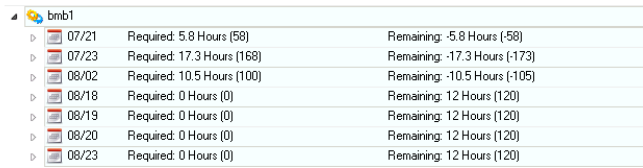
Example For release date 1/1/2011, there are two shifts: 1 and 2. The orders currently placed under the release date consume two hours under shift 1 and three hours under shift 2. The capacity row for the release date is a summation of what is scheduled under the various shifts for the release date in question.

Unlike the MSW, the PSW does not display a Capacity Grid; instead, you view required and remaining capacity at the production line level. This is because you use the Sequencing Grid to manage production orders by release date, not due date. In some cases, the order release/due date are the same, and in other cases, they differ.

When you select a resource from the Resource Navigator, the Sequence Grid displays the production line and a list of release dates, based on the setting of your sequence horizon. For each release date header record, the system displays required and remaining capacity information.

When you expand release date details, the Sequence Grid displays the capacity/required capacity of each shift header record.

Fig. 3.6
Sequence Grid



	Required	Remaining
07/21	Required: 5.8 Hours (58)	Remaining: -5.8 Hours (-58)
07/23	Required: 17.3 Hours (168)	Remaining: -17.3 Hours (-173)
08/02	Required: 10.5 Hours (100)	Remaining: -10.5 Hours (-105)
08/18	Required: 0 Hours (0)	Remaining: 12 Hours (120)
08/19	Required: 0 Hours (0)	Remaining: 12 Hours (120)
08/20	Required: 0 Hours (0)	Remaining: 12 Hours (120)
08/23	Required: 0 Hours (0)	Remaining: 12 Hours (120)

The following topics explain fields within the PSW.

ID. The valid system production order identifier.

Shift. The production line shift as defined in Production Line Shift Maintenance.

Seq. The production order sequence number.

Run Seq 1, 2. You use run sequence fields as a reference to control the sequence in which firmed orders are sequenced on a production line schedule. When multiple items are produced on a single production line, efficiency can be improved by producing the items in a certain order. Run sequence fields display the attributes of an item; for example, you can have a run sequence of small, medium, or large or white, red, black assigned to your various items.

Item Number/Description. The valid item number and description.

Status. The production order status code. Production order status codes correspond to stages in a production order's life cycle:

- Planned
- Firm planned
- Batch
- Exploded
- Allocated
- Released
- Closed

The status of a production order determines how much control you have over its bill, routing, inventory allocations, inventory transactions, and labor.

Quantity Ordered. The planned quantity of the production order. Compare this with the closed quantity, which is the good quantity reported for the order.

Release Date. The date this production order is scheduled to be released to production. The date you enter here initially changes to the actual release date when you release and print the production order. Release dates also determine the date components are required. Normally components are picked when an order is released.

When you move an order in the PSW from one release date to another, the system changes the release date on the order. The change in release date is reflected immediately on the PSW. The order does not have to be in any specific status for this to happen. Only non-planned orders show on the PSW.

The system calculates either release or due date, creating, in effect, forward or backward order scheduling.

Due Date. The due date is the date this order is due to be completed. This is the date you plan to have product available for shipment to the customer or issue to another manufacturing order. All MRP plans are based on this due date.

Resource. The production line as listed in the Resource Panel.

Site. The site to which the resource belongs.

Modifying Production Order Quantities

You can manually adjust the production order quantity in PSW. When you change the quantity of a production order, PSW applies the quantity change to the entire order, not a specific operation.

- 1 Select a production order on the Sequence Grid.
The system highlights the selected production order.
- 2 Modify the value in the Quantity Ordered column by double-clicking in the cell.
PSW updates all calculations. Color indicators may change in the MSW.

Note You can also change the quantity using Production Order Maintenance within PSW.

Creating/Deleting Production Orders

Procedures to create and delete production orders are in Chapter 2, “Master Scheduling Workbench (MSW),” on page 17.

Splitting Production Orders

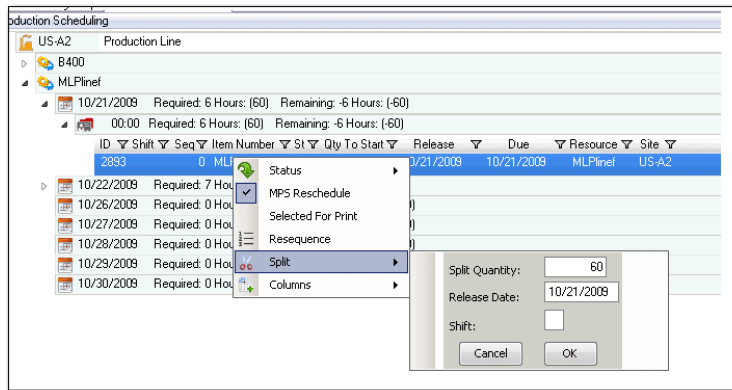
PSW lets you split a production order into smaller production orders while tracking costs to a cumulative order.

To split a new discrete production order into several production orders:

- 1 Select the production order to split.
- 2 Right-click to display the pull-down menu.
- 3 Select Split.
A window displays additional options; see Figure 3.7.
- 4 Enter the split quantity, release date, and if necessary, the shift.
- 5 Press OK.

The system creates a new production order per the data entered in the split pop-up window and reduces the open quantity.

Fig. 3.7
Splitting Orders



Scheduling a Production Order by Dragging and Dropping

For a selected production order, you can drag and drop from Production Order Browse to the Sequence Grid.

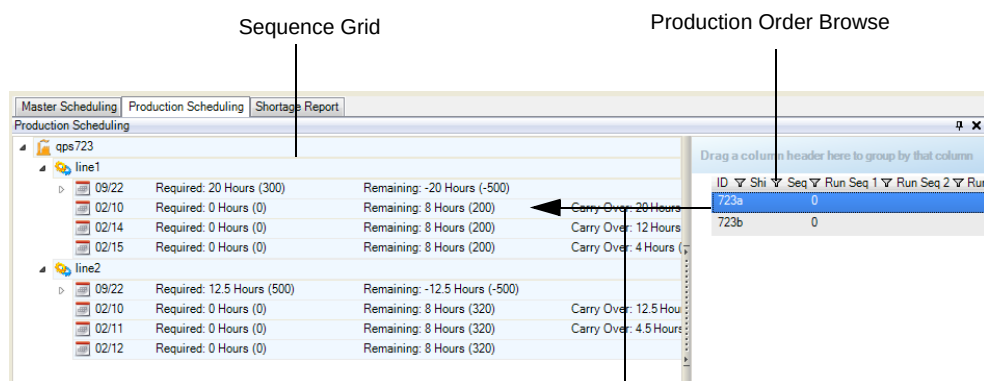
- 1 Select the production order in Production Order Browse.
- 2 Drag the order to the PSW Sequence Grid.

A drop indicator displays, indicating the location at which you can drop the production order.

Note The indicator does not display if the production line target is not defined as a primary or alternate production line.

PSW updates and recalculates data.

Fig. 3.8
Drag and Drop from Production Order Browse



Drag the production order from Production Order Browse to the Sequence Grid.

Modify Production Order Status

You can modify the status of one or many production orders easily within the PSW Sequence Grid.

To do this, use the following procedure:

1 Drill down in the Sequence Grid to view orders.

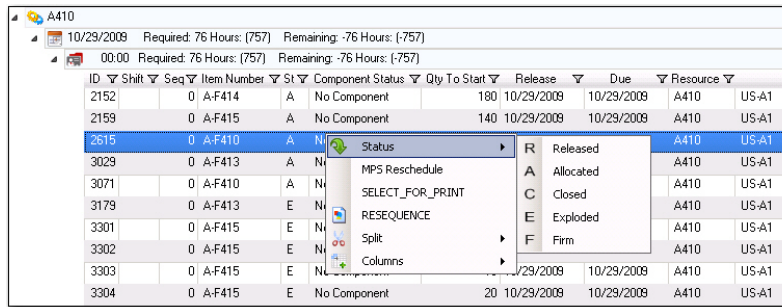
2 Right click, then select Status.

Note You can hold down the right mouse button to select more than one production order to mass change the status.

3 Select the status for the change:

- A(llocated)
- C(losed)
- E(xploded)
- F(irm)
- R(eleased)

Fig. 3.9
Status Change



Modifying Production Order Duration

Occasionally, you may need to manually increase or decrease the production order duration. For example, you may want to expedite a production order and thereby collapse the average duration of the order. Or you may need to expand the duration, starting earlier to complete by the due date.

Production order duration is initially derived from the item manufacturing lead-time or calculated per the required capacity of the production order, factoring resource capacity. Other consideration may influence the amount of time to produce an item, considering:

- Average capacity
- Order quantity
- Operation lead time
- Process time

Production Order Duration can be greater, less than, or equal to the calculated routing duration. To modify the production order duration, use one of the following options:

- Manually update the Duration field in the Date/Time sub-tab in Production Order Maintenance.
- Modify the production order release date only when the due date is anchored; modifying the release dates increases or decreases the duration value.

- Set the Order Duration Calc Method in the Scheduling tab of Preferences, under Option in the top tool bar. This sets the method to calculate the order duration when the order is firmed, created, and modified.

Note You can set the Order Duration Calc Method in the Scheduling tab of Preferences, under Options in the top tool bar. This sets the method to calculate the order duration when the order is firmed, created, and modified (future). When you select a different calculation method from user preferences, the Order Duration Calc Method takes precedence over the standard duration calculation; see “Select the Method for Duration Calculations” on page 33.

Defining Shifts/Sequences

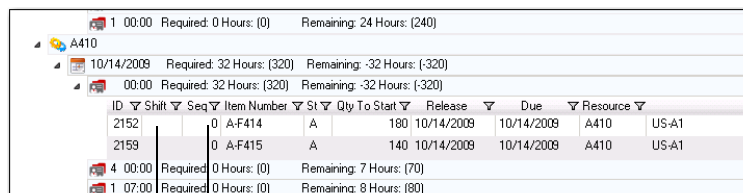
Sequencing determines the order in which manufacturing processes production orders. Within QAD EE, sequenced orders have a unique sequence number that identifies the order as sequenced. Sequencing of production orders is by release date and optionally, shift when shifts are used. Sequence IDs are unique to each shift. Within PSW, the order in which shifts display is based on the shift start time defined in Shift Maintenance (18.22.1.22).

Production scheduling determines the order start (release) date and sequence, and sequencing is by release date in the PSW. The system considers the release date and sequence of the production order to determine which is consumed first.

Note When working with Component Availability Check (CAC), the system prioritizes by order status, release date, then sequence for component consumption. When you have multiple shifts per day and the sequence number repeats within that day, CAC cannot determine the shift. For more information on CAC, refer to Chapter 4, “Component Availability Check (CAC),” on page 79.

To change an order from unsequenced to sequenced or to change an existing sequence number, select a single production order and enter a sequence ID in the Seq field. You modify the shift by entering a shift number in the Shift field.

Fig. 3.10.
Sequence and Shift Field



ID	Shift	Seq	Item Number	St	Qty To Start	Release	Due	Resource
2152	0	A-F414	A	180	10/14/2009	10/14/2009	A410	US-A1
2159	0	A-F415	A	140	10/14/2009	10/14/2009	A410	US-A1

Enter a sequence number or shift.

Once you update the sequence, the Sequence Grid displays the new position of the production order per the specified sequence. If the sequence number you enter is assigned to an existing order, PSW resequences the existing sequenced order number by increasing the number as well as all subsequent orders for the release date.

Dragging and Dropping for Sequence/Shift Changes

You can also select one or more production orders to sequence and drag and drop from Production Order Browse to the Sequence Grid or within the Sequence Grid. Once you drop the orders, the system assigns the sequence number to the orders and assigns as greater than the prior sequenced numbers. The system also assigns shift numbers.

If you change production order release dates, PSW sets the sequence and shift to 0 (zero). You cannot drop an order onto a production line that does not have a release date.

Unsequencing Production Orders

Occasionally, you may need to unsequence a production order, removing the sequence ID and replacing with an unsequenced status, that is, the sequence ID is 0 (zero).

You can do this by:

- Entering a 0 (zero) in the Seq field of the Sequence Grid
- Entering a 0 (zero) in the Seq field within the production order in Production Order Maintenance within PSW.
- Dragging a sequenced order and dropping it after an unsequenced order. The system changes the sequence to 0.

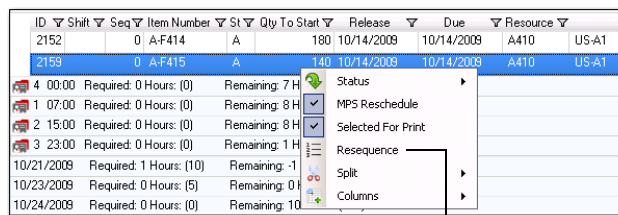
Note Dragging/dropping after an unsequenced order only works when the order you are dragging is the only sequenced order or you drop that order between two unsequenced orders.

Resequencing Production Orders

Resequencing should happen automatically whenever release date, shift, or production line change on an order; however, occasionally, resequencing does not occur automatically. When this occurs, use the resequencing option in the right-click menu. You can quickly resequence selected orders by right-clicking on a line, then selecting the Resequence option.

When you delete a production order, the system resequences the orders.

Fig. 3.11
Resequence Option



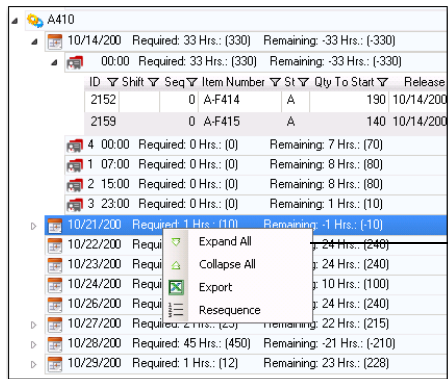
Select Resequence after you select the lines.

Dispatching and Printing

You can publish production schedule data to the shop floor using a dispatch list. To do this, you export PSW data to a Microsoft Office Excel spreadsheet.

While in the Sequence Grid, right-click on the release date row. A window displays options to expand, collapse, export, and resequence. Select Export. When you do, the system opens Excel and creates a temporary spreadsheet file. You should rename the file from Microsoft Office Excel.

Fig. 3.12
Export Window



ID	Shift	Seq	Item Number	St	Qty	To Start	Release
2152	0	A-F414	A		190	10/14/200	
2159	0	A-F415	A		140	10/14/200	
4	00:00						
1	07:00						
2	15:00						
3	23:00						
10/21/200							
10/22/200							
10/23/200							
10/24/200							
10/26/200							
10/27/200							
10/28/200							
10/29/200							

Right click to
display this
window.

QAD EE Programs to Use When Dispatching and Printing

You can use two QAD EE browse collections to help you release production to the shop floor:

- Release Production Orders by Production Line
- Release Production Orders by Work Center

You also use the QAD EE Print Orders Selected for Print function when dispatching to the shop floor.

Production Orders by Production Line

Production schedulers can use Release Production Orders by Production Line to quickly determine if the production schedule is viable for the day, week, month, or any specified time period. Release Production Orders by Production Line provides quick answers for production schedulers when they need to know the following:

- Before releasing a work order to the floor, are all components available?
- For production orders scheduled over the next one+ days, are there component shortages?

Release Production Orders by Work Center

Production schedulers can use Release Production Orders by Work Center to quickly determine component availability for discrete work orders for a particular work center. Checking components by work center lets production schedulers know if the production schedule is viable for the week. Release Production Orders by Work Center provides quick answers for production schedulers when they need to know the following:

- Before releasing a work order to the floor, are all components available?
- For production orders scheduled over the next one+ days, are there component shortages?

Select Orders to Release and Print

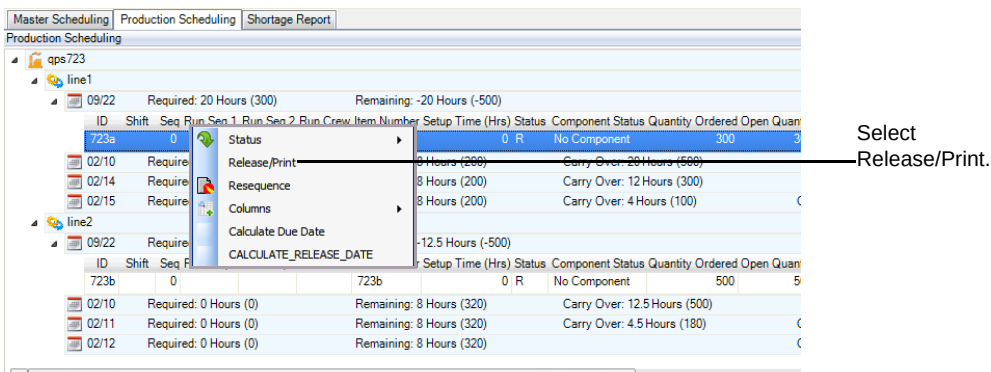
You use the PSW to select orders to release/print and then use the QAD EE Print Selected Orders for Print function to print the orders.

- 1 In the PSW Sequence Grid, select the production orders to print.
- 2 Right-click, then select Release/Print.
The system changes the order status to R(elease) and release/print is selected on the production order.
- 3 Save your changes.
- 4 In the .NET Menu Search Panel, type `Print Orders Selected for Print`; then, open the Print Orders Selected For Print program.
- 5 In Print Orders Selected For Print, select the production line that has the orders you want to print, then set the output to page.

The system prints the orders, picklist, routing, and so on.

Note The Print Orders Select For Print program was specifically designed to simplify the print process, letting you print orders that you selected for print from the workbenches.

Fig. 3.13Y
Print Function



Component Availability Check (CAC)

This chapter presents an overview of the features within the planning and scheduling workbenches that help you check component availability. Specific topics include:

Introduction **80**

Introduces the CAC elements and features.

CAC User Preferences **81**

Describes user preferences for CAC, including field descriptions for all user preferences.

Using CAC to Schedule Production **82**

Prior to releasing production schedules or orders to the shop floor, you can verify which orders have and do not have the necessary materials before releasing them to the shop floor. This section describes how the integrated workbench component checking capabilities can help you determine this.

Check Components for Requirements **87**

Presents data that lets you use the workbenches to check components for requirements.

Supporting Data **87**

Describes supporting data that helps you find the cause of a shortage and find a solution.

Introduction

MSW helps you create a balanced production plan, typically at the departmental level, balancing demand, supply, and capacity. PSW helps you create a production schedule that optimizes use of resources on the shop floor. Before you release a production plan or schedule, you want to ensure that you have enough materials to support the plan/schedule. You can use the component availability check (CAC) capabilities built into the MSW/PSW to do this.

The integrated workbench component check capabilities serve two distinct purposes:

- Schedulers and planners use CAC features to ensure that the production orders they plan/schedule have enough materials. They check component availability across a range of production orders and order statuses, then use CAC supporting data to analyze shortages and potential shortages to determine action that needs to be taken, if any.
- Buyers, materials planners, and materials expeditors use the QAD EE Monitor Material Shortages browse collection to monitor shortages, even at specific locations. They need features to help them trace component shortages across multiple levels that include the parent and all child components of the parent and the ability to notify others of existing or potential shortages so that they can determine a plan of action to address the shortages; for example, by purchasing or building more components.

Both types of users can use CAC supporting data to analyze the details behind a production order component availability status. Within the MSW/PSW, panels are included that provide supporting data for:

- **Component list**
When you select the Component sub-tab within the Production Order Maintenance tab, component information is divided into two parts: the left side displays the BOM list of a production order, including component status, picking and issuing status, and more. See “Component List” on page 88.
- **Supply/demand summary**
To get a summary of how the system got to the component status, you can look at the Supply/Demand Summary sub-tab to view all demand and supply related to the component within a site or domain. See “Supply/Demand Summary” on page 88.
- **Supply/demand details**
The Supply/Demand Detail sub-tab provides MRP details of the selected component. You can drill down into the details, viewing projected QOH based on supply and demand by date. See “Supply/Demand Details” on page 90.
- **Inventory details by site**
Use data in the Inventory Detail sub-tab to drill into component inventory detail records for a particular site/location combination to determine options when dealing with component shortages. See “Inventory Details by Site” on page 90.

This chapter is divided into the following sections.

- 1 The first section covers features and procedures for schedulers and planners.
- 2 The second section covers features and procedures for buyers, materials planners, and expeditors.
- 3 The last section covers supporting data that either group of users can access.

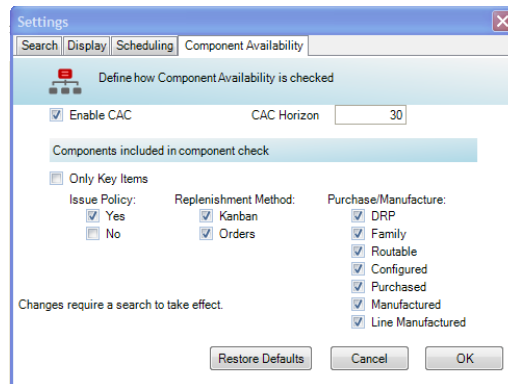
CAC User Preferences

The following topics discuss options available when configuring CAC within the MSW/PSW.

You select Option, then Preferences, then the Component Availability tab to set CAC preferences. Set the horizon, then select the components the system includes in the component check:

Important Changes to preferences require that you run Search again.

Fig. 4.1
Settings Window, Component Availability Tab



Enable. Indicates whether to enable CAC.

No: CAC calculations do not occur during data search retrieval and save. Shortage Report and Production Order Maintenance Component Supply/Demand Summary and Detail windows are blank.

Yes: CAC is enabled and calculations occur during data retrieval and save. Component status information displays in the Production Order Maintenance tab, the order component list panel, the Component Supply/Demand Summary and Details Panels, and the Shortage Report.

CAC Horizon. Enter the number of days into the future within which the CAC calculations consider MRP detail data. This helps improve the performance of CAC calculations by excluding MRP detail data after a certain point in the future. Typically, CAC statuses are relevant only for production orders to be released in the near-term future; therefore, you should set this to the horizon within which you expect to be releasing production orders.

Note If the number is too small, the system may not be able to compute some production order component availability statuses. For example, this can occur for production orders with a due date that is after the end of the horizon.

Only Key Items. Indicate whether to include only key items when calculating CAC. Key items are identified using Item Master Maintenance (1.4.1), Item Inventory Data Maintenance (1.4.5) or Item-Site Inventory Data Maintenance(1.4.6).

No: Both key items and non-key items are included in the CAC calculation.

Yes: Only key items are included in the CAC calculation.

Issue Policy. Indicate whether to include items according to their Issue Policy. Issue Policy is set using Item Master Maintenance (1.4.1), Item Planning Data Maintenance (1.4.7) or Item-Site Planning Data Maintenance(1.4.17).

Issue Policy Yes:

Not checked: Items with Issue Policy set to Yes are not included in the CAC calculation.

Checked: Items with Issue Policy set to Yes are included in the CAC calculation.

Issue Policy No:

Not checked: Items with Issue Policy set to No are not included in the CAC calculation.

Checked: Items with Issue Policy set to No are included in the CAC calculation.

Replenishment Method. Indicate whether to include items according to their replenishment method. You set the replenishment method using Item Master Maintenance (1.4.1), Item Planning Maintenance (1.4.7) or Item-Site Planning Maintenance (1.4.17).

Replenishment Method Kanban:

Not checked: Items whose Replenishment Method is set to Kanban are not included in the CAC calculation.

Checked: Items whose Replenishment Method is set to Kanban are included in the CAC calculation.

Replenishment Method Orders:

Not checked: Items whose Replenishment Method is set to Orders are not included in the CAC calculation.

Checked: Items whose Replenishment Method is set to Orders are included in the CAC calculation.

Purchase/Manufacture. Indicate whether to include items according to their Purchase/Manufacture code. Purchase/Manufacture code is set using Item Master Maintenance (1.4.1), Item Planning Maintenance (1.4.7), or Item-Site Planning Maintenance (1.4.17). Items for each possible Purchase/Manufacture code type can be selected or not selected by checking or unchecking its check box:

Not checked: Items with the indicated Purchase/Manufacture code are not included in the CAC calculation.

Checked: Items with the indicated Purchase/Manufacture code are included in the CAC calculation.

Using CAC to Schedule Production

CAC provides visibility during master scheduling, production scheduling, and the releasing of production orders. For each production order, you can view the component status of the order. During production sequencing, you can determine if there are material constraints in the production schedule, and drill down to determine the problem and possible resolutions.

Prior to releasing production schedules or orders to the shop floor, you can verify which orders have the necessary materials before releasing to the shop floor. You have full details of the materials issued and specific shortages by item.

Use CAC features within PSW to:

- Release production orders to the shop floor that have the necessary components available.
- Calculate and display the severity of a material shortage at the production order and component levels.

- Help you:
 - Release production orders to the shop floor that have the necessary components available.
 - Calculate and display the severity of a material shortage at the production order and component levels.
 - Determine when the next material receipt will be available in the case of material shortages.
- Drill down into the material shortage details for a component to analyze the cause and possible solutions.
- Simulate a schedule change and recalculate production order material status for all production orders sharing common components when a production order is modified.
- Output production orders related to particular release dates to a spreadsheet that can include the component status when you indicated to display the status column in the Sequence Grid.

The following subsections provide procedures to check components during production scheduling, followed by information to configure CAC.

Component Check Example

As a Production Planner, you want to ensure that all production orders scheduled for the upcoming week have enough components available. You run the MSW/PSW to look at production orders that have a release date during the next seven days.

The Shortage Report tab in the MSW/PSW displays all production order component records with a status of Projected Shortage or Shortage. You look at the Supply/Demand Summary data under the Components tab in Production Order Maintenance to see the cumulative supply and demand information for that production order component detail record. To get more information, you look at data under the Supply/Demand Details tab to view the MRP details the system used to calculate the production order component status.

You have several options to resolve the shortage. You can reschedule either supply or demand. For example, to reschedule supply you can reschedule a purchase order receipt if the component is purchased. Or, if the component is manufactured, you can reschedule a production order. To reschedule demand, you could reschedule a sales order or forecast demand.

Once you make the change, refresh the data to determine if the shortage no longer exists for the component.

Working with CAC Data

The system retrieves production order component detail records when CAC is enabled. The system calculates CAC statuses when it returns data from your initial search for records and displays the production order component status of each production order retrieved. Results are shown in the Component Status column within the Sequence Grid; see Figure 4.2. They also display in the same-named column in the Production Order Maintenance Summary List and in the Components sub-tab in the workbenches; see Figure 2.21 on page 46.

When a production order has a component or components tied to it with a Shortage or Projected Shortage status, then the Component Status field tied to the production order is colored red.

Changing Production Orders

To have the component availability status recalculated when production order data is changed, you must save your changes. If you change the quantity of an order or change the release date, this can affect CAC data.

Component Check Calculations

The system calculates component availability for a production order component record by calculating projected quantity on hand (PQOH) using MRP supply and demand detail information.

The system factors these key considerations when computing the time-phased consumption and supply of material:

- For component demand records:
 - Release dates: oldest demand records processed first
 - Shift and sequence
 - Orders status: Authorized, Firmed, then Planned
 - R and A orders have priority over F and P orders, regardless of consumption date.
- For component supply records:
 - Due dates
 - Order status: Authorized, Firmed then Planned
 - Expiration dates

Displayed Calculation Results

The calculation results display in the Component Status column within the PSW Sequence Grid. They also display in the summary list of the Production Order Maintenance tab and in its Components sub-tab.

Fig. 4.2
Sequence Grid, Component Status Column

ID	Shift	Seq	Item Number	St	Component Status	Qty To Start	Release	Due	Resource
2152	0	A-F414	A	No Component	180	10/29/2009	10/29/2009	A410	US-A1
2159	0	A-F415	A	No Component	140	10/29/2009	10/29/2009	A410	US-A1
2615	0	A-F410	A	No Component	12	10/29/2009	10/29/2009	A410	US-A1
3029	0	A-F413	A	No Component	10	10/29/2009	10/29/2009	A410	US-A1
3071	0	A-F410	A	No Component	300	10/29/2009	10/29/2009	A410	US-A1
3179	0	A-F413	E	No Component	10	10/29/2009	10/29/2009	A410	US-A1
3301	0	A-F415	E	No Component	5	10/29/2009	10/29/2009	A410	US-A1
3302	0	A-F415	E	No Component	10	10/29/2009	10/29/2009	A410	US-A1
3303	0	A-F415	E	No Component	15	10/29/2009	10/29/2009	A410	US-A1
3304	0	A-F415	E	No Component	20	10/29/2009	10/29/2009	A410	US-A1
3305	0	A-F415	E	No Component	25	10/29/2009	10/29/2009	A410	US-A1
3306	0	A-F415	E	No Component	30	10/29/2009	10/29/2009	A410	US-A1

System-calculated shortage severity displays here.

The Component Status column displays a textual description of the status. The following lists the possible component status in order of severity.

No components. The production order does not have any components tied to it.

Issued Complete: The component open quantity for the production order is 0 (zero). This applies only to production orders with a status of R.

Available: There is enough QOH to cover production order component requirements.

Authorized Receipts: There are unconfirmed Advanced Ship Notices (ASNs) that cover the production order component requirements.

Scheduled Receipts: There are scheduled receipts that cover the production order component requirements.

Planned Receipts: There are planned receipts that cover the production order component requirements.

Projected Shortage: Not enough QOH and unconfirmed shipper receipts, scheduled receipts, and planned receipts to cover the production order component requirements. This only applies to production orders with status of P, F, B, or E.

Shortage: Not enough QOH to cover the production order component requirements. This only applies to production orders with status of A or R.

Production Order Status

When calculating component availability, the system considers the status of a production order. Production orders can have a status of:

- (P)lanned
- (F)irm
- (B)atch
- (E)xploded
- (A)llocated
- (R)eleased

The system groups the production order statuses into three status categories when calculating component availability:

- Planned: Planned production orders are in this category.
- Firm: Firm, Batch, and Exploded production orders are in the Firm category.
- Authorized: Allocated and Released production orders are in this category.

The following depicts where the system applies demand/supply records to the appropriate status category.

Fig. 4.3
Supply/Demand and Status Categories

Due Date		Status Category		
		Authorized		
		Firm		
		Planned		
1st	2nd	CAC prioritization of Demand Records		
Release Date		Status Category		
		Authorized	Shift/Sequence	WO IDs
		Firm	Shift/Sequence	WO IDs
		Planned		WO IDs
1st	2nd	3rd	4th	

Supply/Demand		Order Type	Applied To Status Categories		
			Authorized	Firm	Planned
Both		Production Order (released)	X	X	X
Both		Production Order (allocated)	X	X	X
Supply		ASN Receipt	X	X	X
Supply		DRP (intransit)	X	X	X
Supply		Expiring Inventory	X	X	X
Both		Production Order (firm)		X	X
Demand		Sales Order		X	X
Supply		Purchase Order		X	X
Supply		Supplier Schedule (firm)		X	X
Demand (site)		DRP Intersite Request (follows same logic as supply work orders)			
Supply (site)		DRP Intersite Demand (shipped)	X		
Supply (site)		DRP Intersite Demand (scheduled) "follows same logic as work orders"			
Supply		Supplier Schedule (plan)			X
Demand		Forecasts			X
Both		Production Order (planned)			X
Supply		DRP (planned)			X

The steps the system follows for sequenced production orders to calculate their POH and CAC status are as follows:

- 1 Determine the status category for a production order.
- 2 Within a production order status category, process by due date, then shift.
- 3 If no shift start time is defined, then shift processing is sequential (1.2.3.4...and so on). Shift 0 is processed last for each status category.
- 4 Within a production order status category, process by sequence. Sequence 0 is processed last.
- 5 If no sequence number is defined, process by production order ID.

Shortage Report

As part of the CAC features integrated into the workbenches, you can access the Short Report tab within the workbenches. Production planners, material expeditors, or schedulers can generate a list of components with shortages that impact the scheduler's production schedules for the production lines or work centers. In the report, these users can expand an item to see details regarding the shortage, such as the first date the shortage occurs, which production line or work center is impacted, and the most recent supplier/PO found in the system for the component.

You click on the Shortage Report tab at the top of the workbench to display a report that provides the following data:

- Component item number, description, and CAC status
- Quantity short and gross requirements
- Next scheduled receipt and receipt ID
- Buyer/planner

- Pur/Mfg code and parent item
- Production order ID, status, and operation
- Production line, work center, and site

Check Components for Requirements

Use the following topics to help you check components for production order requirements. You can check the Component Status column in the PSW Sequence Grid. Planned Receipts can display in the Component Status column. When it does, there is sufficient inventory projected to be available for the production order component. The data in the Component Status column includes nettable on-hand inventory, unconfirmed shipper receipts, scheduled receipts, and planned receipts.

Fig. 4.4
Planned Receipts

Supply		P	On-Hand	Authorized Receipts	Firm Receipts	Planned Receipts
			150	0	60	1603

Demand		Demand	Gross Reqs	Projected On Hand		
Authorize		1242	-1092	-1092	-1032	571
Firmed		138	-1230	-1230	-1170	433
Planned		263	-1603	-1603	-1543	60

You can rectify shortages by determining if the depending assembly production order for the component can be completed earlier, or if a purchase order receipt can be moved up. Additionally, you could see if the quantity of an outstanding discrete purchase order or supplier schedule can be increased.

Exporting Data

You can export the data that displays in the Shortage Report and the PSW to a Microsoft Office Excel spreadsheet.

From within the Shortage Report, right-click on any field within the report, then select Export Report. When you export, the system retains the structure/formatting of the source data.

Supporting Data

When you see that you have a potential shortage or a shortage for a production order, you can drill down into the details behind the component status using the supporting data at the bottom of the PSW. Specifically, you can drill down to Production Order Maintenance, then select the Components tab to see the following data:

- List of components related to the production order in focus within the Sequence Grid
- Supply/demand summary
- Supply/demand details
- Inventory details

You can also run a Shortage Report by selecting that tab within the workbenches.

The following topics discuss data found under the Production Order Maintenance Components tab.

Component List

When you select the Component sub-tab within the Production Order Maintenance tab in the workbenches, component information is divided into two parts: the left side displays the BOM list of a production order, including component status, picking and issuing status, while the right side provides more data through tab selections.

Important The system shows one level down in the BOM only, except when there is a phantom at that level.

Fig. 4.5
Component Summary List

Components									
Item Number	Qty Required	Qty Allocated	Qty Issued	Op	Component POH	Work Ctr	Item Description	Open Quantity	Component Status
A-C410	110	0	0	10			Component Inscr	110	No Status
A-C411	110	0	0	20			Component Cap	110	No Status
A-C412	110	0	0	30			Component Brack	110	No Status

View the component status here. A ? indicates the system has not calculated the status yet.

Item Number/Description. The number and description of the component that is behind the component status of the selected production order in the Sequence Grid.

Component Status. The status related to the POH of the component.

Quantity Required. The original quantity required for the item/production order.

Quantity Allocated. The quantity allocated for the item/production order.

Quantity Issued. The quantity already issued for the item/production order.

Op. The ID of the operation from where the component is backflushed.

Work Center. The ID of the work center to which the component is issued.

Component POH. The system-calculated value for projected quantity on hand for the component, considering all prior demand/supply, including the demand of the selected order. This does not include future production orders of Authorized status; however, Allocated/Released would also be included in the POH calculation.

Open Quantity. The open quantity for the production order.

Note You can add/remove fields to this panel in the .NET UI Browse Maintenance program.

Supply/Demand Summary

The Supply/Demand Summary Panel provides a summary of all supply/demand records for the selected component. It summarizes the total demand and supply for the component, considering the production order demand from the production order selected in the Sequence Grid.

Use the data in this panel to determine how the component projected on-hand was calculated using the following data:

- Prior scheduled production orders that also require the component
- Prior incoming supply for the component
- Authorized, firmed, or only planned replenishment

Rows, cells, and columns are automatically highlighted in the panel as follows:

- Demand rows: Highlighted demand row cells indicate that the demand row status category (planned, scheduled, authorized) is equal to the selected production order status.
- Projected On Hand: Highlighted Projected On Hand cell indicates the source POH for the selected component.
- Supply cell column: The highlighted supply cell column indicates the Projected On Hand value that was used to determine the component status.

The Supply/Demand Summary Panel lets you view the aggregated records from a matrix point of view:

- The top portion displays supply quantities. It lists the current quantity On Hand for the production order component item and other sources of supply up to the due date of the production order component record.
- The lower portion displays demand quantities. It lists the three categories of demand (Authorized, Scheduled, and Planned). Each row starts with prior demand requirements and the gross requirements of the selected production order component record. Then, from left to right, it adds in the current QOH, then adds in the other cumulative supply quantities to calculate the projected on-hand quantities.

This supply and demand matrix format provides you with a global view of component supply/demand.

Fig. 4.6
Supply/Demand Summary Panel

Components							
Item N	Supply/Demand Summary		Supply/Demand Details		Inventory Detail		
Supply/Demand Summary							
MRP Supply/Demand Records Summarized Thru:				8/20/09	For Selected Production ID:		1379
SUPPLY				On Hand	Authorized Receipts	Scheduled Receipts	Planned Receipts
Demand	Demand	Prior Gross Reqs	Gross Reqs	Projected On Hand			
	Authorized						
	Scheduled						
	Planned						

MRP Supply/Demand Records Summarized Thru. The issue date of the selected production order component record.

For Selected Production Order ID. The production order ID of the selected production order component record.

On Hand. The nettable, on-hand inventory found in all locations across the site.

Authorized Receipts. The sum of all authorized receipts prior to the Issue Date of the selected production order component record. Authorized receipts are sources of supply and include:

- Production orders with a status of Allocated or Released that cover production order component requirements
- Unconfirmed ASNs that cover the production order component requirements

Firm Receipts. The sum of all firm receipts before the Issue Date of the selected production order component record.

Planned Receipts. The sum of all planned receipts before the Issue Date of the selected production order component record.

Gross Reqs. The current open quantity of the selected production order component record not netted with inventory.

Supply/Demand Details

Use the data in the panel to easily:

- View demand detail information; for example, demand source, due date, and quantity.
- View supply detail information; for example, supply source, due date, and quantity.
- Determine when inventory expires and the impact on production.
- Identify where you should reprioritize; for example, you can correct a shortage if you expedite production order B and reschedule production order A.

Fig. 4.7
Supply/Demand Details

Supply/Demand Summary									
Supply/Demand Detail					Inventory Detail By Site				
Date	Demand	Supply	Auth PQOH	Firm PQOH	Plan PQOH	Source		Reference	
09/16/2009	0	60	150	210	210	Order: Supplier: Quality Products Div 1000		Order: bws Line: 1	
10/29/2009	180	0	-30	30	30	W/O Component: Line: A410 Work Ctr: A410		W/O: 10050036 ID: 2152 Assembly: A-F414 W/O Stat: A	
10/29/2009	140	0	-170	-110	-110	W/O Component: Line: A410 Work Ctr: A410		W/O: 10050043 ID: 2159 Assembly: A-F415 W/O Stat: A	
10/29/2009	12	0	-182	-122	-122	W/O Component: Line: A410 Work Ctr: A410		W/O: brent ID: 2615 Assembly: A-F410 W/O Stat: A	
10/29/2009	300	0	-482	-422	-422	W/O Component: Line: A410 Work Ctr: A410		W/O: bws2 ID: 3071 Assembly: A-F410 W/O Stat: A	
10/30/2009	610	0	-1092	-1032	-1032	W/O Component: Line: A410 Work Ctr: A410		W/O: 10050008 ID: 2124 Assembly: A-F410 W/O Stat: A	
11/11/2009	5	0	-1092	-1037	-1037	W/O Component: Line: A410 Work Ctr: A410		W/O: A-F510 ID: 4378 Assembly: A-F410 W/O Stat: F	
11/12/2009	120	0	-1092	-1037	-1157	W/O Component: Line: A411 Work Ctr: A410		W/O: 10050013 ID: 2129 Assembly: A-F411 W/O Stat: P	
11/12/2009	108	0	-1092	-1037	-1265	W/O Component: Line: A410 Work Ctr: A410		W/O: 10050019 ID: 2135 Assembly: A-F412 W/O Stat: P	
11/13/2009	35	0	-1092	-1037	-1300	W/O Component: Line: A410 Work Ctr: A410		W/O: 10050027 ID: 2143 Assembly: A-F413 W/O Stat: P	
11/14/2009	0	1603	-1092	-1037	303	W/O		W/O: 10050051 ID: 2170 W/O Stat: P	
11/16/2009	100	0	-1092	-1137	203	W/O Component: Line: A411 Work Ctr: A410		W/O: 10050014 ID: 2130 Assembly: A-F411 W/O Stat: F	

Date. The release dates for demand records or the due dates for supply records.

Demand. The standard MRP definition for demand.

Supply. The standard MRP definition for supply.

Auth POH. The POH of all authorized demand/supply records.

Firm POH. The POH of all firm and authorized demand/supply records.

Plan POH. The POH of all planned, firm and authorized demand/supply records.

Source. The demand/supply record source; for example, production order, sales order, production line, and so on.

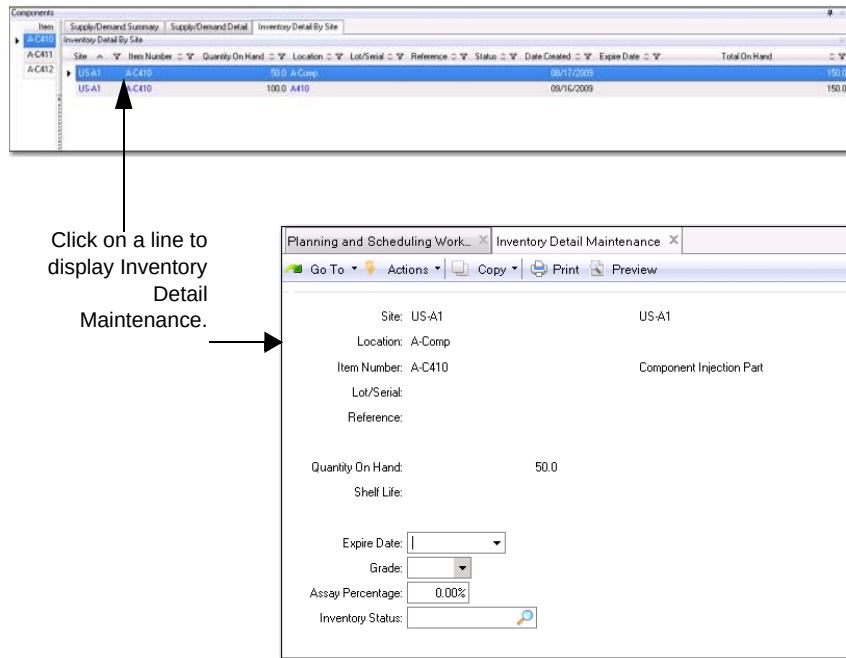
Reference. The demand/supply record reference; for example, the order number, assembly item number, and so on.

Inventory Details by Site

Use the data in the Inventory Details sub-tab to drill into component inventory detail records to determine options when dealing with component shortages.

When you select a record within the Inventory Details by Site Panel, and click on the record, the system launches the QAD EE Inventory Detail Maintenance program.

Fig. 4.8
Inventory Details by Site



Site. The site associated with the inventory.

Item Number. The item number.

Quantity on Hand. The system organizes inventory detail data by item, site, location, lot/serial, then reference. For each unique combination of these values, the system tracks the quantity on hand and other inventory attributes, such as expire date and status.

Location. The ID of the physical location where inventory is stored.

Lot/Serial. The lot/serial number for the item.

Reference. The lot reference number.

Status. The inventory status code associated with the inventory quantity. Inventory status codes determine whether inventory balances are available for allocation, are considered by MRP, or are allowed to go negative. Status codes also restrict particular transactions at specific locations.

Date Created. The date the inventory detail record was created.

Expire Date. The date the inventory expires.

Total on Hand. The total on hand quantity of this item in inventory.

Troubleshooting, Tips, and Errors

Use this appendix when issues arise in functionality.

Overview 94

Presents an overview of the type of information found in this appendix.

Errors 98

Describes errors that can display in the workbenches and provides solutions or workarounds to correct them.

Overview

The PSW, MSW, CAC, and other workbench features play a crucial role in your day-to-day scheduling operations. So when problems occur or issues arise, your workday is affected, and this, in turn, indirectly affects production.

You can take a number of basic steps to solve workbench problems on your own, or, at the very least, narrow down their causes. So the next time you encounter a misbehaving function, try performing the troubleshooting tips in this appendix.

You can also document the steps you take; that way, if a tech-support call becomes inevitable, you can eliminate what is not causing the problem.

Item Number Displays, but Not Planned Orders

For a production line, the item number displays on the workbench, but none of the MRP planned orders for the item display.

Assumptions:

- MRP planned orders exist for the item number.
- The item number is defined as an L(ine) type item in Item Planning Maintenance (1.4.7).
- The item is set up on a production line.

Possible Causes

You defined a production line for an item after you ran MRP. The planned order created by MRP does not have the planned orders assigned to the production line.

You define the item on two or more production lines. The production line you are viewing is NOT the primary production line. Planned production orders are only defaulted on the primary production line.

Solution

Check primary production line for item. Regenerate MRP.

Repetitive Scheduled Order S Type Not Created

For a production line, you firm a planned order, but the system did not create a repetitive, S-type, scheduled order.

In MSW, it is possible to schedule a discrete production order on a production line.

Assumption: The item is set up on a production line.

Possible Causes

The item number is not defined in the item master (site master) as a Pur/Mfg item of L type.

Solution

Set the Pur/Mfg code to L in Item Data Maintenance (1.4.1). Pur/Mfg codes other than L default the firmed order as a discrete order.

Item Does Not Display in MSW

In MSW, the item for the order does not display.

Possible Causes

The item does not have a routing defined for it.

The item does not have active supply and demand in the scheduling horizon you specified. Items that display in the MSW Schedule Grid that fall within the search criteria have supply and demand data for them. Items without supply and demand data do not display in the workbenches.

Solution

Set up a routing for the item in Routing Maintenance (14.13.1) and generate a work order routing for a work order containing this item. This creates the records needed to show the item in the Planning and Scheduling Workbenches.

If a routing is defined, alter the scheduling horizon through the Options pull-down menu by selecting Preferences, then the Search tab in the Planning and Scheduling Workbenches.

Item Does Not Default as a Repetitive Scheduled Item

On a production line, the item does not default as a repetitive scheduled item.

Possible Cause

The Pur/Mfg code is not set to L for the item master.

Solution

Set the Pur/Mfg code to L in Item Master Maintenance (1.4.1).

MSW-Selected Item Does Not Display in PSW**Possible Cause**

A filter has been applied to the MSW/PSW that hides a production line or item that is visible on one frame/grid and not another. The system will still select/focus on the item record, even if not visible.

Also, the sequencing horizon may be less than the MSW scheduling horizon.

If you are viewing items on a work center resource, the setting of the Pur/Mfg field does not have an impact on this issue; however, setting the BOM and routing does have an impact. Likewise, BOM/routing does not impact viewing an item on the production line, but the setting of the Pur/Mfg field does.

Solution

Remove the filter. The selected record displays as selected.

Change the horizons through the Options pull-down menu by selecting Preferences, then the Search tab in the Planning and Scheduling Workbenches. Verify that for both work center and production lines, there is an active supply/demand for the item within the search history/future horizon.

If viewing items on a production line, set the Pur/Mfg field to L in Item Data Maintenance (1.4.1).

Some Workbench Grids Do Not Show Past Due Data

The Schedule Grid, Supply/Demand Grid, and Capacity Grid do not show data related to past due orders.

Probable Cause

The Schedule Grid, Capacity Grid, and Supply/Demand Grid only show data related to past due orders when they are within the setting of the History Horizon field in the Search window of the Preferences option.

Solution

If you see past due orders but not the detail related to them, expand the history horizon value to see the related data (supply, demand, and so on).

Also, the Production Order Maintenance window within the workbench shows past due orders. Past due open production orders display first, regardless of the history horizon setting you have selected in your user preferences.

Item Highlighted in Red in MSW but No Shortage

The system highlights an item in red for a POH issue in the MSW workbench, but there are no shortages within the production line's scheduling horizon end date.

Probable Cause

This occurs because the item that is on that particular resource is also on other resources in the Schedule Grid. When this is the case, the system looks at the number of firm scheduling days for all resources for which the item is scheduled in the grid; then, it selects the number of firm days that is the highest to associate with the item. So, even though the specific work center that is highlighted may have zero (0) firm scheduling days, another resource for which the item is

scheduled may have, for example two firm scheduling days, so the system uses the two firm scheduling days for the item status for the item, regardless of the resource with which the item is paired.

Solution

No solution required.

Completed Production Order and Item No Longer Display on Workbench

The MSW displays completed production orders where the production order due date is within the history/future horizon that you define through the Options pull-down menu by selecting Preferences, then the Search tab in the Planning and Scheduling Workbenches. When the item you produced has no other active supply/demand records (mrp_det) records, the item/order no longer displays on the workbench.

Probable Cause

If an item has no mrp_det records in the system for any of the sites, then that item and its production orders do not display. For example, if you have an item with just one production order in the system, and you receive the production order but do not close it, the production order can have a zero open quantity but an exploded status. Normally, the order displays as a search result, but once the production order was fully received, the system deleted the mrp_det record for that order. Since that was the only production order for the item and no other mrp_det records exist, that item and the order do not display.

Item Does Not Display in MSW

Item does not display on a repetitive production line in the MSW.

Probable Cause

An item does not display in the MSW when:

- It does not have a routing/BOM defined.
- It does not have active supply/demand in the horizon you are viewing.

When you add an item to the production line, the system displays warnings when the routing or BOM does not exist for the item. Also, the system displays a warning when the item is not set as a repetitive manufactured item in item planning records.

Solution

In Item Planning Maintenance (1.4.7) or Item Data Maintenance (1.4.1), set the Purchase/Manufacturer code for the item to L.

Note If the message displays because you are scheduling discrete orders on a production line or working with items that may only be manufactured discretely, you can overlook the warning and continue processing.

Ensure that a routing exists in Routing Maintenance (14.13.1) and that a product structure (BOM) exists in Product Structure Code Maintenance (13.1).

Errors

WO Record Locked By Another User

If you are working in MSW, then use QAD EE Work Order Maintenance (16.1) to edit an order that MSW receives, then return to the MSW workbench to modify the order and attempt to save the order, the system displays a red icon in the MSW and an error message, informing you the record is locked by another user.

Additionally, when Work Order Control (16.24) is locked, it may lock Production Order Maintenance, so that MSW cannot create new production orders when you leave the ID and Number fields blank. When this occurs, you may receive an error message.

Data Modified by Another User

You can receive an error message in the workbenches, indicating that another user modified data. When you receive this error while attempting to update records, the system does not let you update. You must refresh data by searching for records again before you update.

The error can display in the following situations:

- You are saving several orders in the workbenches; however, one record is open in the CHUI version of QAD EE.
- You open a production order record in MSW, then change that same production order in another program. After, you attempt to update the order along with several others in MSW and click save.
- You make changes as described above but from one of the following tabs: Detail, Comments, Date/Time, and Compliance.
- You open a planned order in the Production Order Maintenance window, delete demand, run MRP so that the system deletes planned orders, then save the planned order.
- You open a planned order, change demand so that the system creates new planned orders, run MRP, then save the planned order.

System Unable to Process Request

The system can display a message indicating that it cannot process a request. This can occur, for example, when the system is retrieving a large number of records for a search. When this happens, check the log file. Typically, the system cannot process requests because it has run out of memory.

When this occurs, try any or all of the following:

- Reboot the PC to clear memory usage.
- Change the search criteria to extract less data.
- Upgrade the PC with more memory 4 GB or more.

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