QAD Enterprise Applications
Enterprise Edition

Training Guide

WIP Lot Trace

70-3051D
QAD 2011 Enterprise Edition
Lab: Enterprise Edition 2011 - Addons r02 - Training
Workspace: 10USA > 10USACO
April 2011

WIPLotTrace_TG_v2011EE.pdf/mdf/b3k

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Contents

About This Course

Course Description

QAD designed this course to cover the basics of preparing to implement the WIP Lot Trace (WLT) module of QAD Enterprise Applications. The course includes:

- An introduction to the WLT module
- An overview of key business considerations
- Setting up the WLT module
- Operating the WLT module
- Activities and exercises throughout the course
  - Students practice key concepts and processes in the WLT module

Course Objectives

By the end of this class, students will:

- Know how to analyze key business decisions before setting up the WLT module
- Know how to set up and operate the WLT module

Audience

- Implementation consultants
- Members of implementation teams
- Key users

Prerequisites

- Basic knowledge of how QAD Enterprise Applications is used in the business
- Working knowledge of the manufacturing industry in general

Course Credit and Scheduling

This course is designed to be taught in one day.

Virtual Environment Information

The hands-on exercises in this book should be used with the Enterprise Edition 2011 - Addons r02 - Training environment, in the 10USA > 10USACO workspace.

QAD Web Resources

The QAD website provides product and company overviews.

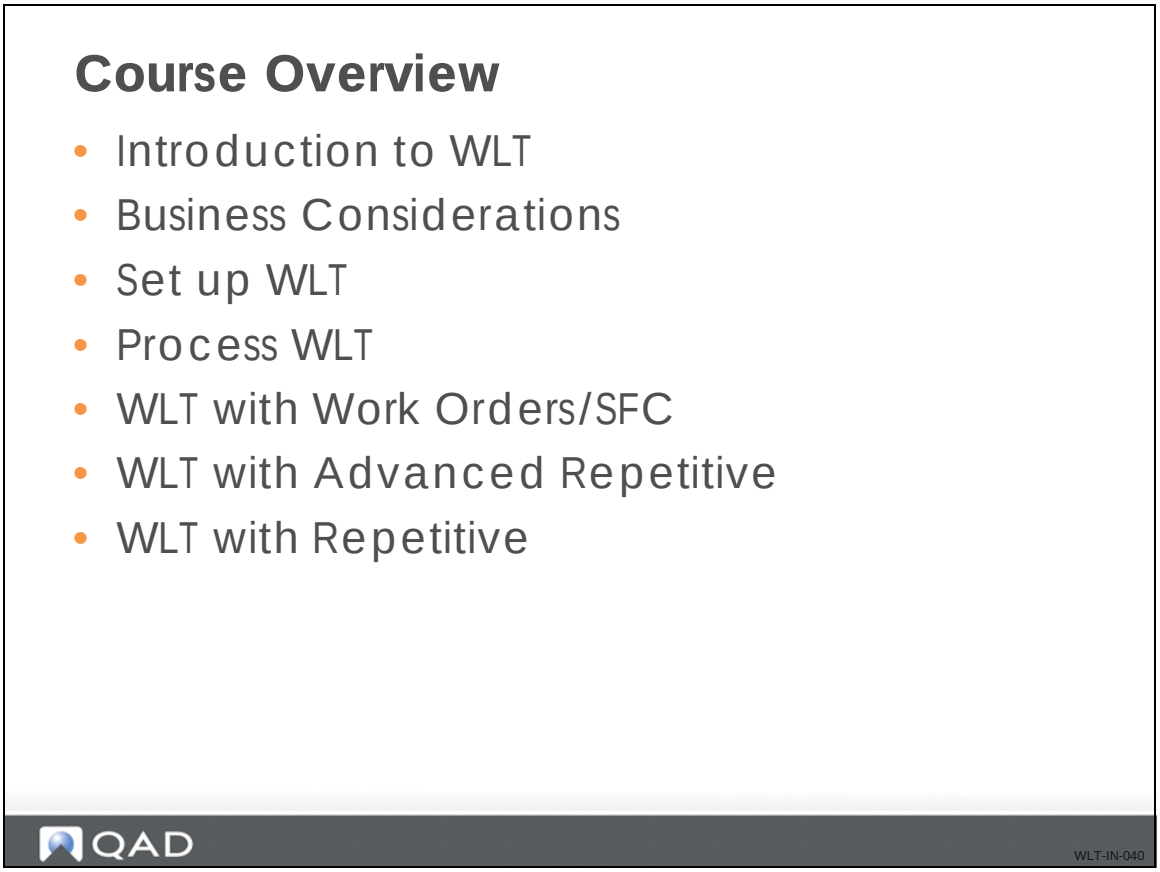
http://www.qad.com/

From QAD's main site, you can access QAD's Learning or Support sites.

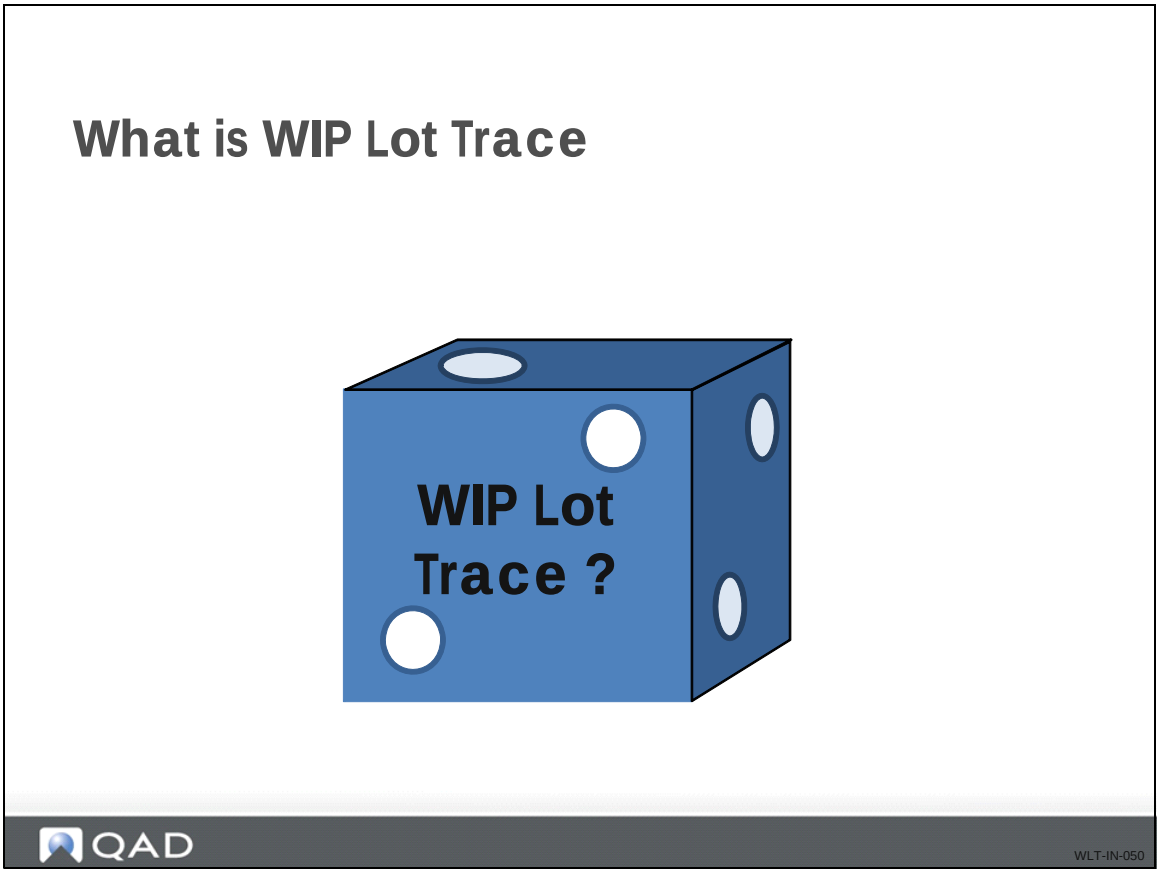
Chapter 1

Introduction to WLT

Course Overview



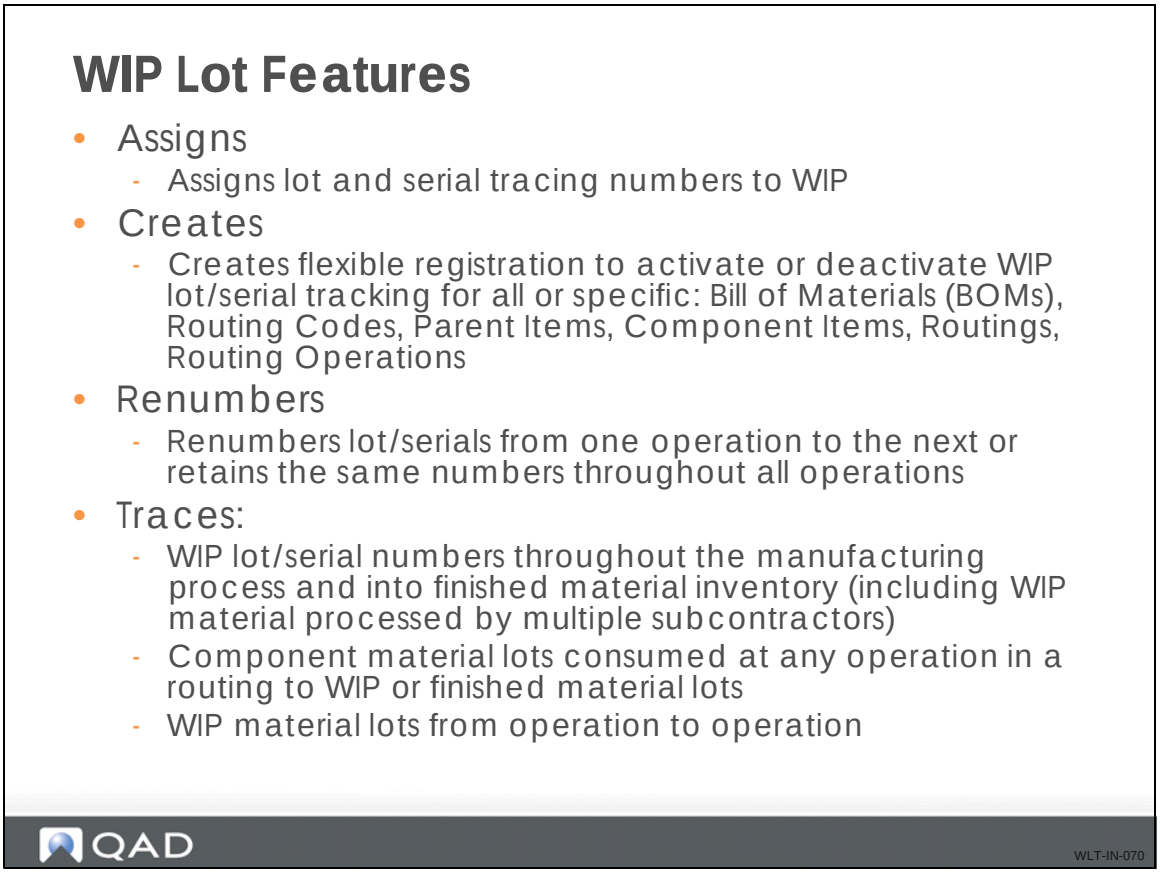
What is WIP Lot Trace?



WIP Lot Trace (WLT) is functionality in QAD Enterprise Applications that adds work-in-process (WIP) lot and serial tracing and reporting to several modules.

- Tracing records are created at the operation level whenever registered resources are consumed or produced
- Use to trace component, WIP material, and finished goods based on parent items, product structures, and routings

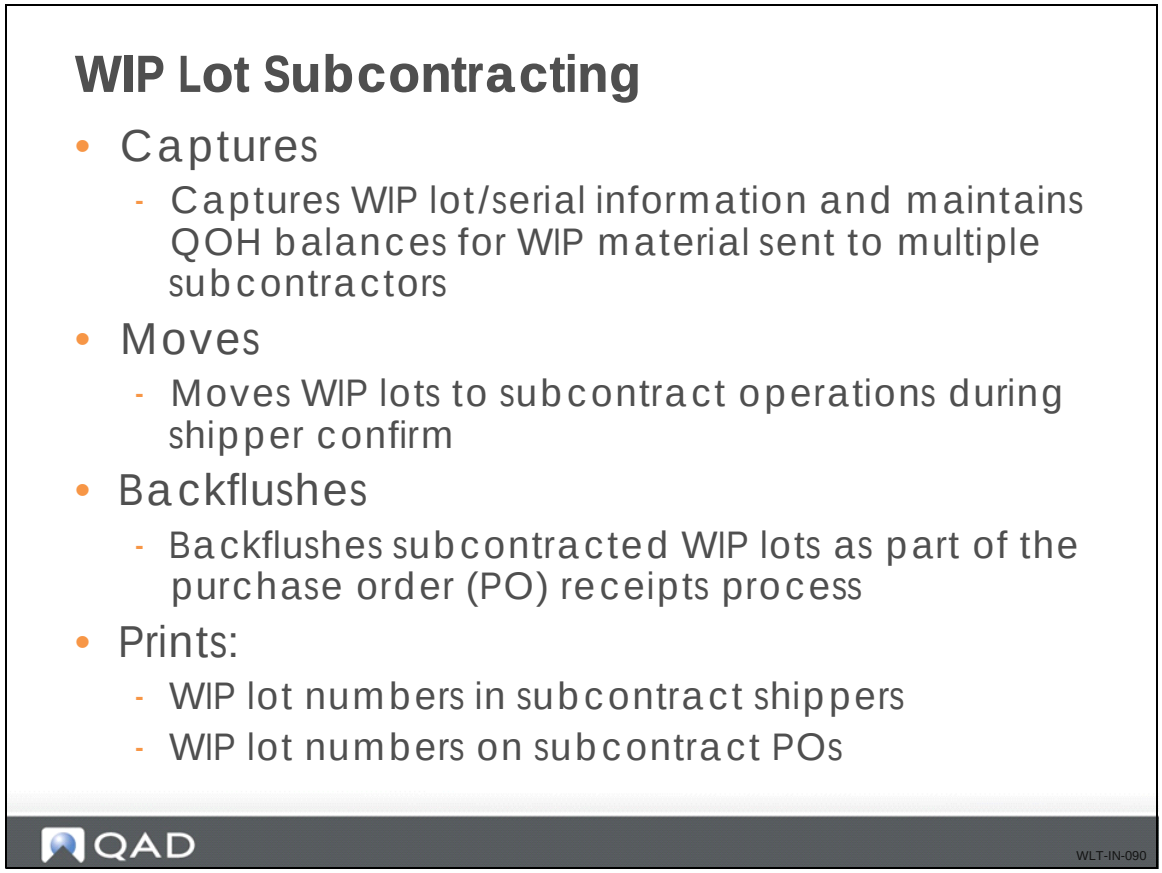
WIP Lot Features



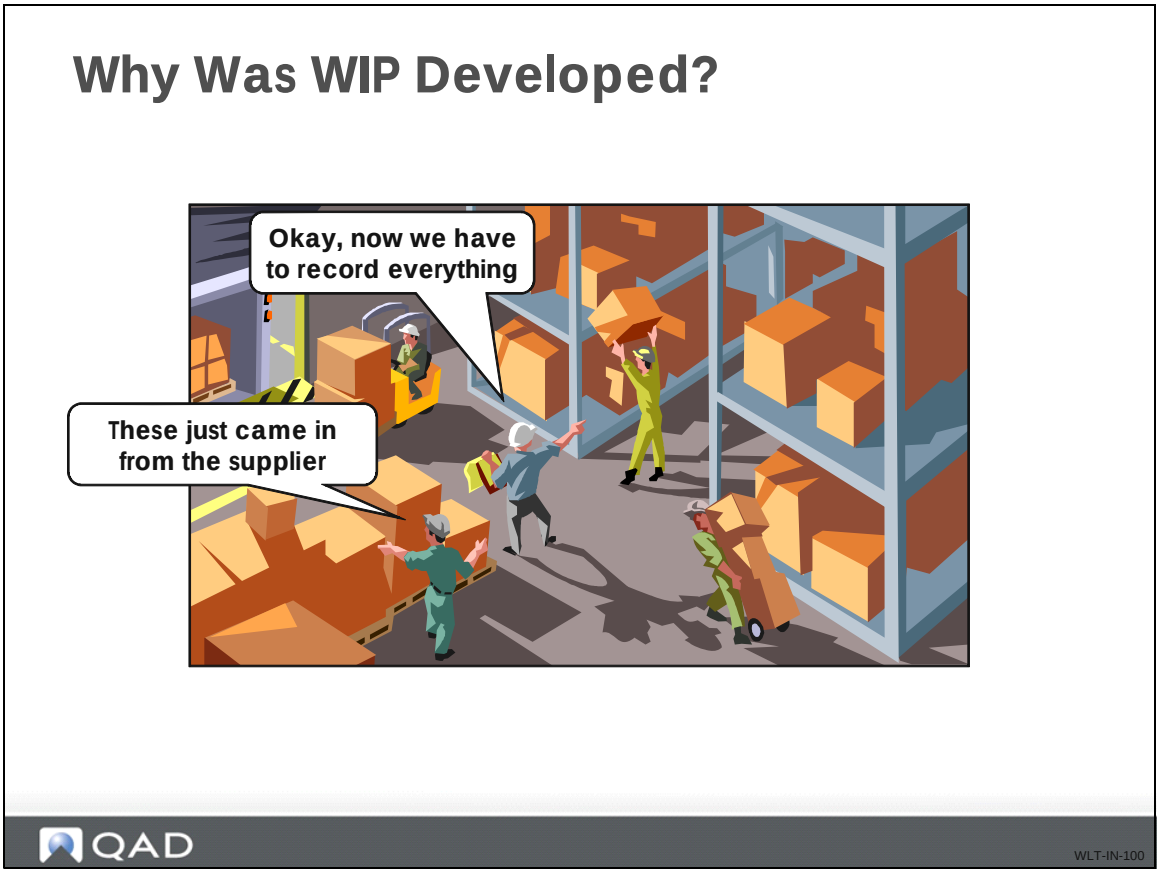
WIP Lot Features (continued)

- Determines
  - Determines the constituent WIP or component material lots of finished or WIP material lots
- Maintains:
  - Complete WIP tracing history
  - Up-to-date cumulative scrapped, consumed, and produced quantities for traced WIP lot/ serial numbers at the operations level
  - Quantity-on-hand (QOH) balances at the operation level for traced WIP lot serials
- Generates
  - Reports providing visibility or WIP lot/serial numbers and quantities
  - Can assign WIP lot/serial numbers automatically using Number Range
  - Management (NRM) features
- Controls
  - Lot sizes for all traced material Combining and splitting of lot and component material being traced WIP inventory QOH balances for WIP material lot/serials being traced

WIP Lot Subcontracting



Why Was WIP Developed?



Many companies need to keep detailed records of the:

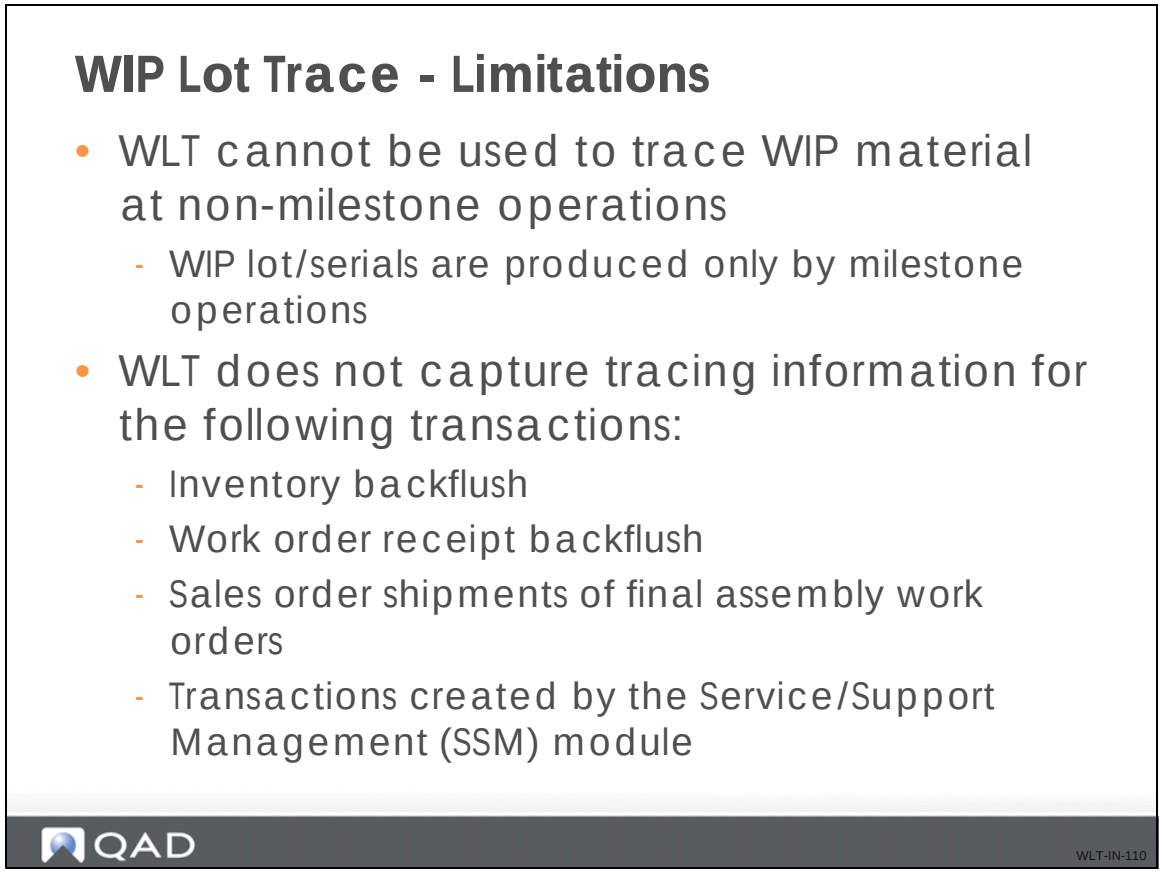
- Raw materials they receive from their suppliers
- WIP that consumes those raw materials
- Finished items produced from WIP

Additionally, they must be able to track any WIP material sent for subcontract processing.

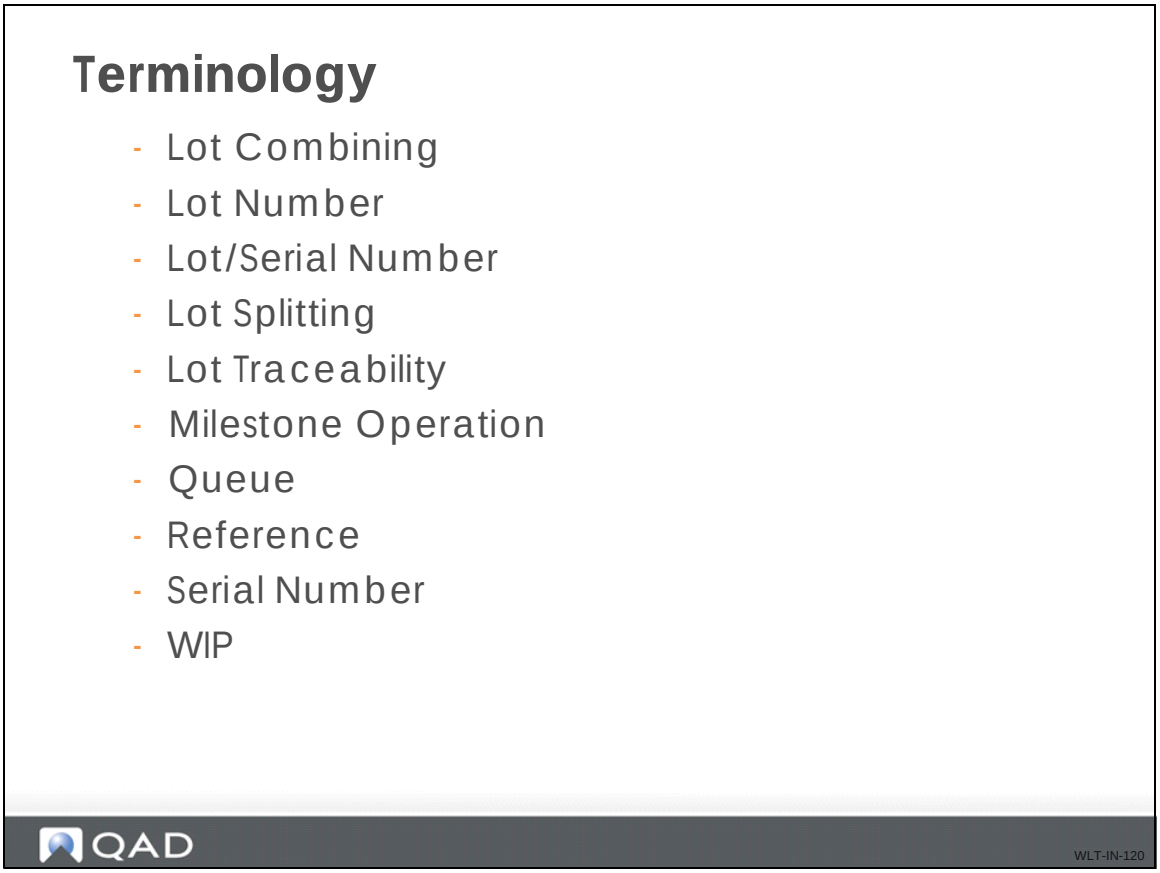
Some manufacturing environments require the ability to trace WIP to comply with government and customer safety requirements and regulations.

- ADG customers needed it
- Legal requirements

WIP Lot Trace - Limitations



Terminology



Lot Combining

Creating one lot of processed material from several lots of input material.

Lot Number

A unique combination of letters and/or numbers identifying a discrete group of items in an inventory location.

Lot/Serial Number

Indicates it can be either a lot number or a serial number.

Lot Splitting

Creating several lots of processed material from one input lot.

Lot Traceability

Lot consumption and production information sufficient to trace material lots through the manufacturing and distribution process.

Milestone Operation

An operation, defined in Routing Maintenance (14.13.1), that is used to report completions.

Queue

A factory location containing material processed by an operation.

Reference

An additional, optional identifier that can be assigned to lot-controlled material.

Serial Number

A unique ID assigned to a discrete, single piece of material.

WIP

Work In Process. Indicates a product in various stages of completion throughout the plant. Stages include raw material released for manufacturing, up to completely processed material awaiting final inspection and acceptance as finished product.

Supported Operations

Several modules have been modified to use the WLT functionality.

Advanced Repetitive

- Operation Transaction Detail Inquiry (18.22.4.2)
- WIP Status Report (18.22.4.11)
- Sub Container Maintenance (18.22.5.4)
- Sub Shipper Maintenance (18.22.5.5)
- Sub Shipper Print (18.22.5.9)
- Sub Shipper Issue (18.22.5.11)
- Cumulative Order Close (18.22.10)
- WIP Status Inquiry (18.22.12)
- Backflush Transaction (18.22.13)
- Run Labor Transaction (18.22.14)
- Setup Labor Transaction (18.22.15)
- 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)

Inventory Control

- Transfer with Lot/Serial Change (3.4.3)
- Batchload Transfer with Lot/Serial Change (3.4.4)
- Transaction Detail Inquiry (3.21.1)

Purchasing

- Purchase Order Maintenance (5.7)
- Purchase Order Print (5.10)
- Purchase Order Receipts (5.13.1)
- Purchase Order Returns (5.13.7)
- PO Container Maintenance (5.13.13)
- PO Shipper Maintenance (5.13.14)
- PO Shipper Receipt (5.13.20)

Shop Floor Control

- Labor Feedback By Work Order (17.1)
- Labor Feedback By Employee (17.2)
- Labor Feedback By Work Center (17.3)
- Operation Move Transaction (17.6)
- Operation Scrap Transaction (17.7)
- Operation Transaction Browse (17.8)
- Operation Transaction Detail Inquiry (17.9)
- Operation by Work Center Report (17.13)
- Operation by Work Order Report (17.14)
- Operation by Employee Report (17.15)

(Standard) Repetitive

- Repetitive Transaction Detail Inquiry (18.4.2)
- Repetitive Setup Transaction (18.13)
- Repetitive Labor Transaction (18.14)
- Repetitive Rework Transaction (18.16)
- Repetitive Reject Transaction (18.17)
- Repetitive Scrap Transaction (18.18)

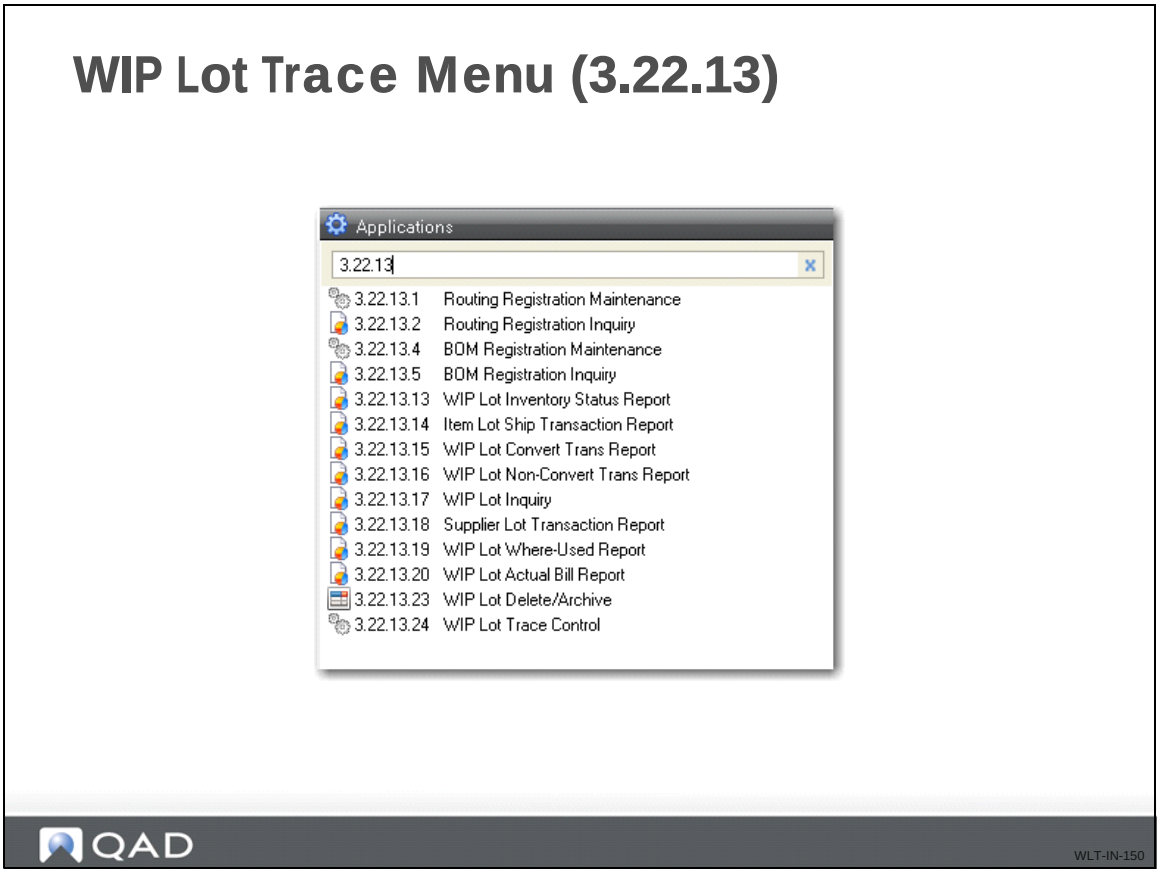
Work Orders

- Work Order Split (16.9)
- Work Order Component Issue (16.10)
- Work Order Receipt (16.11)
- Work Order Receipt Backflush (16.12)
- Work Order Operation Backflush (16.19)

When using WLT in a work order manufacturing environment, you should be aware of the following:

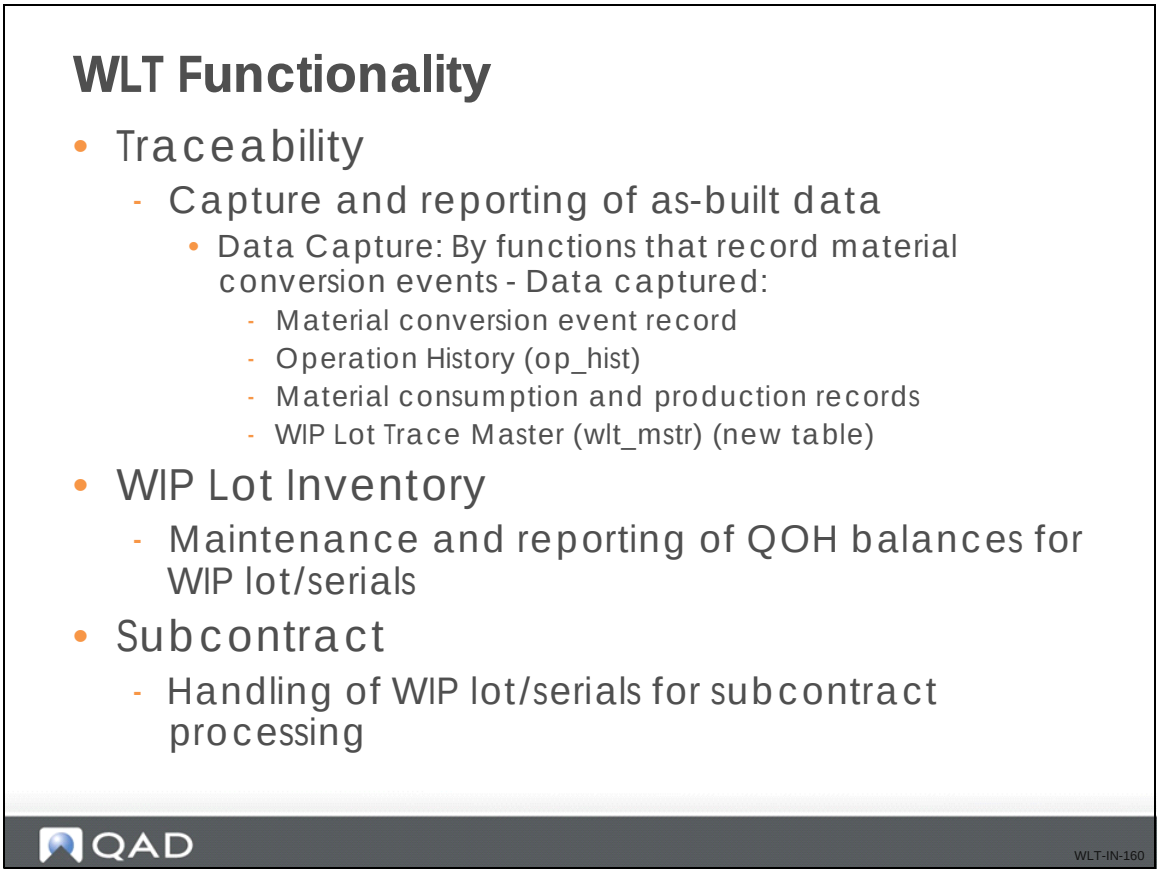
- Work Order Receipt Backflush (16.12) is disabled because it does not let you report production on an operation per operation basis
- You must specify an operation when processing a receipt, issue, or labor transaction for a WLT controlled work order

WIP Lot Trace Menu

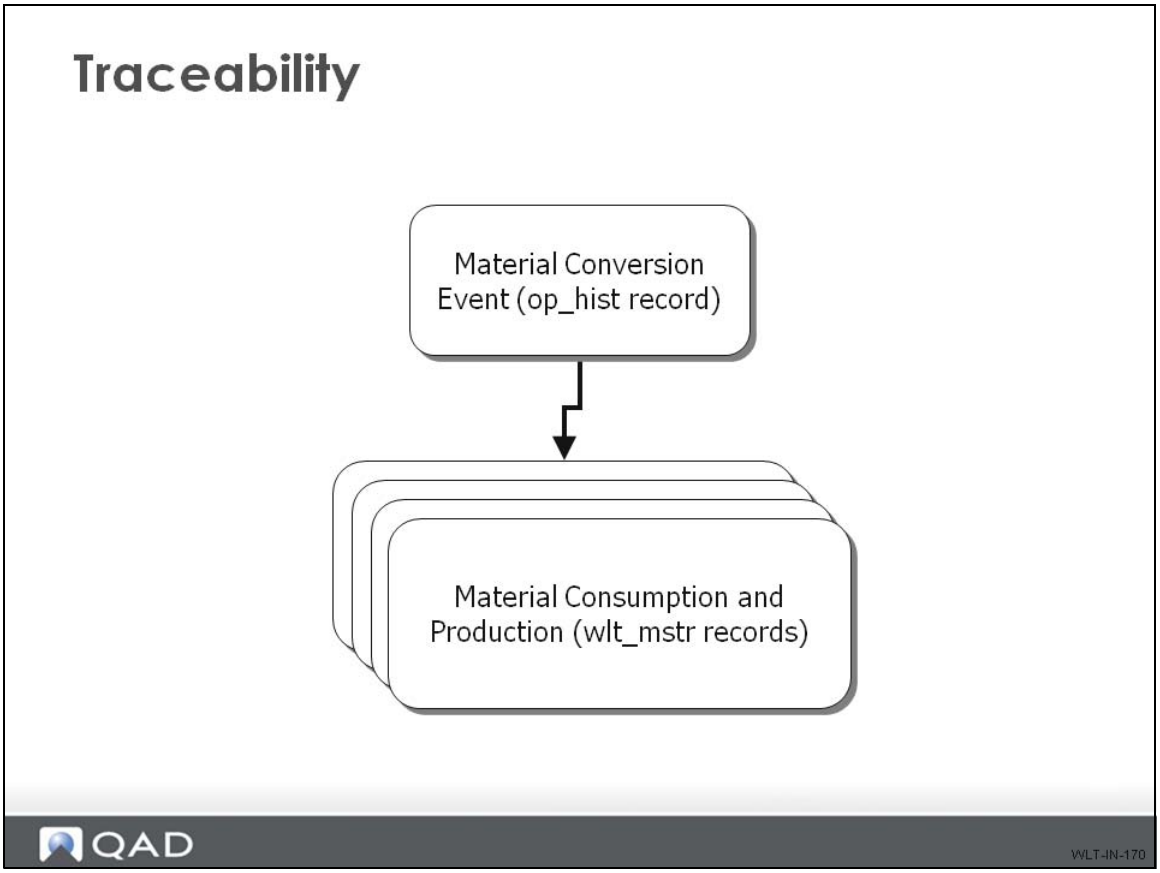


Use the WIP Lot Trace Menu to access specific WLT functions. You turn on WLT by setting the Enable WIP Lot Trace field to Yes in WIP Lot Trace Control File (3.22.13.24).

WLT Functionality

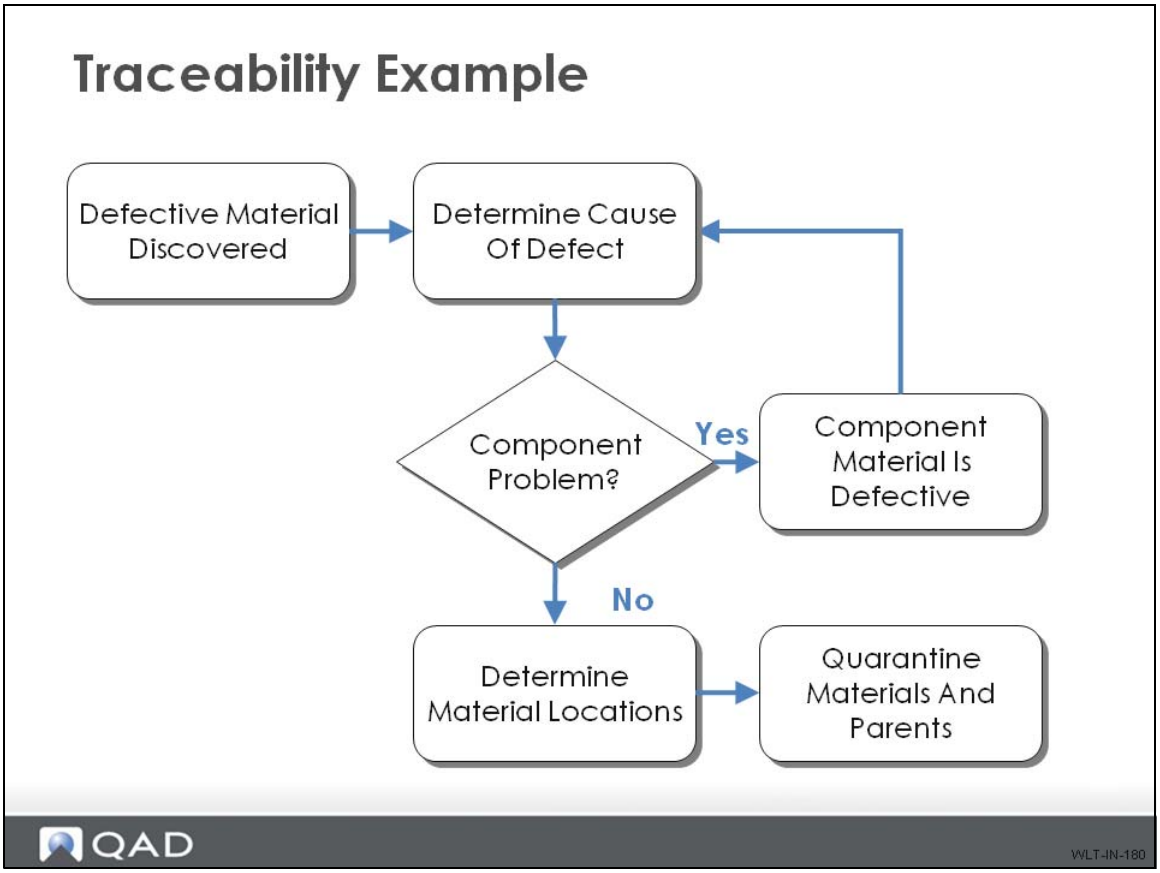


Traceability



The above graphic shows an example of captured data.

Traceability Example



Traceability - Data Reporting

Traceability

- Data Reporting

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- WIP Lot Where-Used Report (3.22.13.19)
- Lot Actual Bill Report (3.22.13.20)
- Transaction detail reports
- Transaction detail inquiries

WIP Lot Inventory

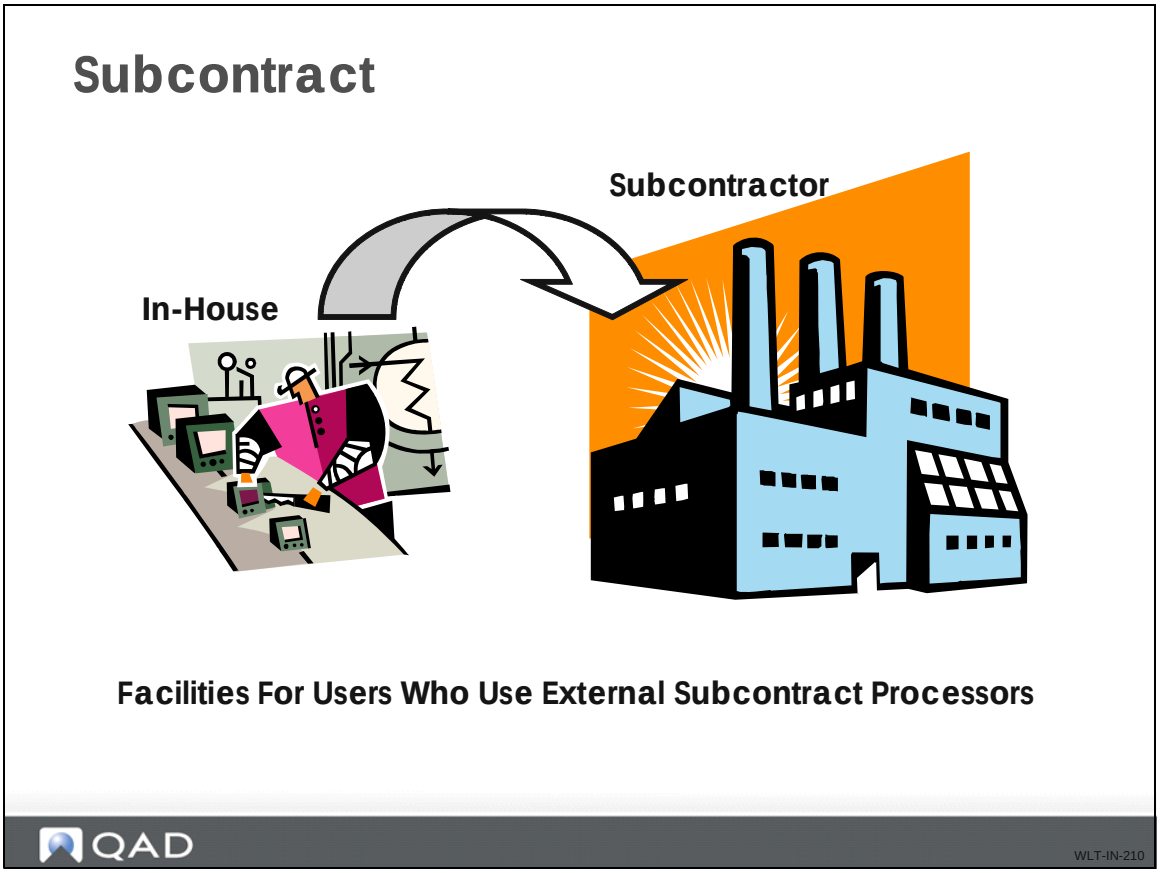
Data Maintenance

- QOH balances maintained by:
  - WIP lot/serial
  - Operation
  - Queue
  - Work center
  - Machine
- Similar to inventory QOH balances
- Updated by material conversion functions (e.g., Backflush) and other functions (e.g., Scrap, Reject, Rework, Adjust)

Data Reporting

- WIP Lot Inventory Status Report (3.22.13.13)
- Advanced Repetitive WIP Status Inquiry/Report

Subcontract



Traceability data captured/WIP lot QOHs maintained.

- Purchase Order Maintenance (5.7)
  - Entry of a WIP lot/serial on each subcontract-type line
- Purchase Order Print (5.10)
  - Print entered WIP lot/serial
- Sub Container Maintenance (18.22.5.4) and Sub Shipper Maintenance (18.22.5.5)
  - Entry of a list of WIP lot/serials to ship
- Sub Shipper Print (18.22.5.9)
  - Print WIP lot/serials entered
- Advanced Repetitive Sub Shipper Confirm
  - Moves WIP lot/serials to next operation
- Purchase Order Receipts (5.13.1)
  - Backflushes the referenced operation
  - Entry of WIP lot/serials consumed and produced

Review Questions

1. Does WIP Lot Trace impact component items? (Y/N)
2. Does WIP Lot Trace track items at non-milestone operations? (Y/N)
3. How does WIP Lot Trace impact Sales Orders?
4. Does WIP Lot Trace give you visibility of items after sale? (Y/N)

Chapter 2

Business Considerations

Course Overview

Business Considerations

In this section you learn how to:

- **Identify key business considerations before setting up WLT in QAD Standard Edition**
- Set up WLT in QAD Standard Edition
- Process WLT in QAD Standard Edition
- WLT with Work Orders/SFC
- WLT with Advanced Repetitive
- WLT with Repetitive

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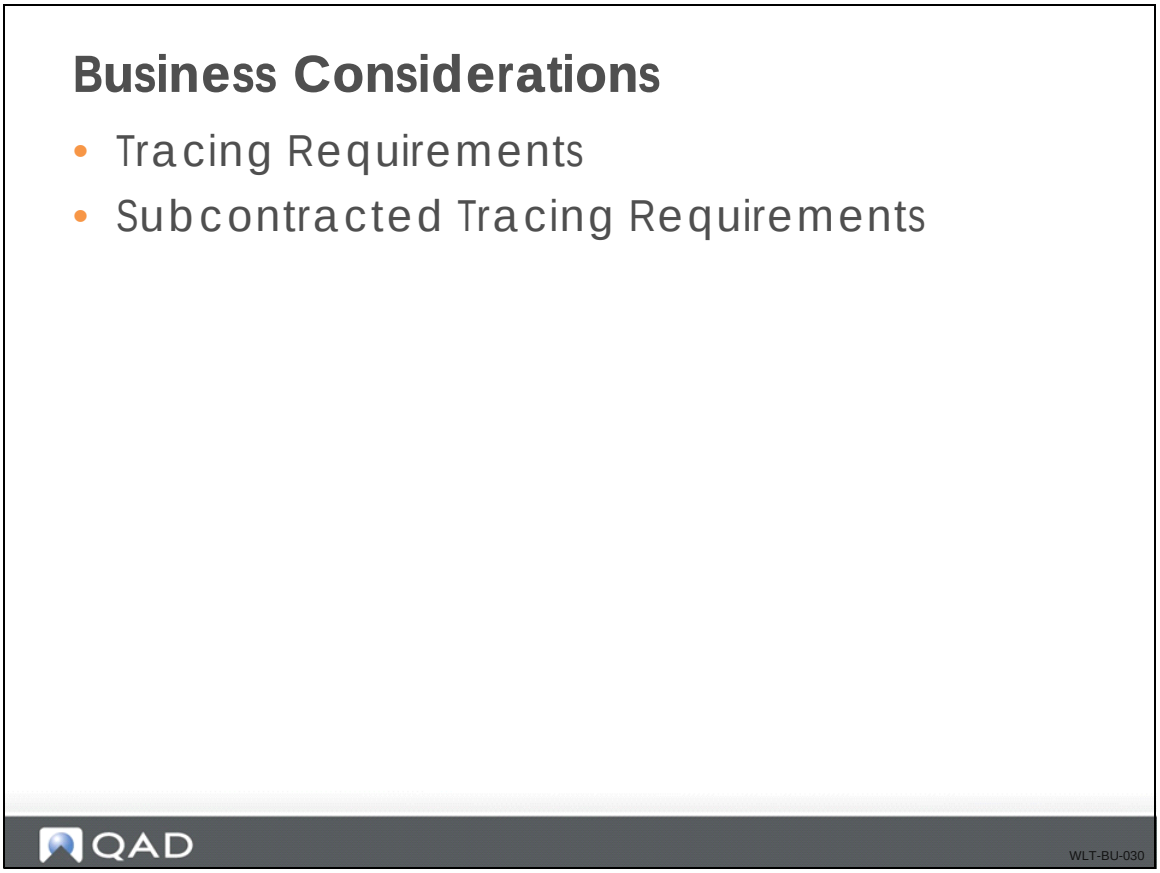
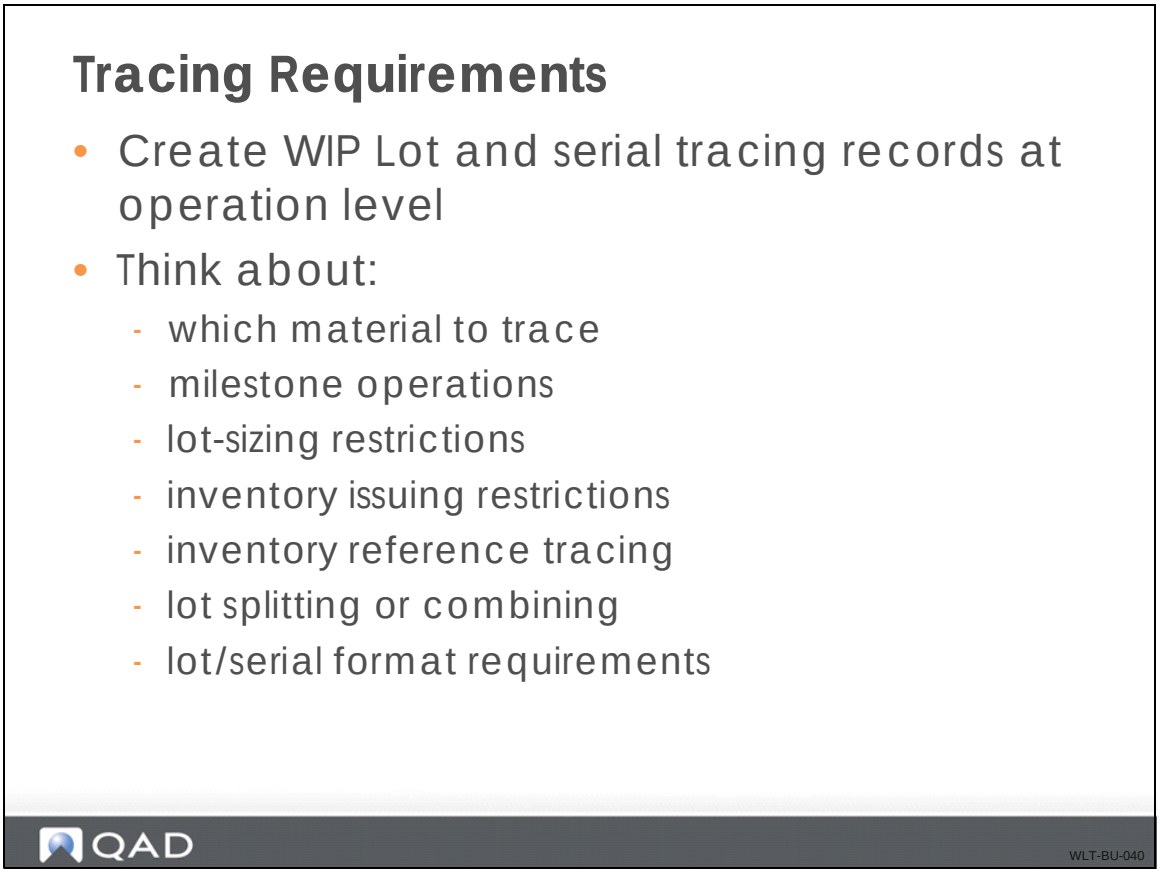
Considerations



There are several business considerations to look at before setting up WIP Lot Trace.This section does not discuss all potential considerations, but presents several to generate thought and discussion.

Tracing Requirements



Definition

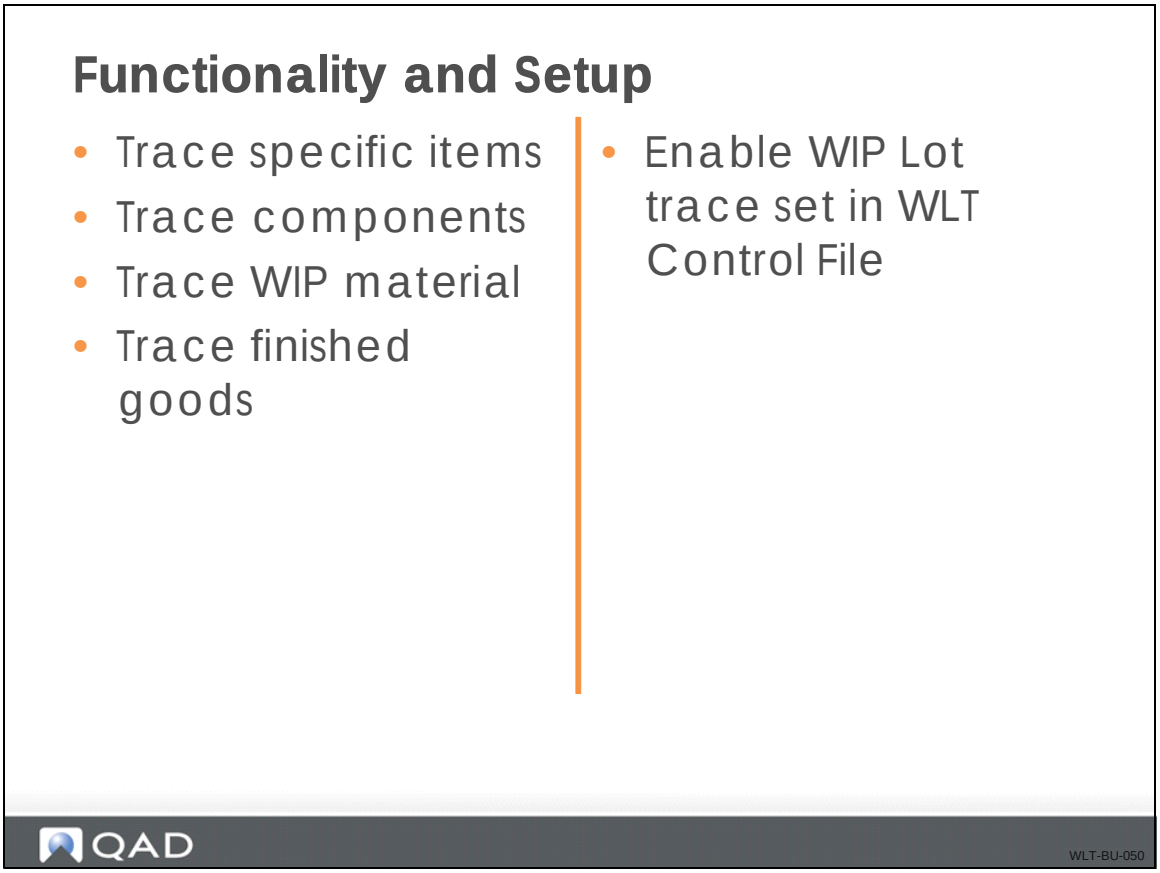
WLT allows you to create WIP lot and serial tracing records at the operation level whenever registered resources are consumed or produced. However, exactly what tracing records are created is determined by how you define your tracing requirements. In other words, you need to determine exactly how much tracing your manufacturing environment requires. Once you determine that, you can set up or define your individual tracing requirements.

What to Consider?

- Decide which material to trace (i.e., which routings and BOMs consume components), and create the WIP material you need to trace
- Know the milestone operations
- If there are any lot-sizing restrictions in your manufacturing environment, list these restrictions, organized by routing, operation, and work center
- If there are any inventory lot quantities issuing restrictions, create records in Routing Registration Maintenance (3.22.13.1) that prevent or allow WIP lot overissuing based on the routing or routing operation
- If inventory reference tracing is required, set up naming and usage standards for references

- Determine if lot splitting or combining is an issue, and if so, clearly defined the requirements then use the information to create records in Routing Registration Maintenance (3.22.13.1) and BOM Registration Maintenance (3.22.13.4)
- If you have specific lot/serial number format requirements, create NRM sequence IDs using Number Range Maintenance (36.2.21.1)

Functionality and Setup

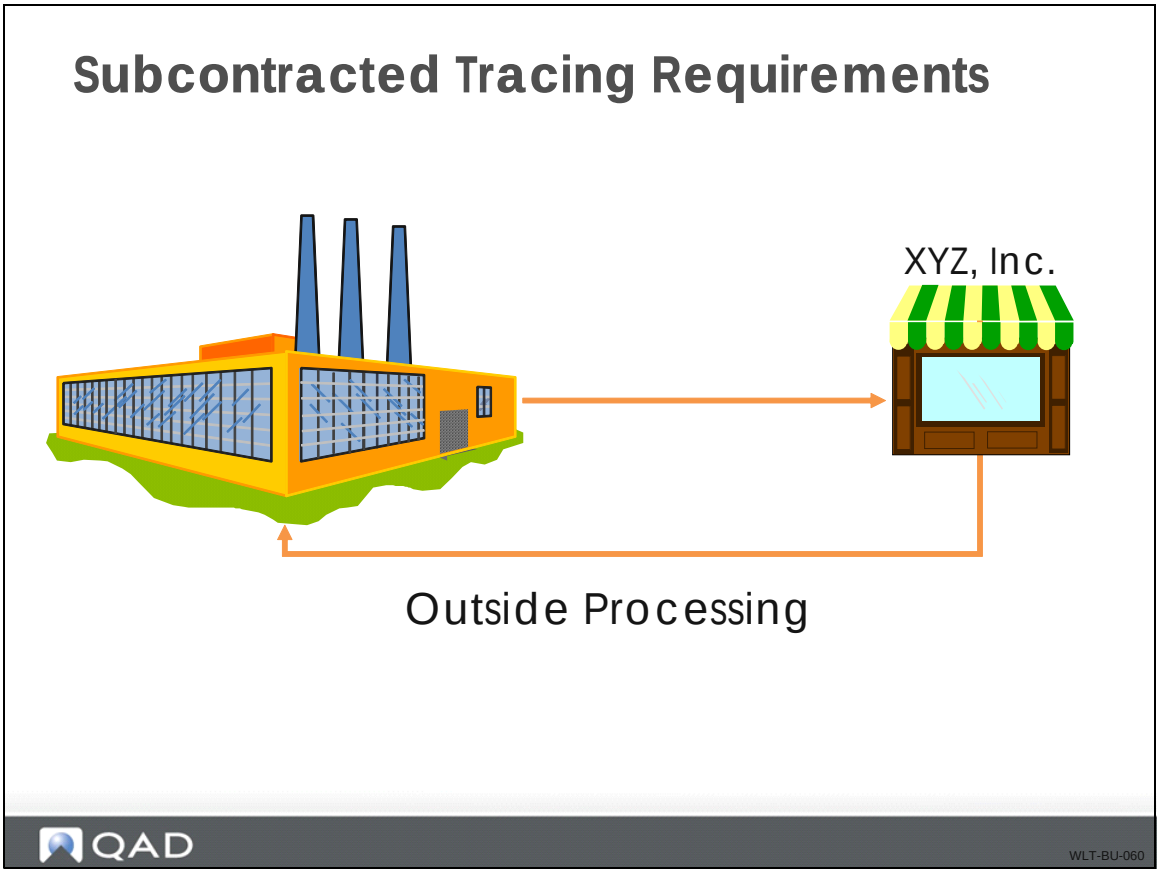


- Trace specific items throughout the manufacturing process
- Trace component and WIP material consumed in the manufacturing of parent items
- Trace component, WIP material, and finished goods based on parent items, product structures, and routings

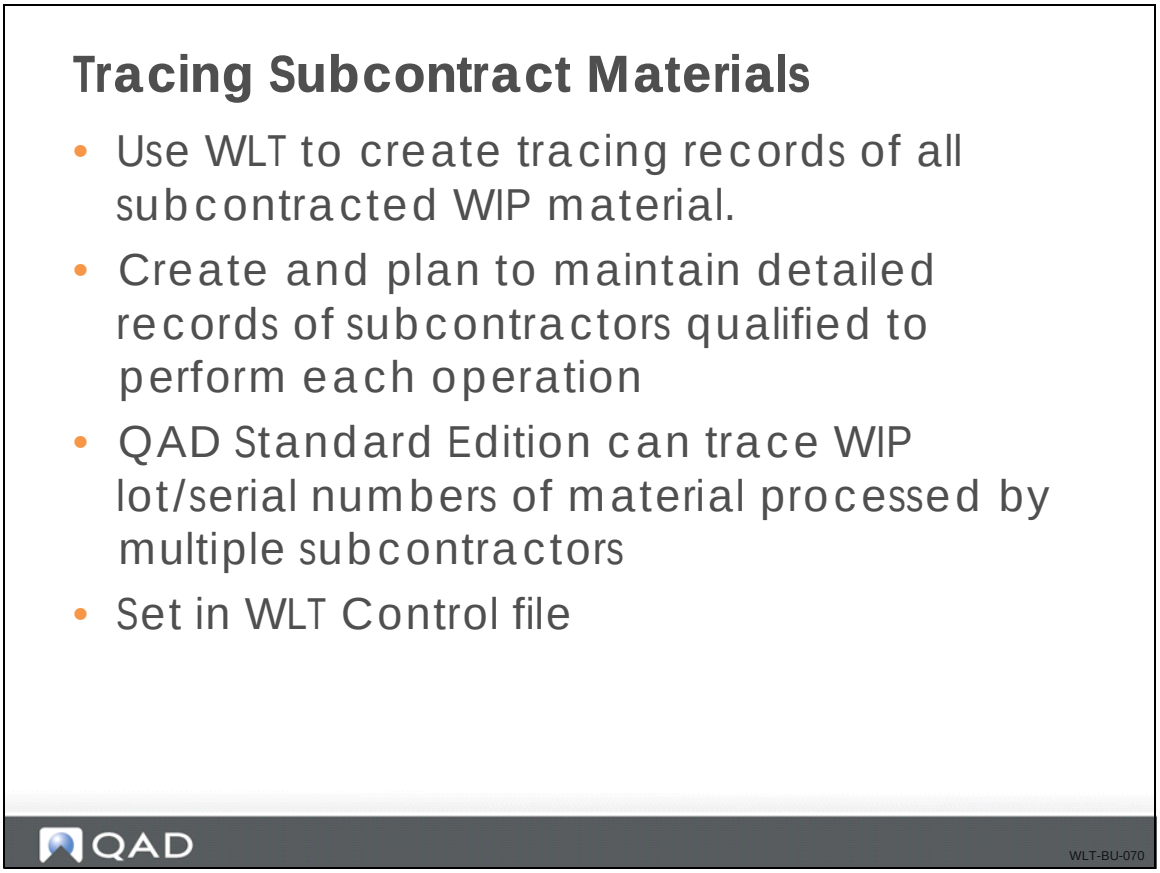
Setup Implications

- WLT functionality needs to be turned on by setting the Enable WIP Lot Trace field to Yes in WIP Lot Trace Control File (3.22.13.24).

Subcontracted Tracing Requirements



Tracing Subcontract Materials



- WLT functionality needs to be turned on by setting the Enable WIP Lot Trace field to Yes in WIP Lot Trace Control File (3.22.13.24).
- Use Work Center Maintenance (14.5) to create a work center for each subcontractor
- Use Routing Maintenance (14.13.1) to create or modify existing routing codes that have subcontracted operations

Business Requirements

Review

Review Questions

1 What kinds of items should be traced? Not traced?

2 How do you identify WIP Lot Trace items on the plant floor?

Chapter 3

Set Up WLT

Course Overview

Set up WLT

In this section you learn how to:

- ✓ Identify key business considerations before setting up WLT in QAD Standard Edition
- **Set up WLT in QAD Standard Edition**
- Process WLT in QAD Standard Edition
- WLT with Work Orders/SFC
- WLT with Advanced Repetitive
- WLT with Repetitive

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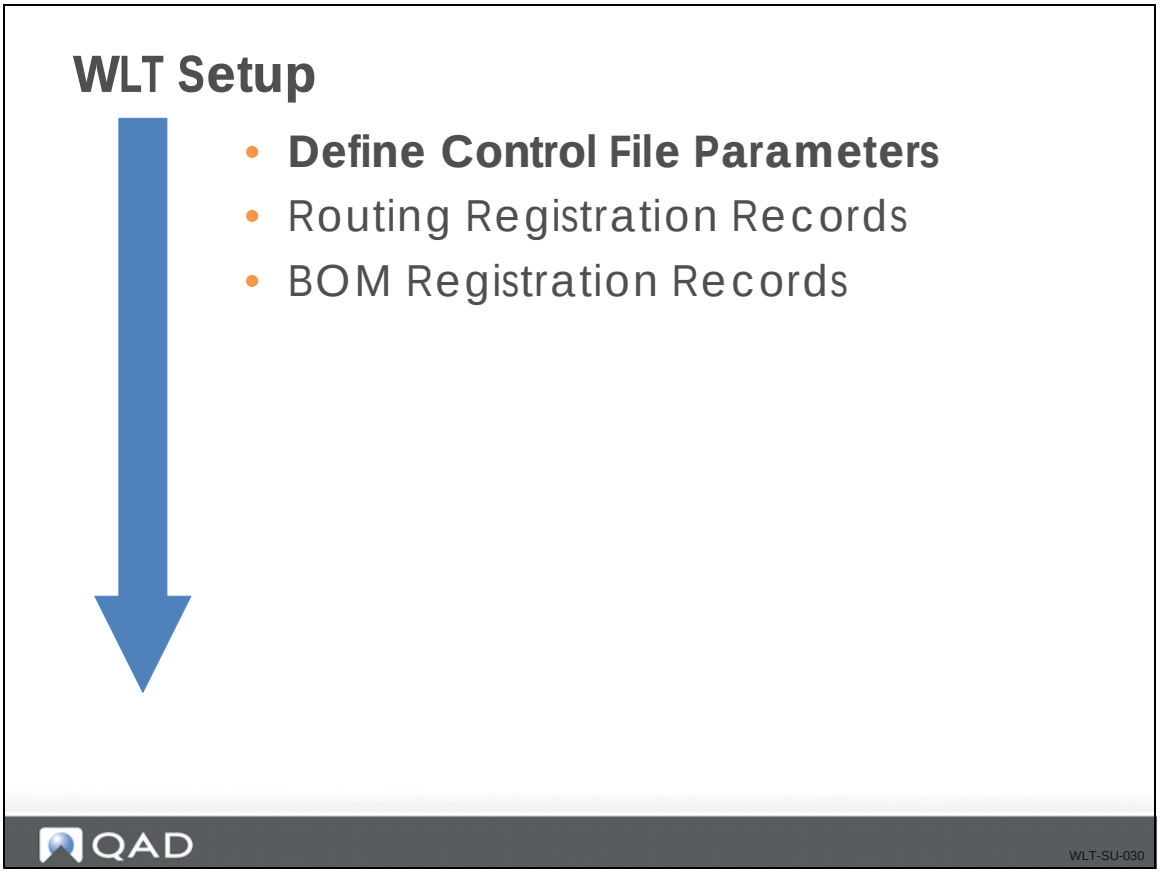
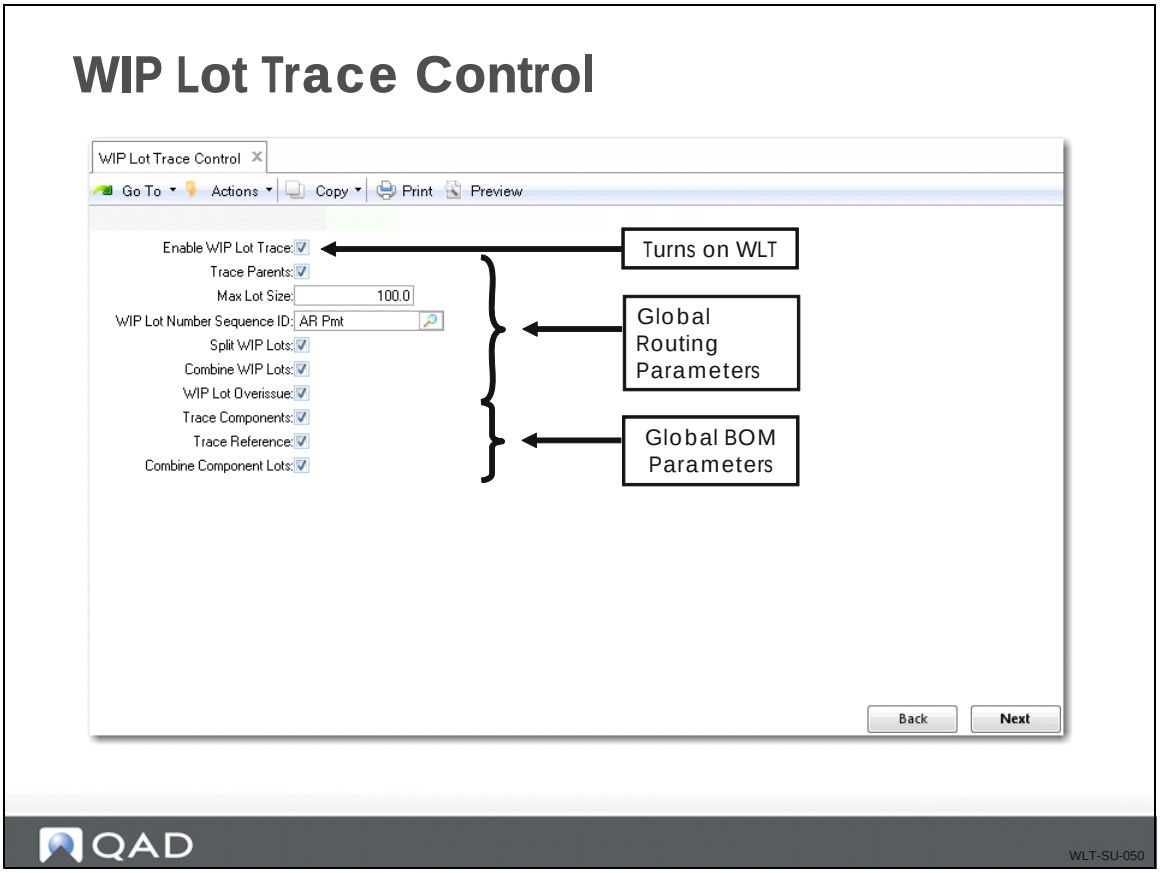
WLT Setup



This illustration is a suggested setup sequence of master files for the WLT module which is based on information that flows from one master file to another and prerequisites that need to be accomplished before setting up a file.

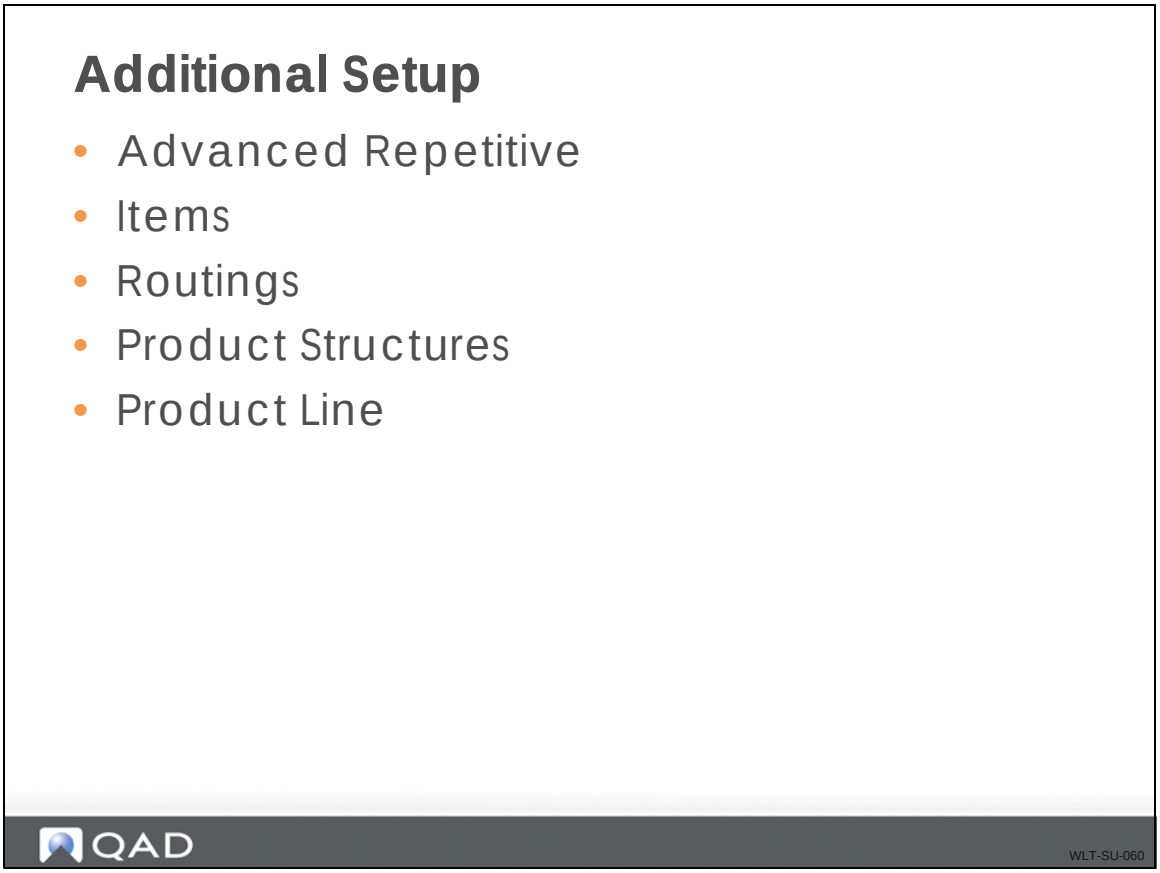
WIP Lot Trace Control



Use WIP Lot Trace Control File to enable the WLT module and to set the parameters which will apply to all routings and BOMs using WLT in your manufacturing environment.

- When WLT is activated, new fields and WLT data collection frames display in programs such as backflush transactions, rework transactions, and reject transactions
  - Use the new fields and WLT data collection frames to enter tracing information
  - Appears in existing (Standard) Repetitive, Advanced Repetitive, Work Orders, Shop Floor Control, and Purchasing programs

Additional Setup



Exercise: Set Up WIP Lot Trace

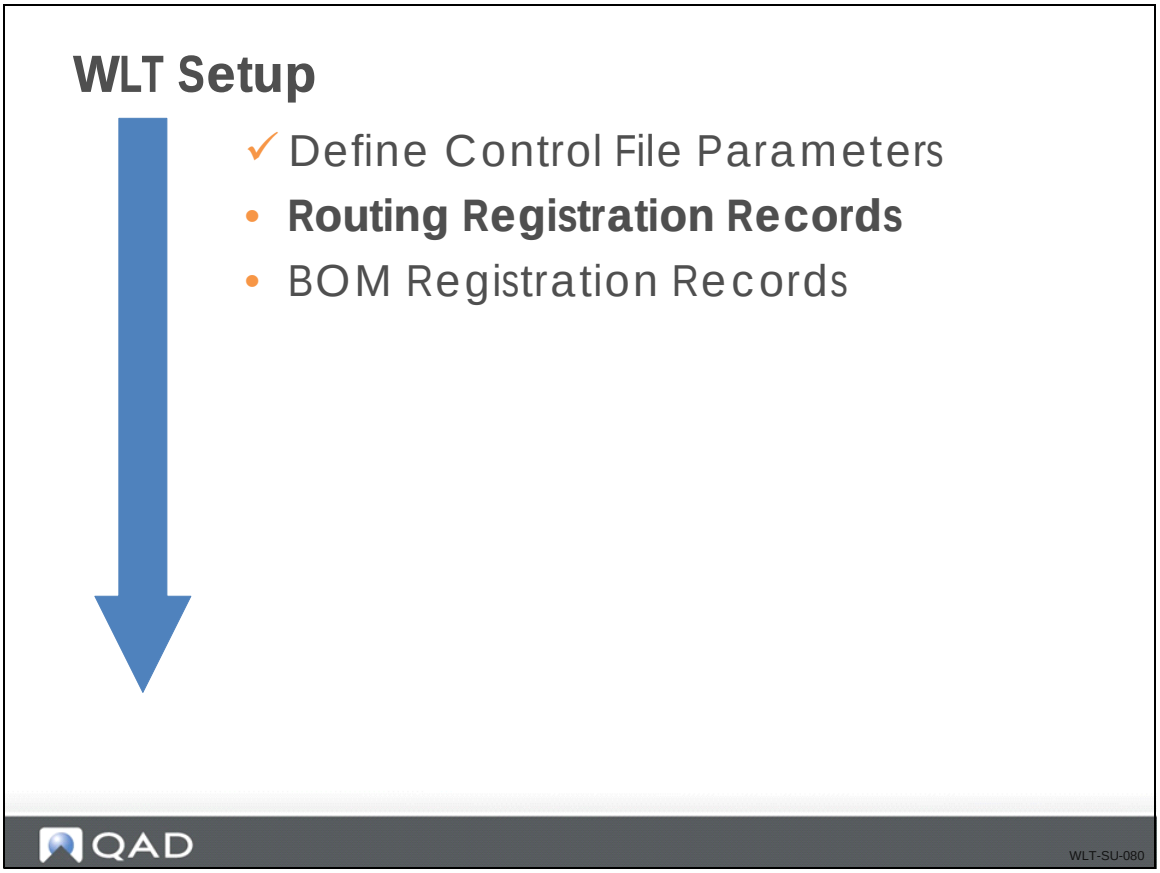
QMI produces medical ultrasound equipment at site 10-100 and needs to perform WIP lot trace on the 10MHz probe assembly (50001) as well as its sub-components throughout the production process.

1. Use Product Strucuture by Item Report (13.8.1) to view the product structures of item 01010 and item 50001.
2. Use Routing Inquiry (14.13.3) to view routing U-001 and routing P-001 for medical ultrasound (01010) and 10MHz probe assembly (50001) respectively.
3. Use WIP Lot Trace Control (3.22.13.24) to configure global settings for WIP Lot Trace. Since we do not want to trace all parent and component items, set Trace Parents and Trace Components to No.

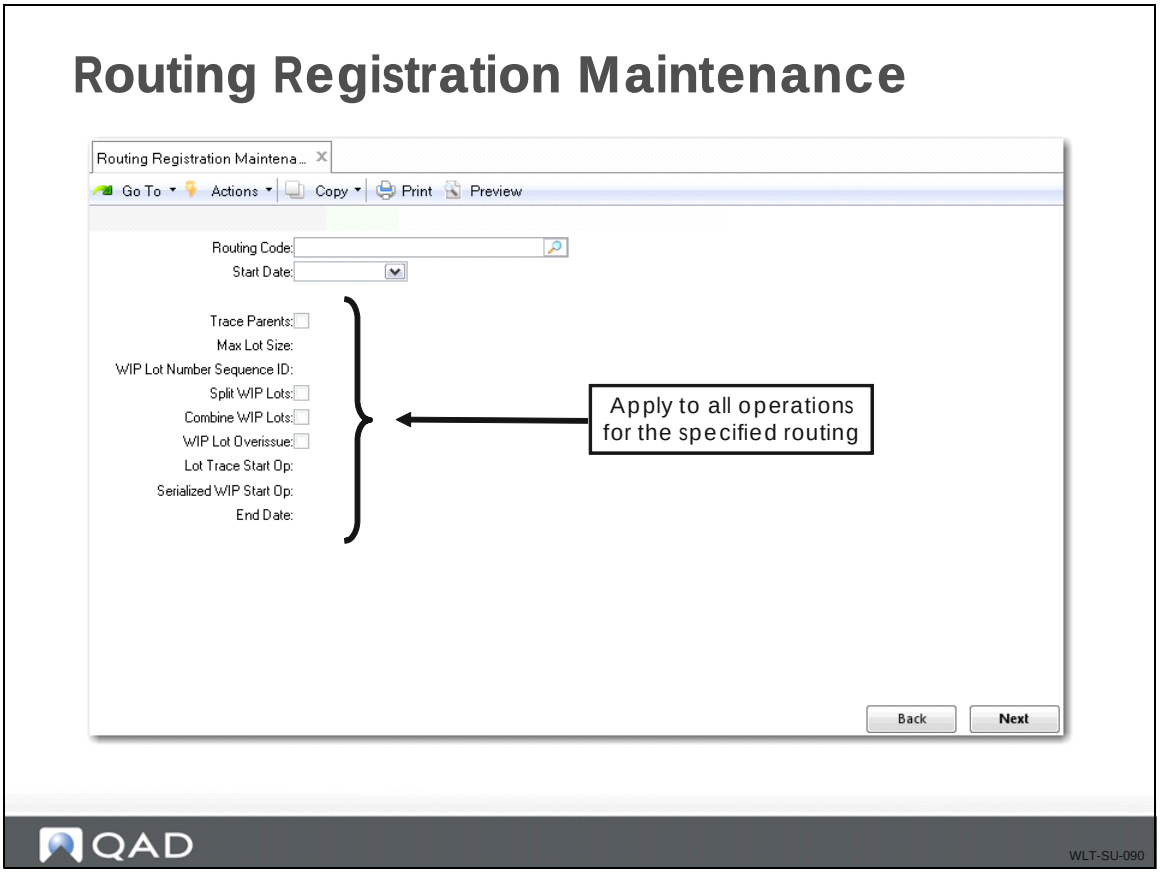
Field	Data
Enable WIP Lot Trace	Yes
Trace Parents	No
Split WIP Lots	Yes
Combine WIP Lots	Yes
WIP Lot Overissue	Yes
Trace Components	No
Trace Reference	Yes
Combine Component Lots	Yes

4. Use Routing Registration Maintenance (3.22.13.1) to set up WIP lot trace for routing P-001. Set Trace Parents to Yes.
5. Use BOM Registration Maintenance (3.22.13.4) to set up WIP lot trace for BOM code 50001. Set Trace Components to Yes.

Routing Registration Records



Routing Registration Maintenance

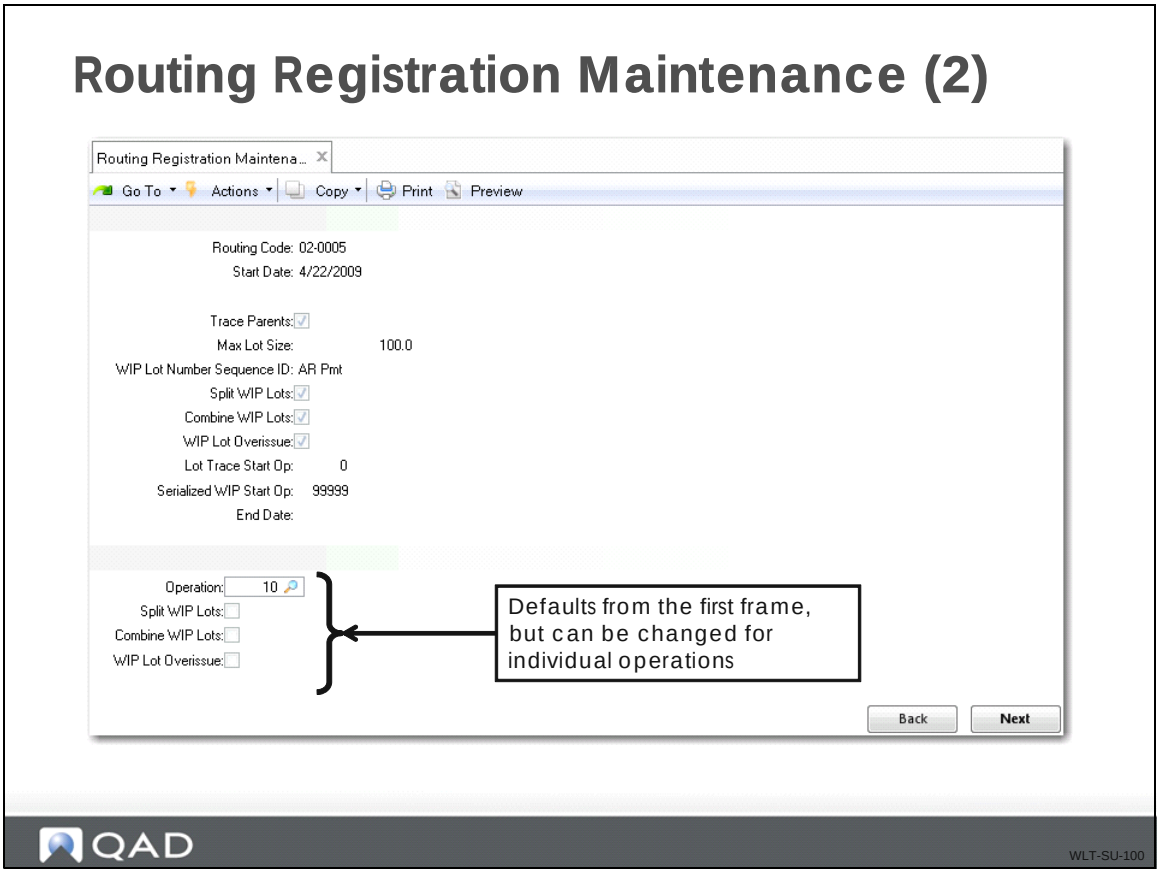


Use Routing Registration Maintenance to define control parameter exceptions for an individual routing code. You do this by creating new settings for parent item routings. Additionally, you can define settings for individual routing operations.

- Settings defined here override WIP Lot Trace Control File settings

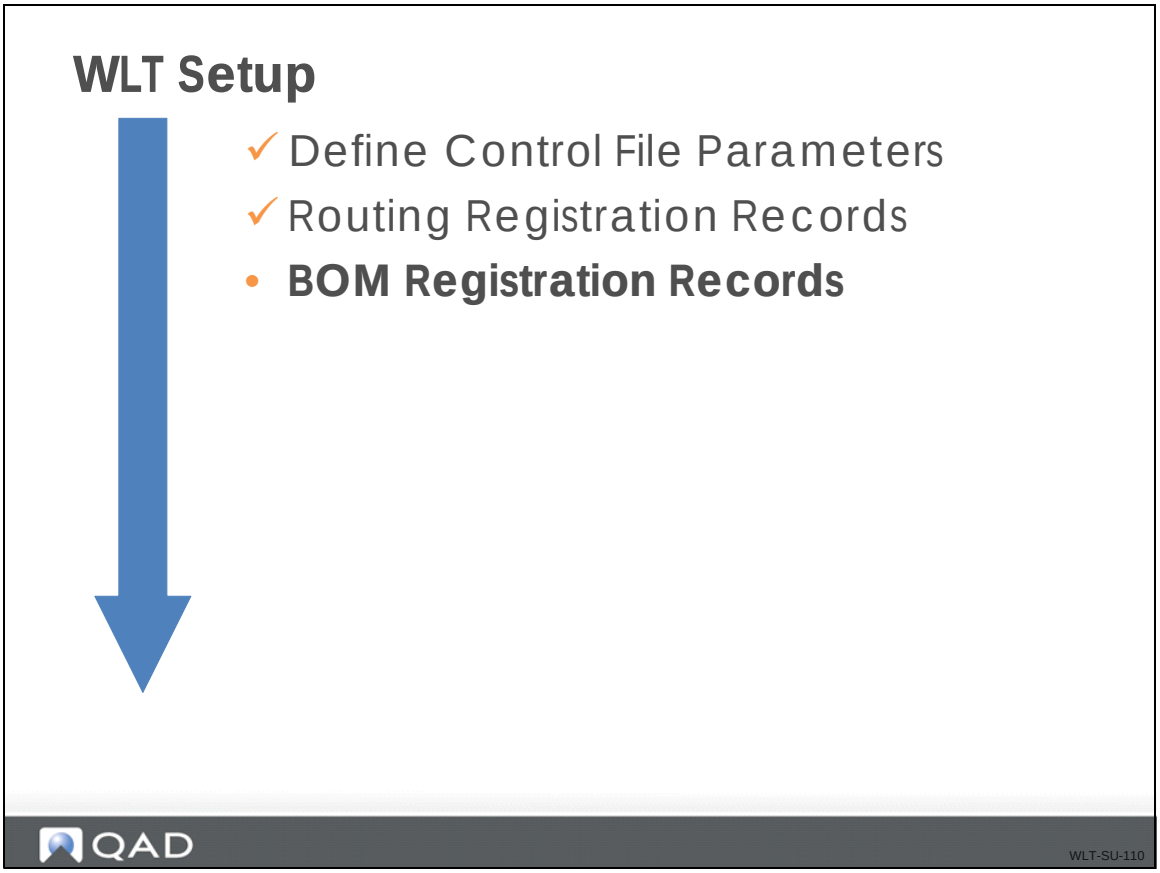
Routing Registration Maintenance consists of two frames. In the first frame you enter control information for the routing code. These settings will be used for all operations of the specified routing. However, you can use the second frame to enter control information specific to an operation within the routing. This information overrides the global routing information entered in the first frame.

Routing Registration Maintenance - Second Frame

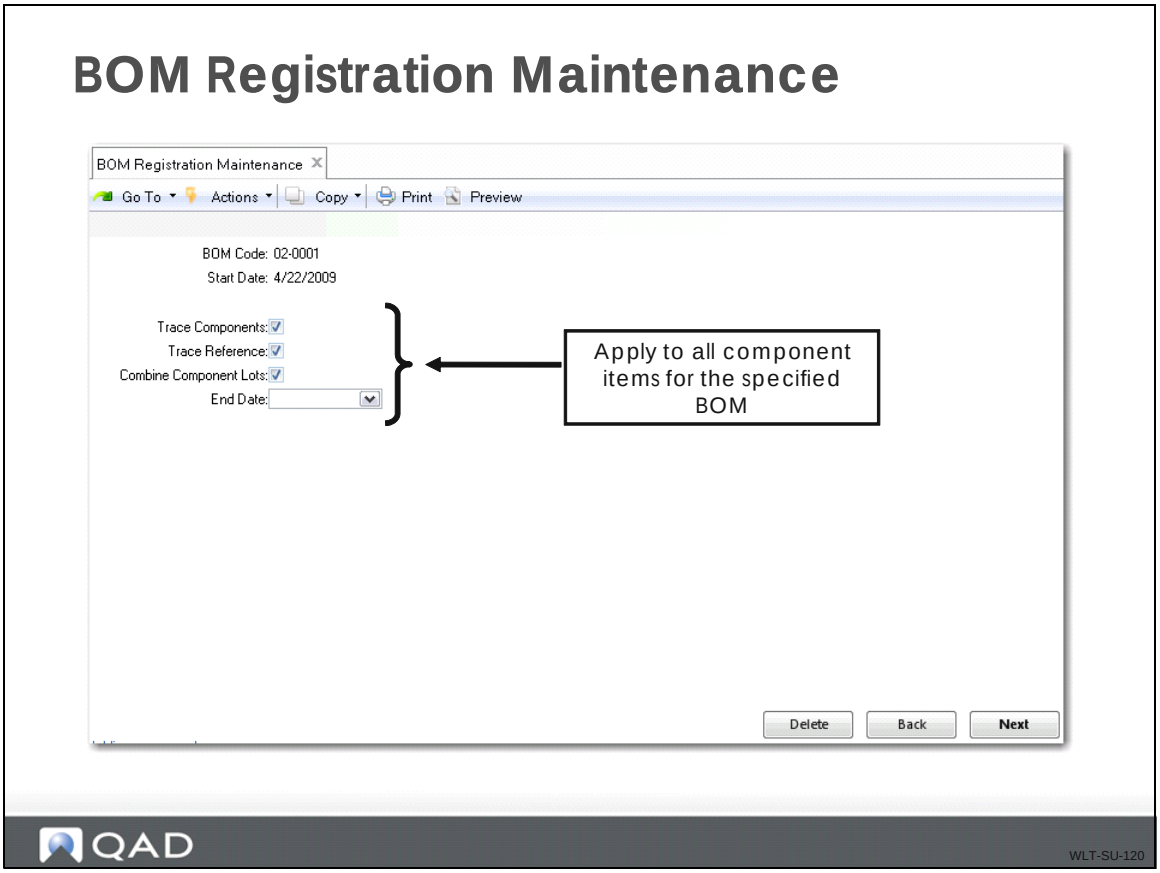


You can use the fields in the second frame to further define whether to allow lot splitting, combining, and overissuing for a specific operation in the routing.

BOM Registration Records



BOM Registration Maintenance

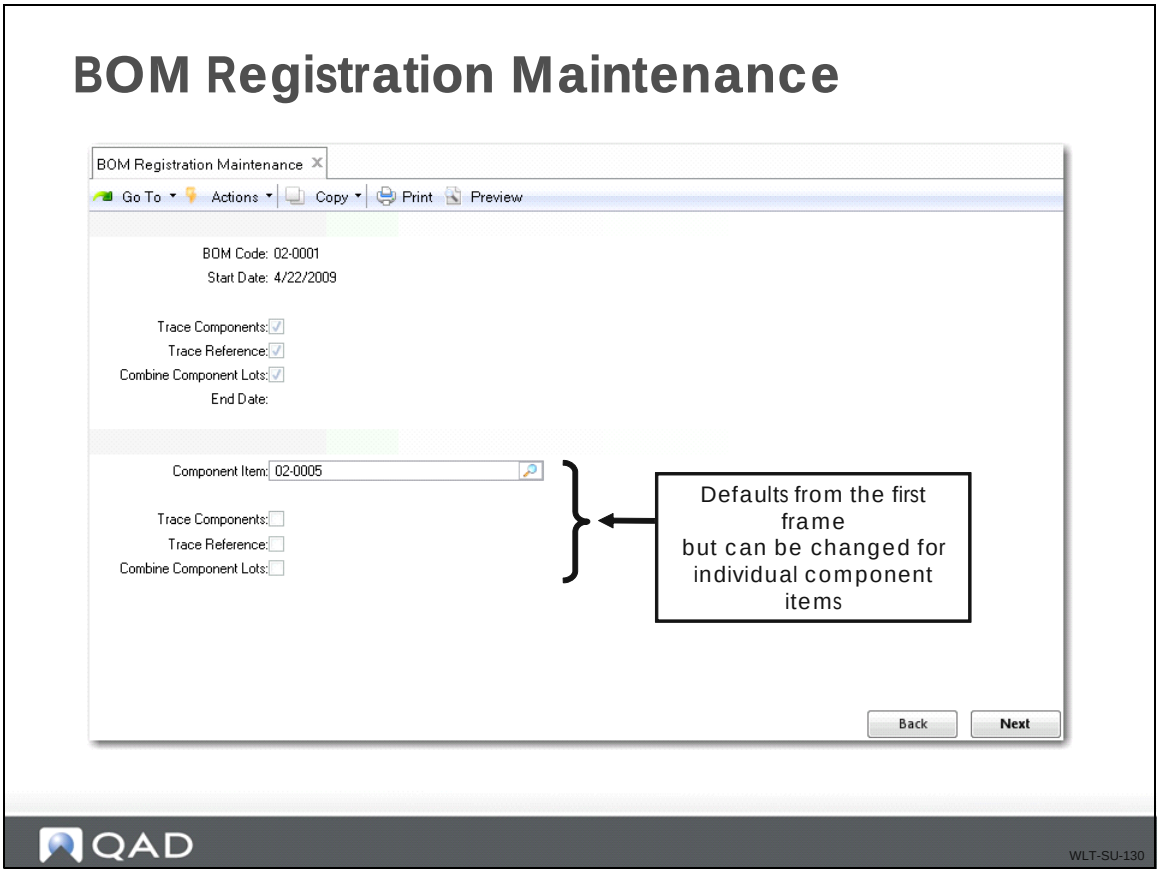


Use BOM Registration Maintenance to define control parameter exceptions for an individual BOM. You can also define settings for individual BOM component items.

- Settings defined here override WIP Lot Trace Control File settings

BOM Registration Maintenance consists of two frames. In the first frame you enter control information for the BOM. These settings will be used for all component items for the specific BOM code. However, you can use the second frame to enter control information for a component of the BOM.

BOM Registration Maintenance - Second Frame



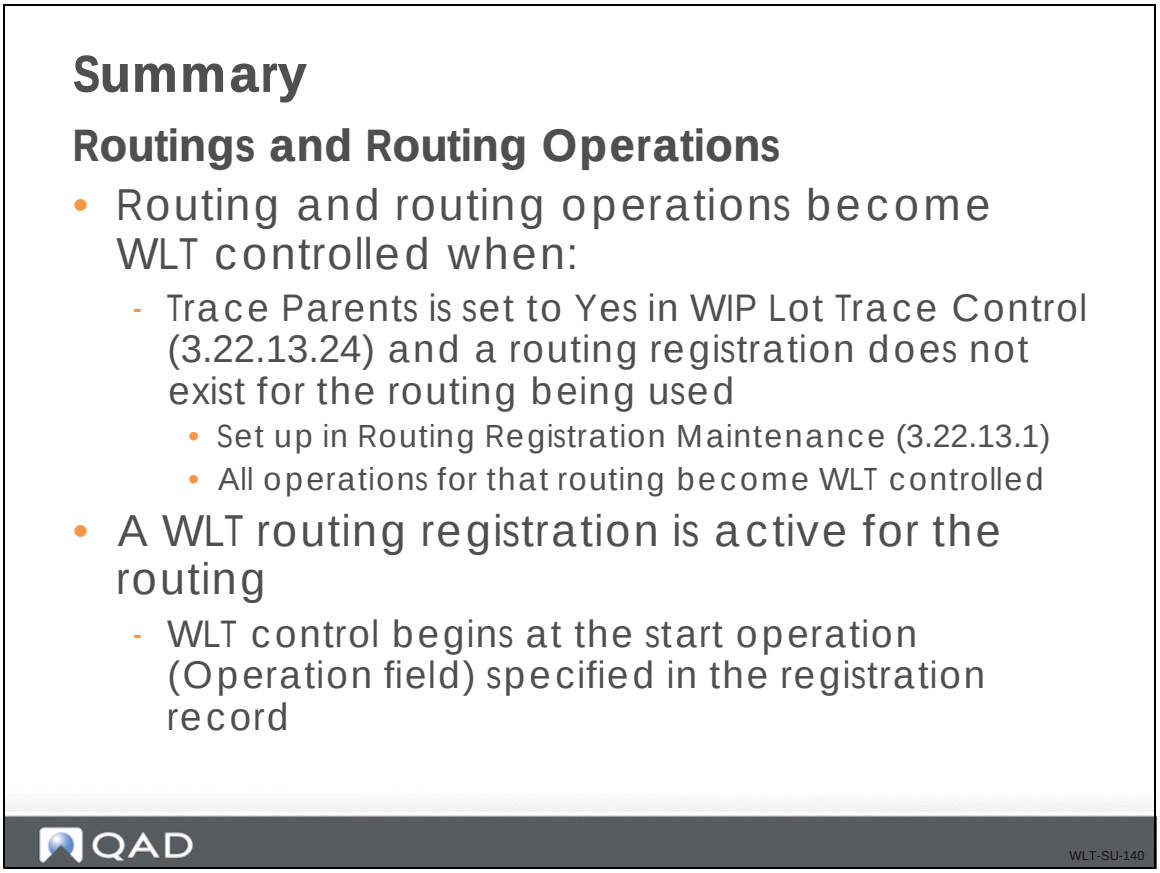
In the second frame you can override the BOM registration controls for a specific component item.

- Changes you make here override the controls set in the first frame for this component in this BOM code only

You also have the option of further defining whether to:

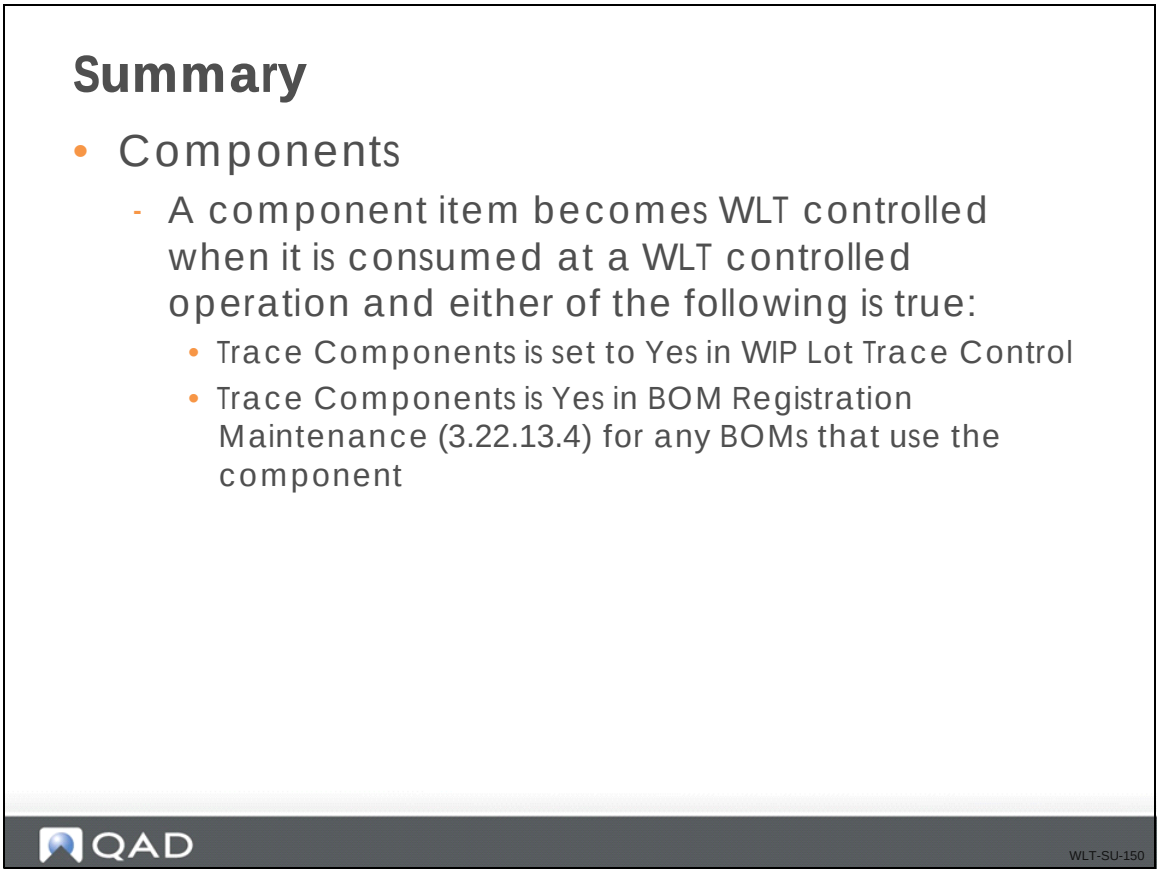
- Trace components or references
- Allow combining of component lots for specific component in the BOM

Summary - Routings and Routing Operations



For our activity we will not setup any exceptions to the WIP Lot Trace rules set in the control file.

Summary - Components



Chapter 4

Process WLT

Course Overview

Process WLT

In this section you learn how to:

- ✓ Identify key business considerations before setting up WLT in QAD Standard Edition
- ✓ Set up WLT in QAD Standard Edition
- **Process WLT in QAD Standard Edition**
- WLT with Work Orders/SFC
- WLT with Advanced Repetitive
- WLT with Repetitive

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Processing Tips

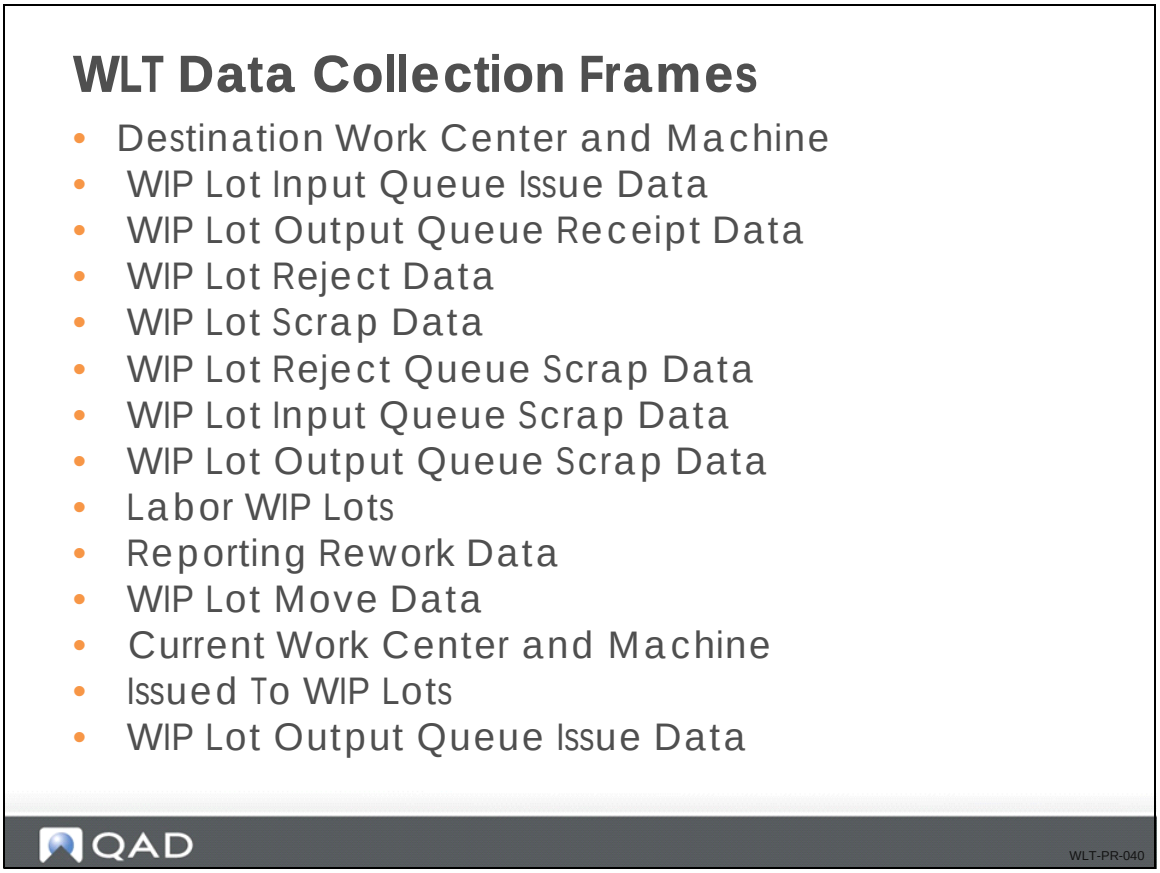
Processing Tips

- WIP material cannot be traced at non-milestone operations
- WIP lot/serial balances can reside only at milestone operations
- Some normally editable fields are not editable
  - WLT data collection frames are used to record the information
- WIP QOH balances cannot reside in the input queue of the first milestone operation, even if the first milestone operation is not the first operation
- Any information entered in WLT data collection frames is used to update QOH balances and WLT history records
- Before processing any WLT modified transactions, the system checks for associated WLT routing or BOM registrations that include lot splitting, combining, and size restrictions
  - If there are none, the system then looks for related restrictions in the WIP Lot Trace Control File (3.22.13.24)

QAD

WLT-PR-030

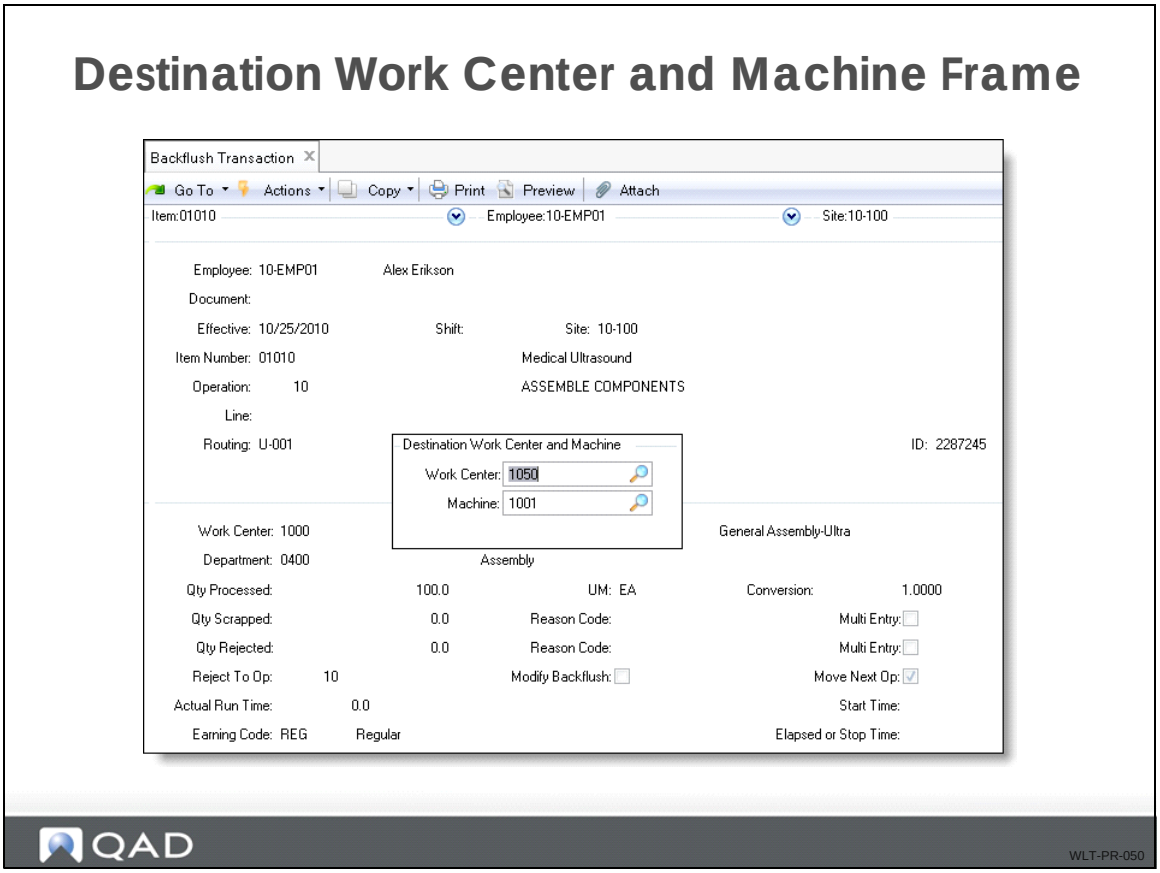
WLT Data Collection Frames



During processing, the system uses WLT data collection frames to collect, record, and update tracing records. Depending on how you have set up your tracing control parameters, these frames appear in various programs in the following modules:

- Repetitive
- Advance Repetitive
- Work Orders
- Shop Floor Control
- Purchasing

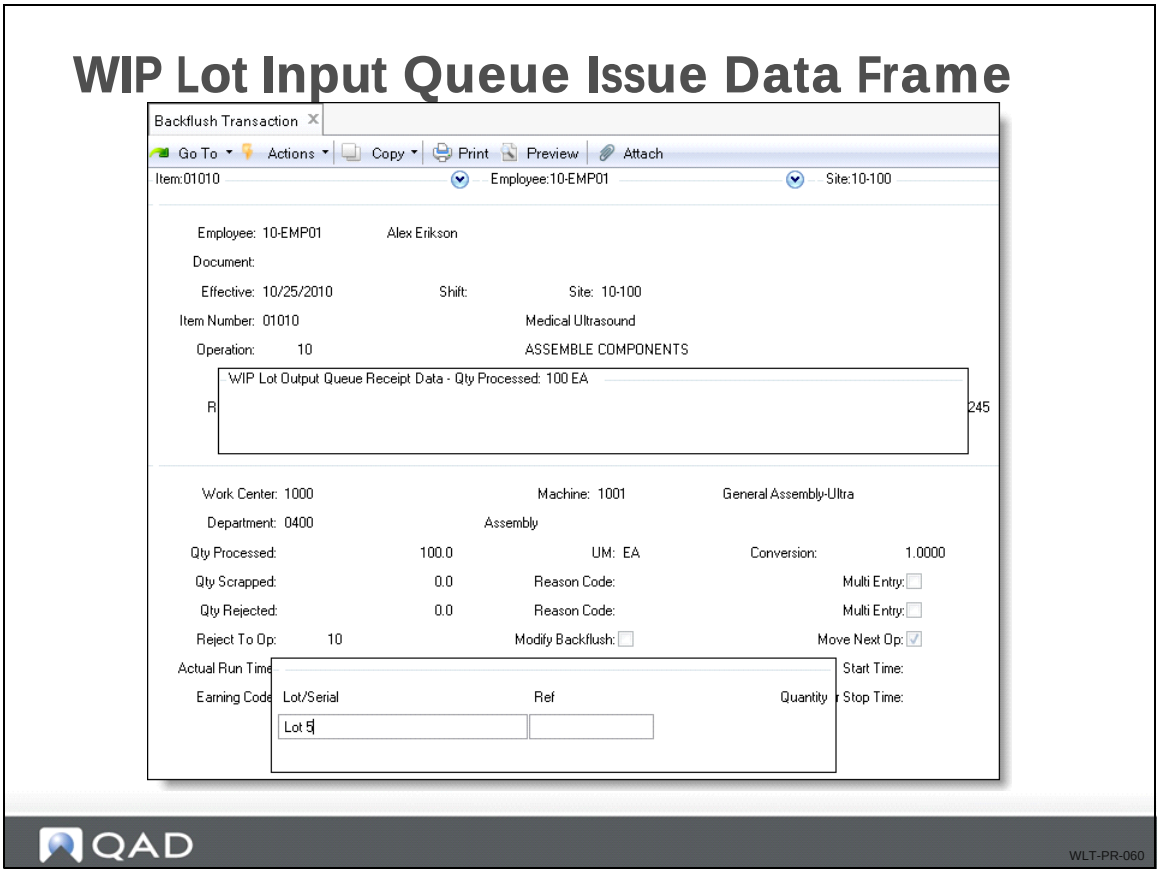
Destination Work Center and Machine Frame



Use the Destination Work Center and Machine frame to specify where to move the WIP material produced at the current operation.

- System uses the information to update QOH balances for the affected queues
- Appears in:
  - Labor Feedback by Work Order (17.1)
  - Labor Feedback by Employee (17.2)
  - Labor Feedback by Work Center (17.3)
  - Work Order Operation Backflush (16.19)
  - Repetitive Labor Transaction (18.14)
  - Repetitive Rework Transaction (18.16)
  - Backflush Transaction (18.22.13)
  - Reject Transaction (18.22.16)
  - Rework Transaction (18.22.17)
  - Move Transaction (18.22.19)

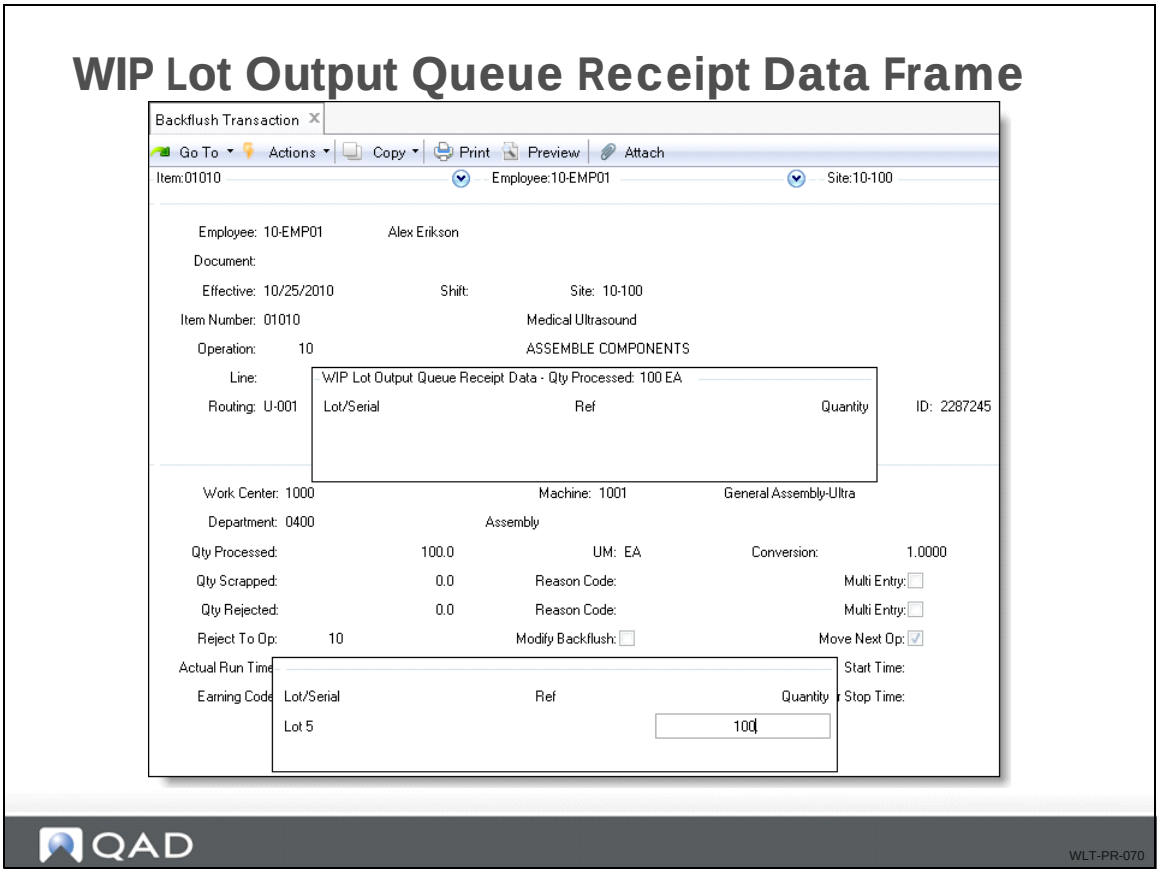
WIP Lot Input Queue Issue Data Frame



Use the WIP Lot Input Queue Issue Data frame to register the lot/serial numbers, references, and quantities of the WIP material being consumed at the current operation.

- Displays when the previous operation's output queue and the current operation's input queue are WLT controlled
- Appears in:
  - Purchase Order Receipts (5.13.1)
  - Purchase Order Returns (5.13.7)
  - Work Order Component Issue (16.10)
  - Work Order Operation Backflush (16.19)
  - Repetitive Labor Transaction (18.14)
  - Repetitive Reject Transaction (18.17)
  - Backflush Transaction (18.22.13)

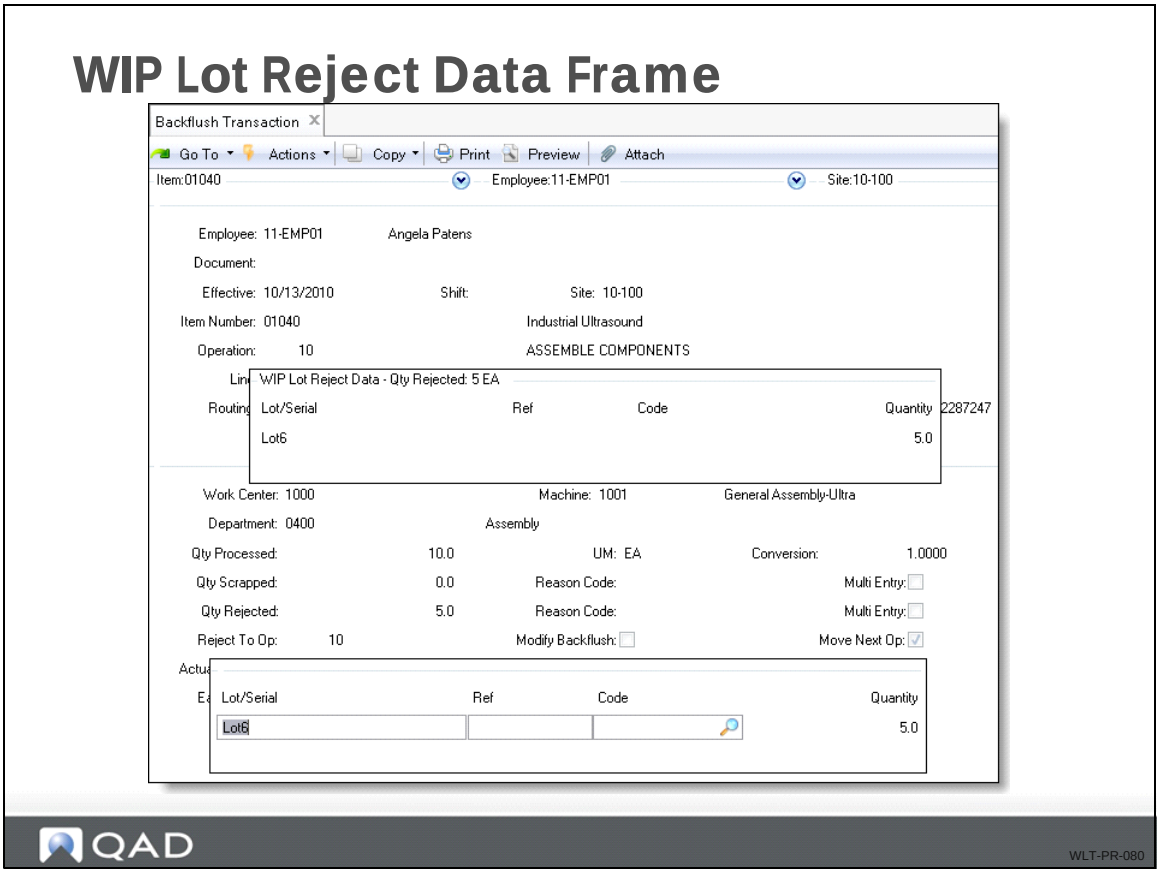
WIP Lot Output Queue Receipt Data Frame



Use the WIP Lot Output Queue Receipt Data frame to report the WIP lot/serial numbers, references, and quantities of the WIP material produced by an operation.

- Appears in:
  - Purchase Order Receipts (5.13.1)
  - Purchase Order Returns (5.13.7)
  - Work Order Operation Backflush (16.19)
  - Labor Feedback by Work Order (17.1)
  - Labor Feedback by Employee (17.2)
  - Labor Feedback by Work Center (17.3)
  - Repetitive Labor Transaction (18.14)
  - Backflush Transaction (18.22.13)

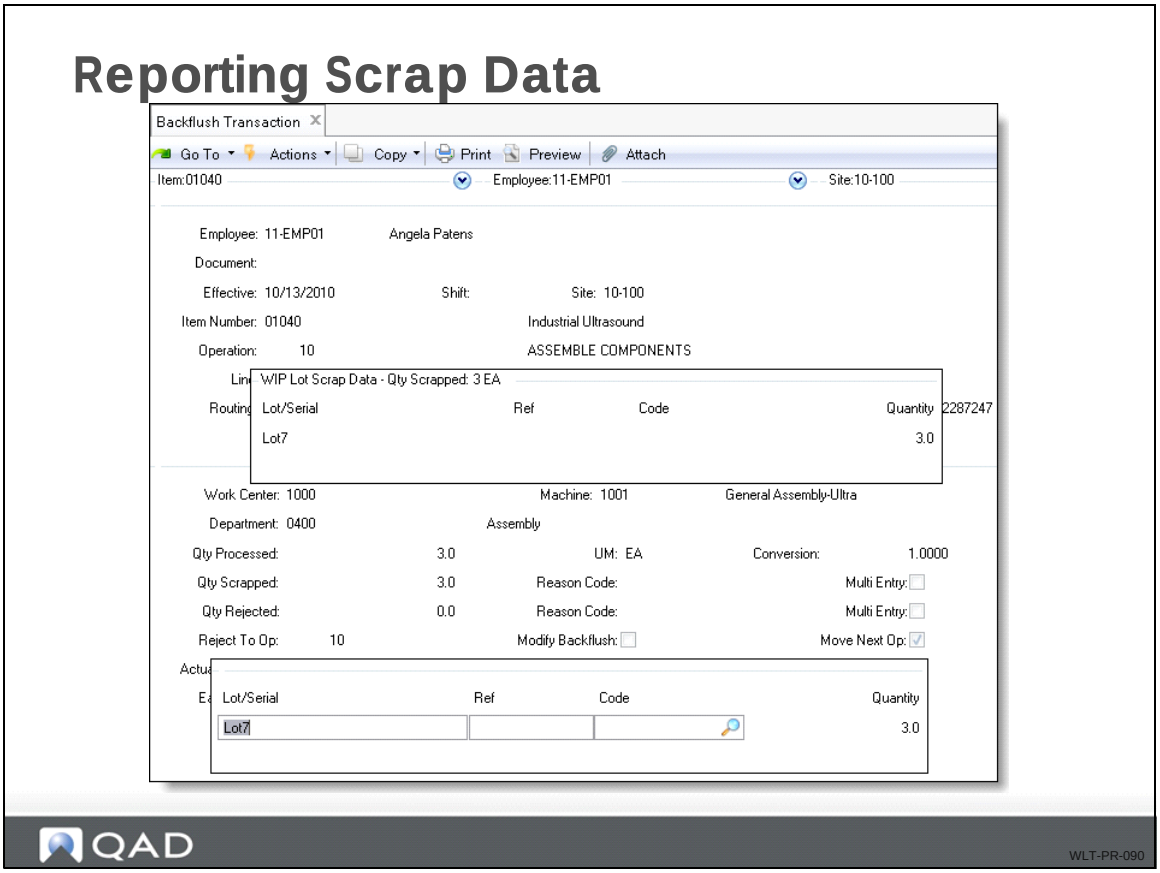
WIP Lot Reject Data Frame



Use the WIP Lot Reject Data frame to report the WIP lot/serial numbers, references, reject codes, and quantities of rejected material.

- Quantity is moved from the operation's output queue to the reject queue
- Appears in:
  - Repetitive Labor Transaction (18.14)
  - Repetitive Reject Transaction (18.17)
  - Backflush Transaction (18.22.13)
  - Reject Transaction (18.22.16)

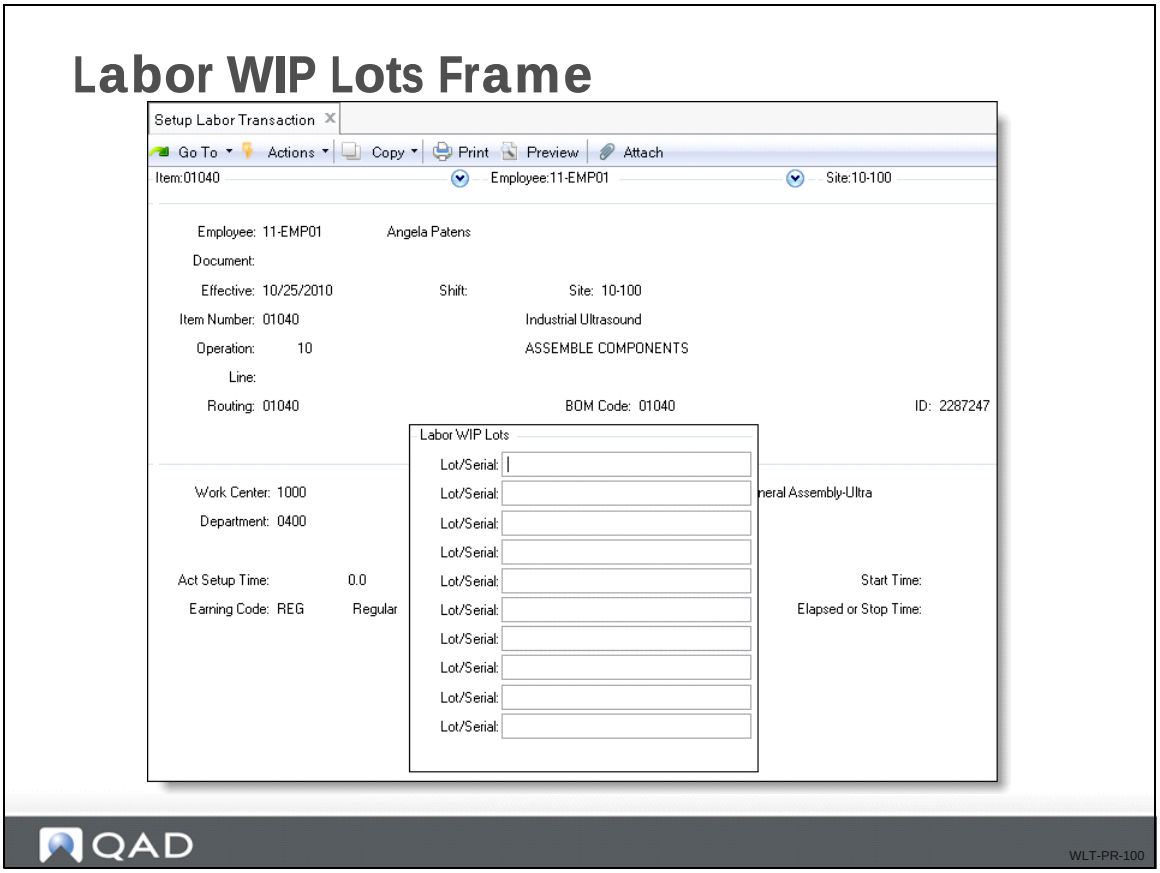
Reporting Scrap Data



There are four different WLT frames that can be used to record WLT controlled material being scrapped from an operation's input, output, or reject queues. Each frame records lot/serial numbers, references, scrap codes, and quantities being scrapped.

- WIP Lot Scrap Data Frame appears in:
  - Repetitive Labor Transaction (18.14)
  - Backflush Transaction (18.22.13)
- WIP Lot Reject Queue Scrap Data Frame appears in:
  - Repetitive Scrap Transaction (18.18)
  - Scrap Transaction (18.22.18)
- WIP Lot Input Queue Scrap Data Frame appears in:
  - Operation Scrap Transaction (17.7)
  - Repetitive Labor Transaction (18.14)
  - Backflush Transaction (18.22.13)
  - Repetitive Scrap Transaction (18.22.18)
- WIP Lot Output Queue Scrap Data Frame appears in:
  - Operation Scrap Transaction (17.7)
  - Repetitive Scrap Transaction (18.22.18)

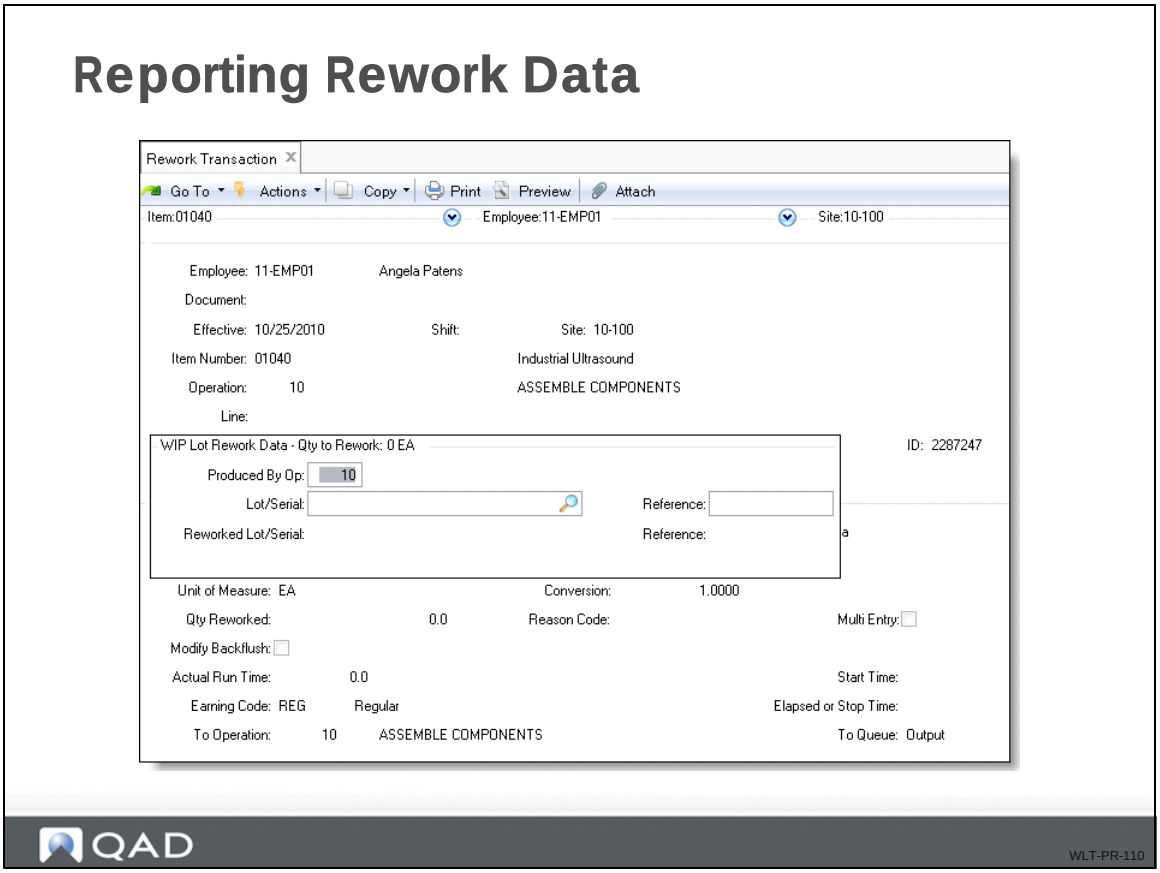
Labor WIP Lots Frame



Use the Labor WIP Lots frame to associate run and set up labor time with corresponding lot/serial numbers. When the output queue of the operation being processed is WLT controlled, the Labor WIP Lots frame appears in:

- Repetitive Setup Transaction (18.13)
- Run Labor Transaction (18.22.14)
- Setup Labor Transaction (18.22.15)

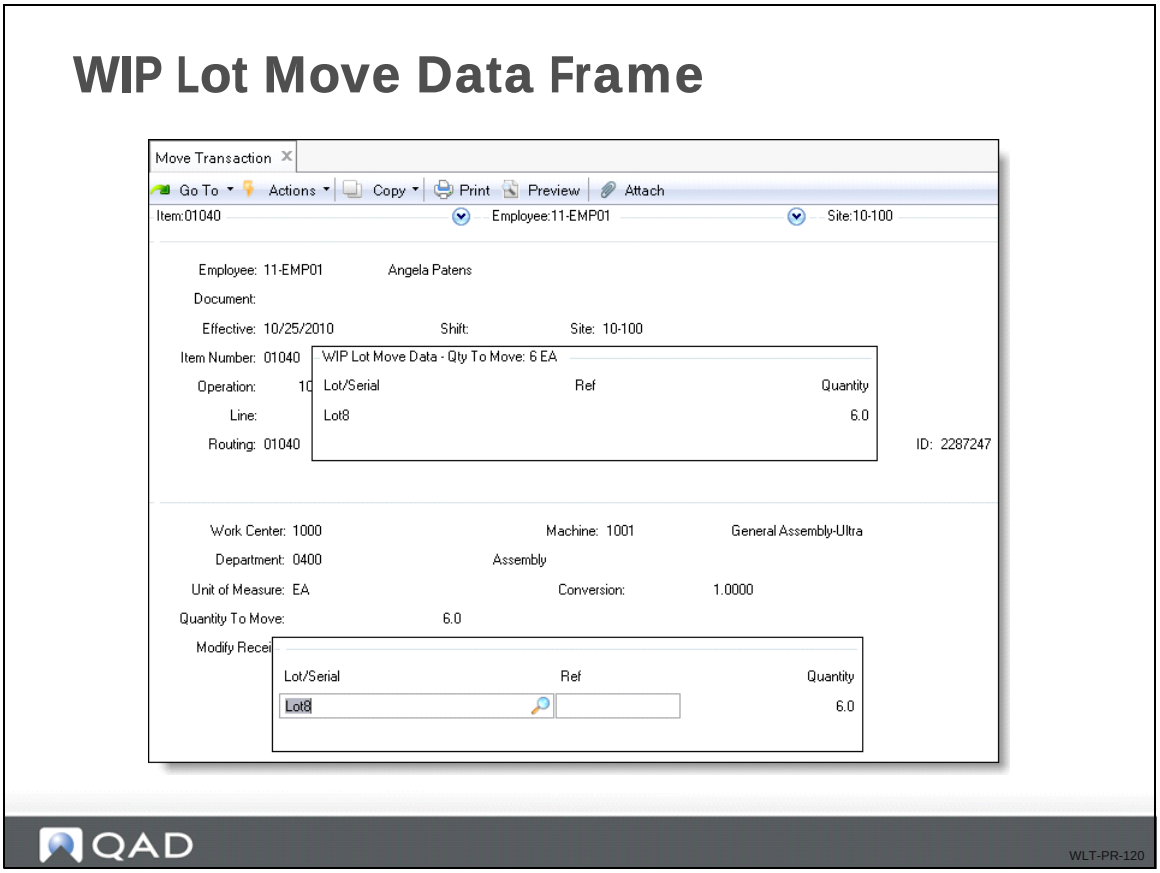
Recording Rework Data



Use the WIP Lot Rework Data frame to specify the WIP lot/serial numbers and references that were reworked.

- Can also be used to assign new WIP lot/serial numbers and references to WIP material
- Appears in:
  - Repetitive Rework Transaction (18.16)
  - Rework Transaction (18.22.17)

WIP Lot Move Data Frame

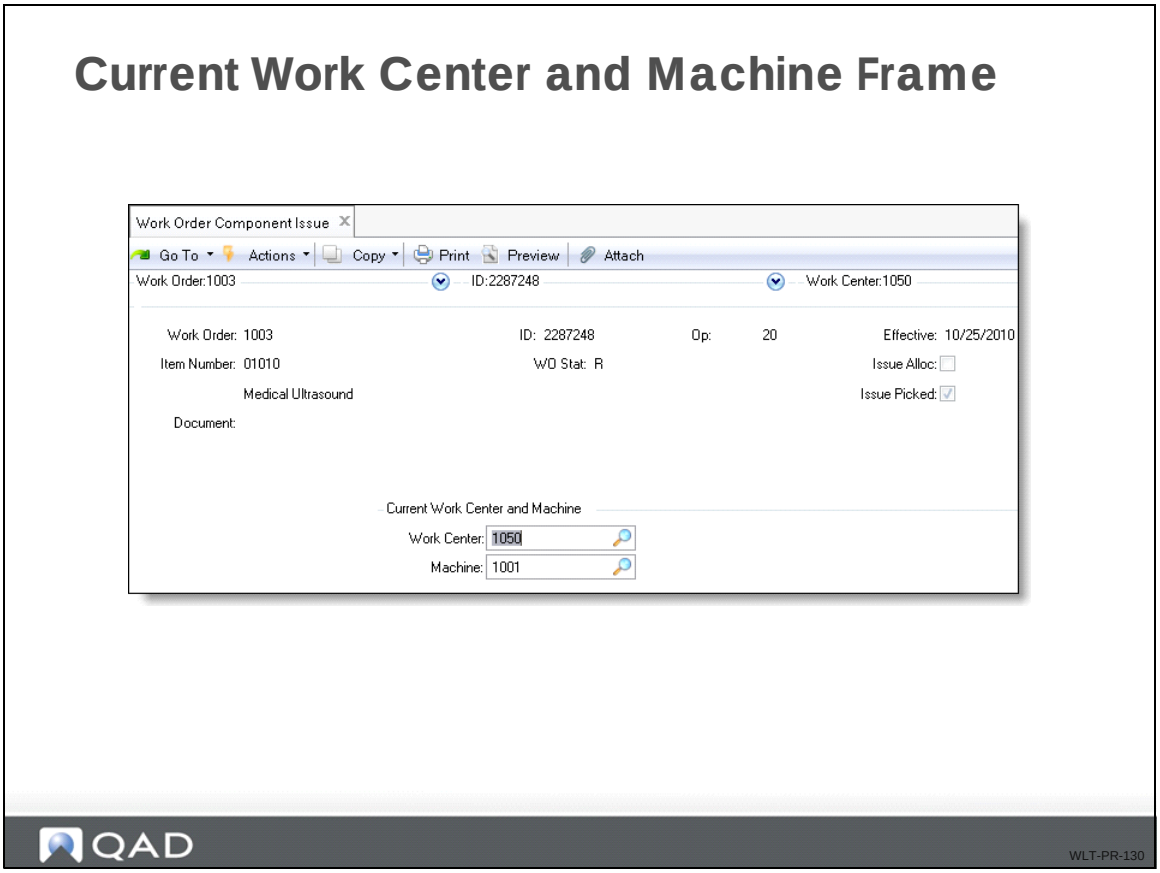


Use the WIP Lot Move Data frame to record the WIP lot/serial numbers, references, and quantities of material being moved.

- Appears in:
  - Operation Move Transaction (17.6)
  - Move Transaction (18.22.19)
  - Sub Container Maintenance (18.22.5.4)
  - Sub Shipper Maintenance (18.22.5.5)

Note This frame does not appear if you are moving WIP quantities to finished goods inventory. The Receipt Data Input frame appears for receipt of finished goods into inventory.

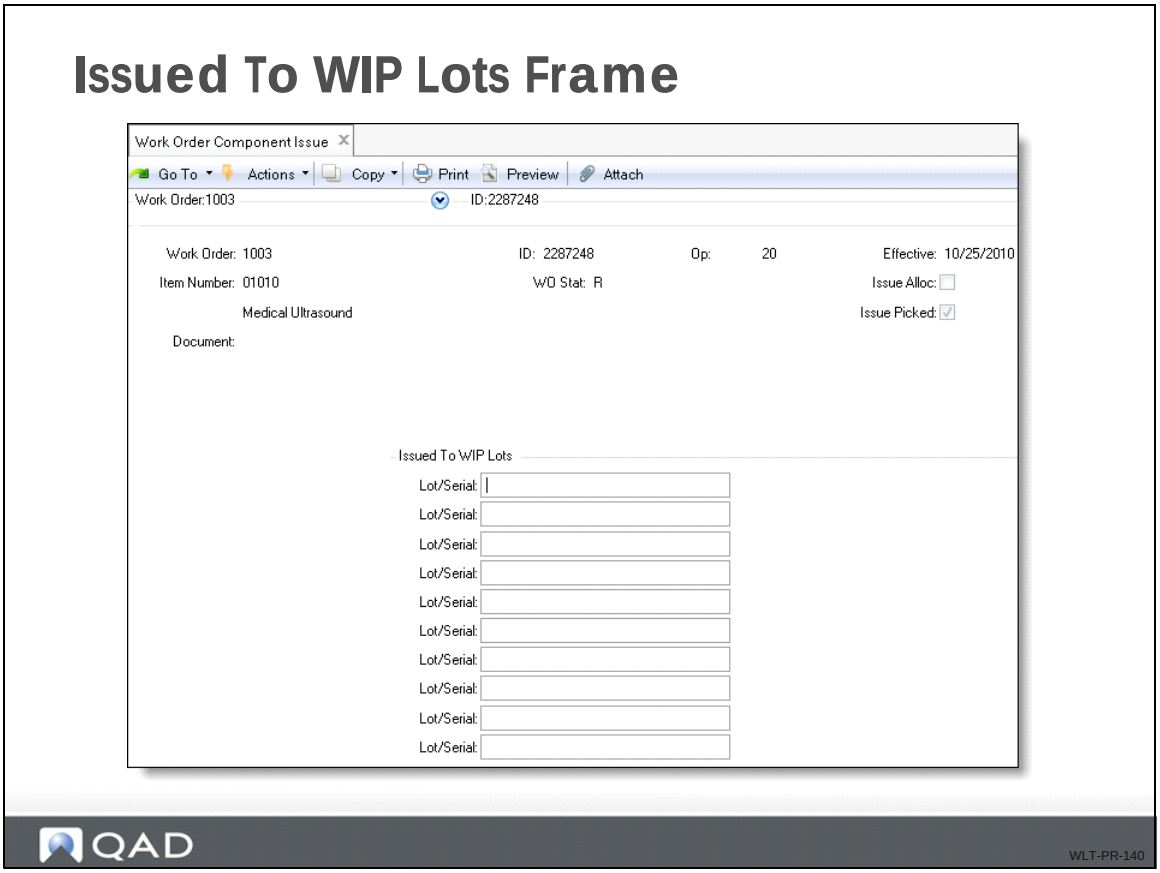
Current Work Center and Machine Frame



Use the Current Work Center and Machine frame to specify the work center and machine location from where the input WIP lot/serial inventory will be consumed by the operation.

- Appears in:
  - Work Order Component Issue (16.10)
  - Work Order Receipt (16.11)

Issued to WIP Lots Frame

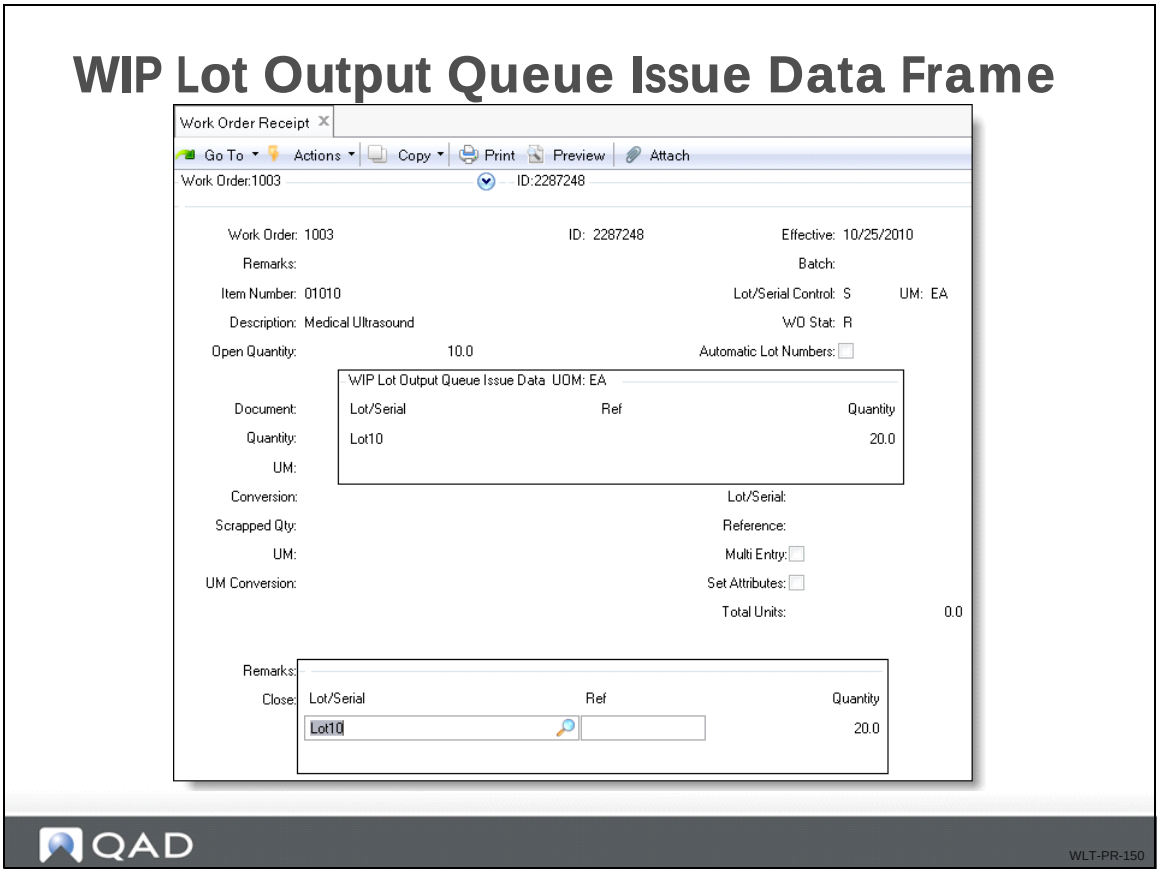


Use the Issued To WIP Lots frame to specify the produced WIP lot/serial numbers to which the specified components and WIP material are being issued.

Note The WIP material to be issued is specified in the WIP Lot Input Queue Issue Data frame that appears immediately before this frame.

- Appears in:
  - Work Order Component Issue (16.10)

WIP Lot Output Queue Issue Data Frame



Use the WIP Lot Output Queue Issue Data frame to enter a list of the WIP lot/serial numbers that should be consumed from the pervious operation's output queue in the specified work center and machine.

- Appears in:
  - Work Order Receipt (16.11)

Review Questions

1 What causes the WIP Lot data entry frames to display?

2 Can you reject partial lots using WIP Lot Trace? (Y/N)

3 Can you move WIP Lots into finished goods inventory? (Y/N)

Chapter 5

WLT with Work Orders/SFC

Course Overview

WLT with Work Orders

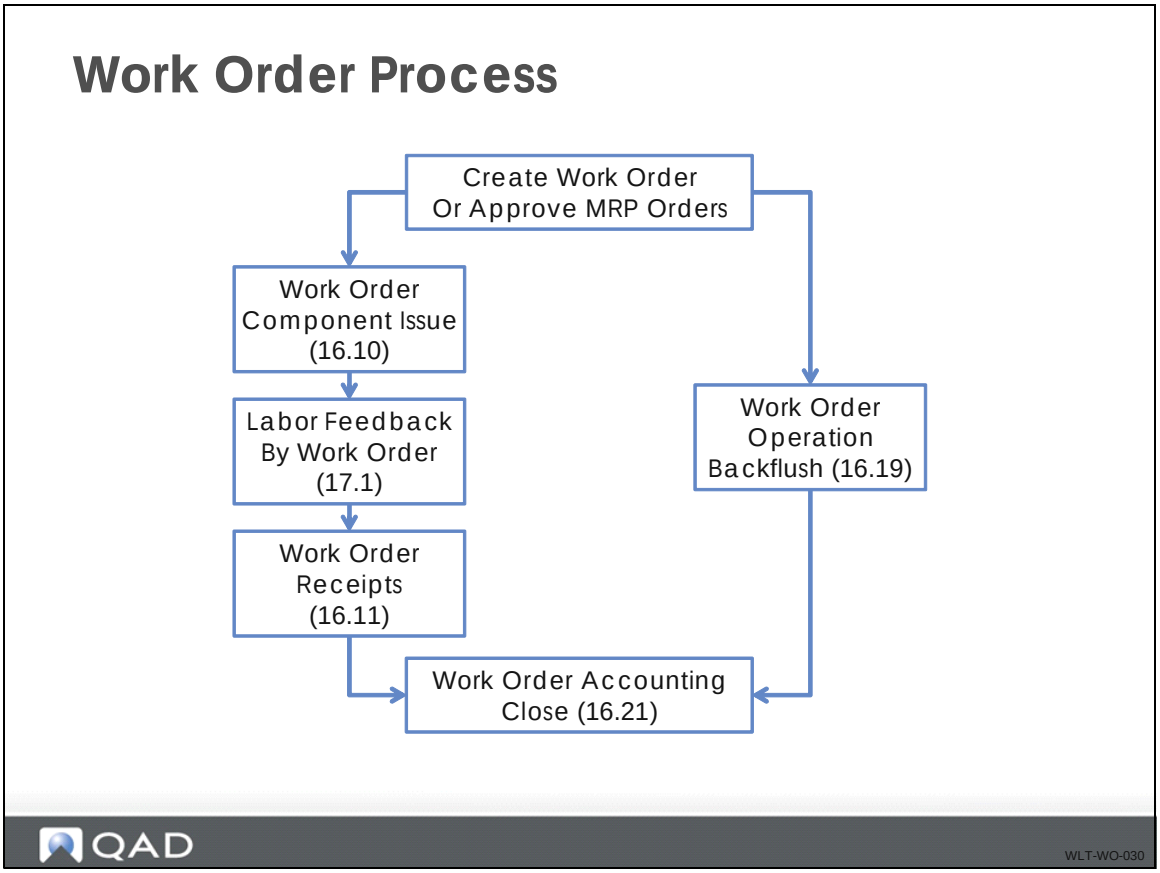
In this section you learn how to:

- ✓ Identify key business considerations before setting up WLT in QAD Standard Edition
- ✓ Set up WLT in QAD Standard Edition
- ✓ Process WLT in QAD Standard Edition
- • **WLT with Work Orders/SFC**
- • WLT with Advanced Repetitive
- • WLT with Repetitive

QAD

WLT-WO-020

Work Order Process



When processing a work order (WO), the system uses WLT data collection frames to collect tracing information if the WO is WLT controlled. A WO is WLT controlled when:

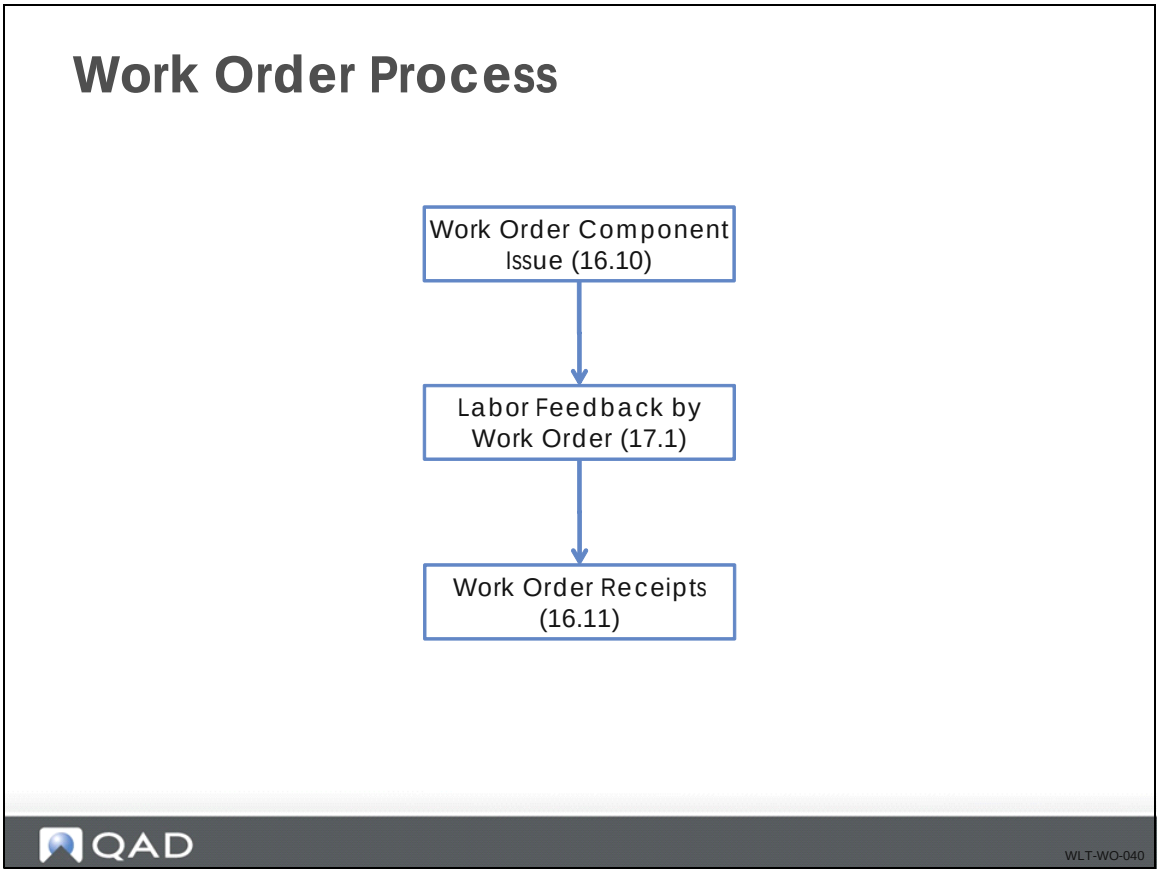
- WLT has been enabled
- Trace Parents is Yes in the WIP Lot Trace Control File (3.22.13.24), or
- A WLT BOM registration record is active for the parent item being manufactured and Trace Parents is Yes for that BOM registration record

The above graphic shows two methods for processing a WO. In the first method, the job flow is:

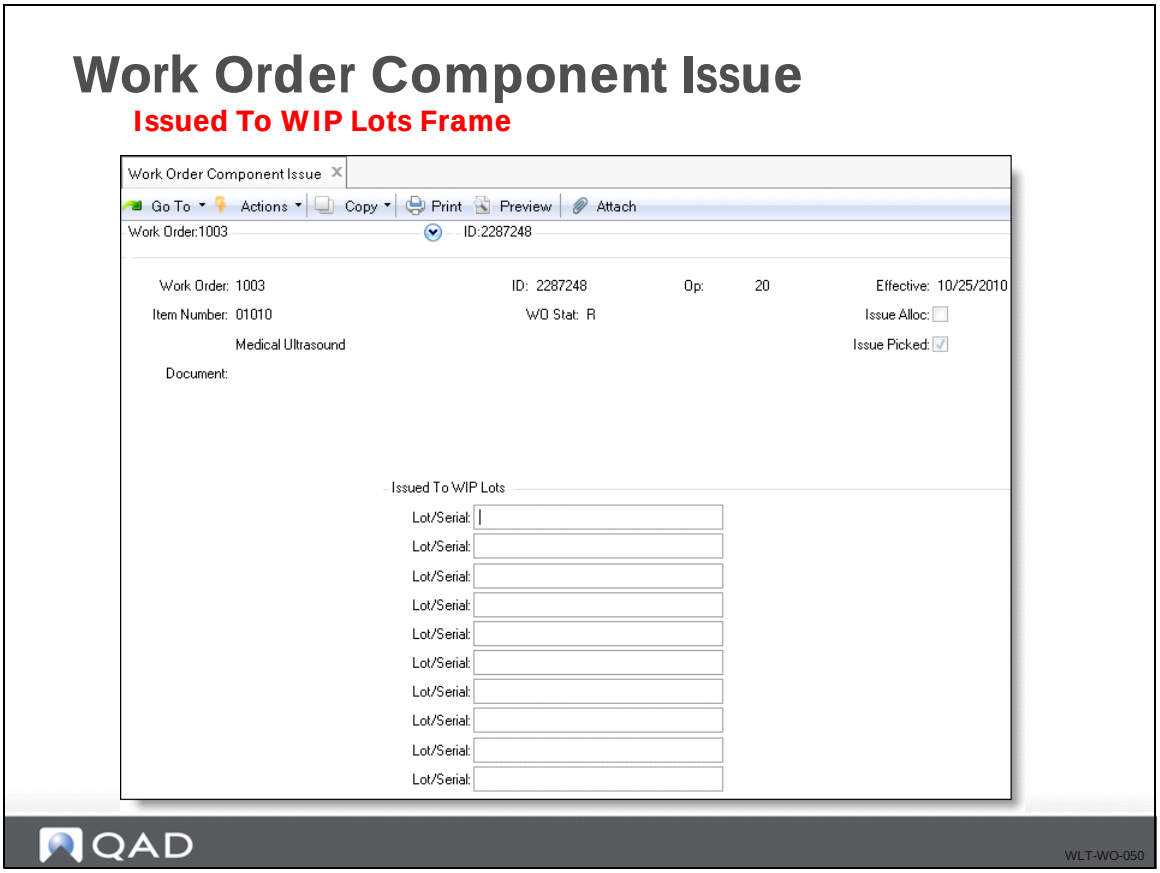
- Issue the components
- Report labor
- Receive finished goods into inventory

The second, or alternative, method is to use Work Order Operation Backflush (16.19). It combines issuing, labor reporting, and receiving functions.

Work Order Process



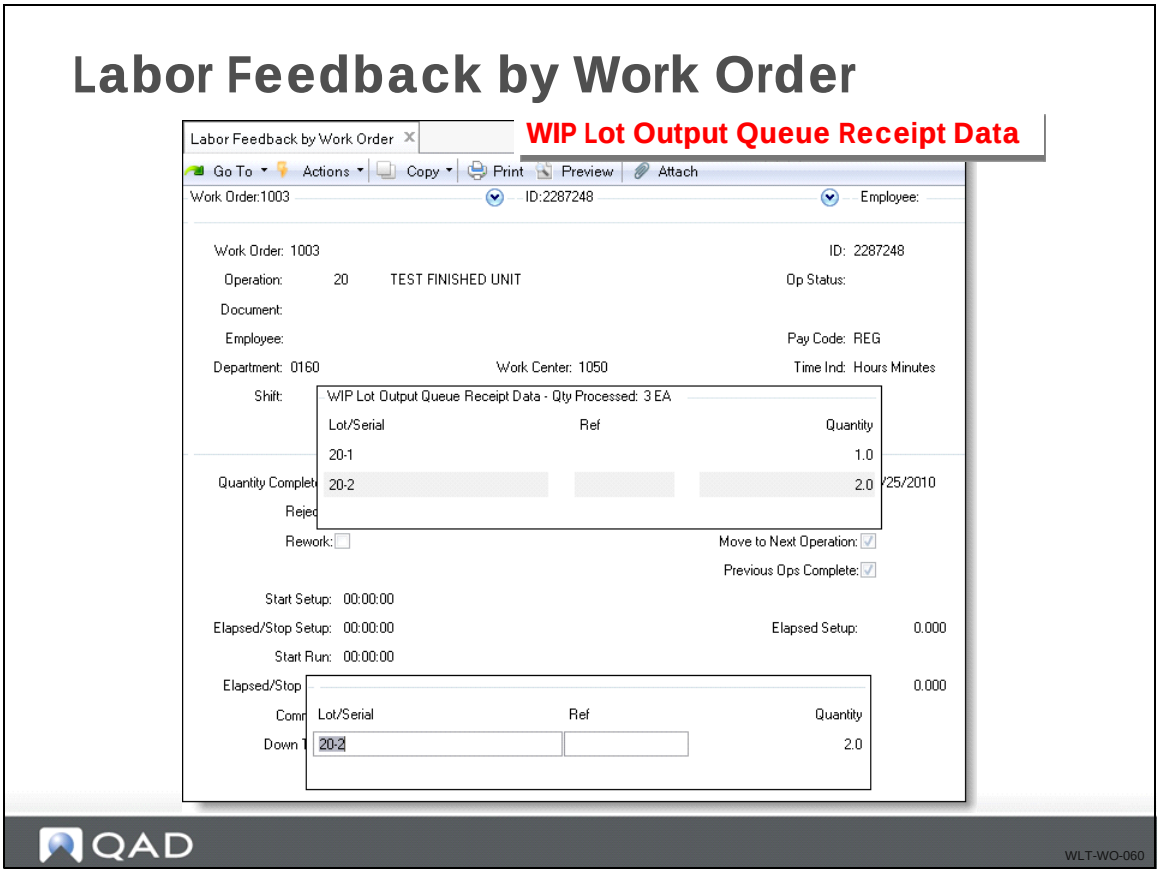
Work Order Component Issue



Use Work Order Component Issue to issue component and WIP material to WLT controlled WOs. It uses the following WLT data collection frames:

- Current Work Center and Machine
- WIP Lot Input Queue Issue Data
- Issued to WIP Lots

Labor Feedback by Work Order



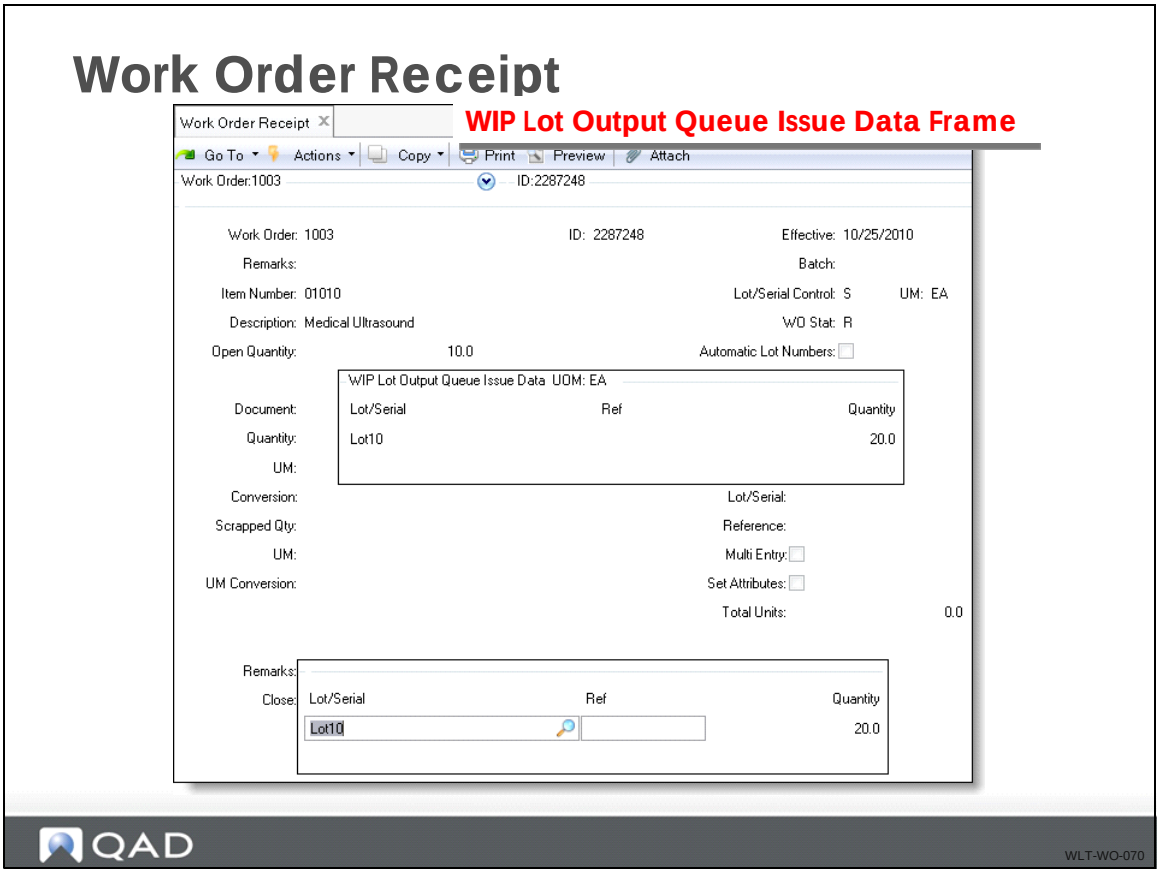
To report labor you can use any of the following Shop Floor Control programs:

- Labor Feedback by Work Order (17.1)
- Labor Feedback by Employee (17.2)
- Labor Feedback by Work Center (17.3)

The labor feedback programs use the following WLT data collection frame:

- WIP Lot Output Queue Receipt Data frame

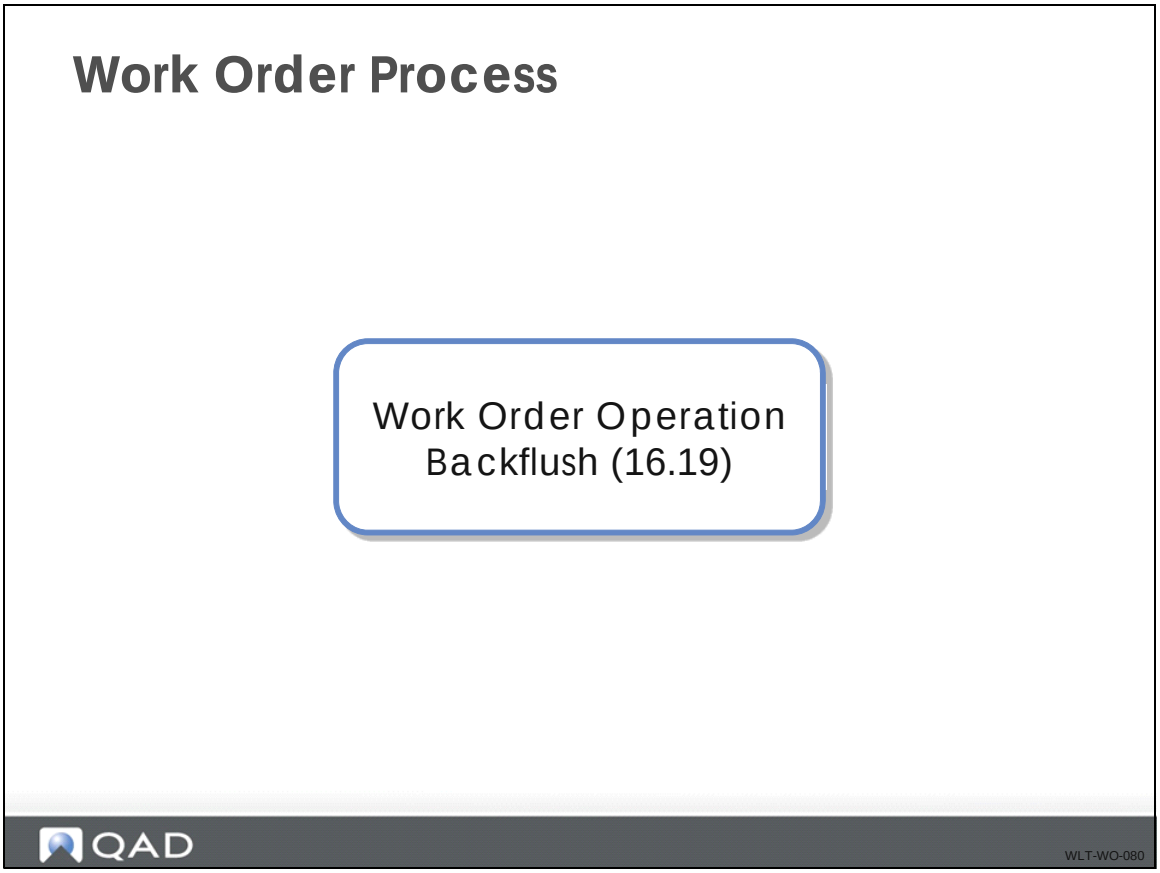
Work Order Receipt



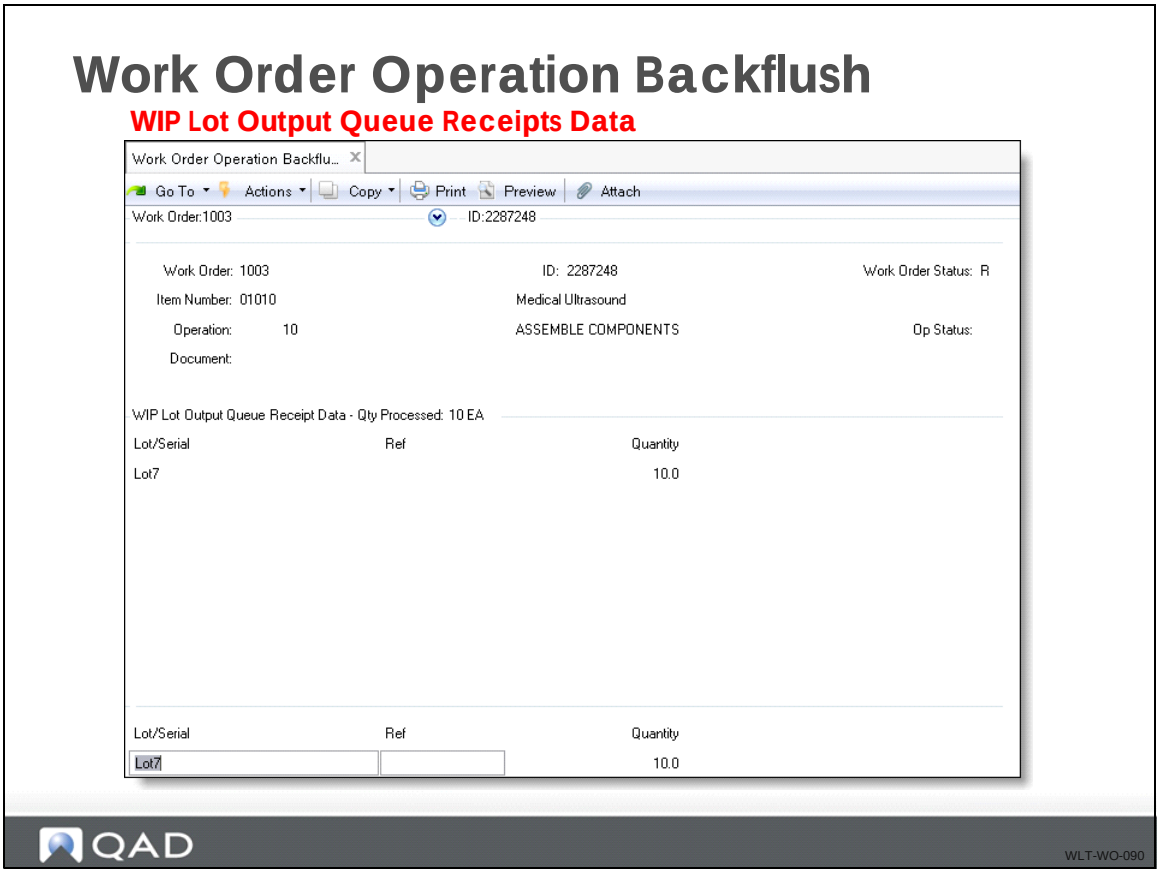
You use Work Order Receipt to receive the finished goods manufactured with WLT controlled routings. Work Order Receipt uses the WLT data collection frames:

- Current Work Center and Machine
- WIP Lot Output Queue Issue Data

Work Order Process



Work Order Operation Backflush



You can also use Work Order Operation Backflush to process a WO. It uses the following WLT data collection frames:

- WIP Lot Input Queue Issue Data
- Destination Work Center and Machine
- WIP Lot Output Queue Receipt Data

Exercise: Work with WIP Lot Trace

Create Work Order

1. Use Work Order Maintenance (16.1) to create a work order for 2 units of 10MHz probe assembly (50001) at site 10-100. Record the work order number.
2. Use Work Order Component Check (16.5) to check if there are any component shortages for the work order just created. If shortages exist, use Receipt - Unplanned (3.9) to receive enough components into site 10-100 to cover the shortage. For serial-controlled items, use the same item number followed by a suffix to define serial numbers; for example, 60004-S001, 60004-S002, and so on.
3. Use Work Order Release/Print (16.6) to release the work order.
4. Use Work Order Component Issue (16.10) to issue materials to operation 10 for the work order. In addition to the component material to issue, you will be prompted to enter a list of WIP material to issue. You will also be prompted to enter a list of WIP lot numbers to which the issued WIP and component lot/serials are issued. Note that these WIP lot numbers are not “produced” by this transaction, but rather, they are used to form the association between the materials issued and the materials that will be produced later.
5. Complete the transaction by clicking back until the “Is all information correct?” message appears; confirm by clicking Yes.

View WIP Lot Tracing Data

1. Now you can view the tracing data created by the component issue transaction. Use Operation Transaction Detail Inquiry (16.20.13.9) to review the operation transaction detail. It should default to your last transaction (ISSUE).
2. Advance to the WIP Lot Trace Data frame. The data displayed shows the material lots consumed and produced as a result of your issue transaction.

   Note The WIP material will be listed with an item number which is the same as the parent item number.
3. WIP Lot Convert Trans Report (3.22.13.15) to view the same detail in report format.
4. Use WIP Lot Where-Used Report (3.22.13.19) to view downstream traceability.
5. Use WIP Lot Actual Bill Report (3.22.13.20) to view composed-of traceability.

Labor Feedback by Work Order

Register an operation completion at the second operation. You will be prompted to enter a list of WIP lot numbers that were produced. This also updates the QOH for the WIP lot/serials produced.

1 Use Labor Feedback by Work Order (17.1) to record the labor feedback by entering the following:

Field	Data
Work Order	[The work order number entered above]
Operation	10
Employee	[Use your Down Arrow to select the first record]
Qty Completed	3
Operation Complete	No

2 Advance to the WIP Lot Output Queue Receipt Data frame and enter the following:

Field	Data
Lot/Serial	10-1
Ref	[Blank]
Qty	1

Repeat the above using the following data:

Field	Data
Lot/Serial	10-2
Ref	[Blank]
Qty	2

Complete the transaction by clicking back until the Is all information Correct? message appears, confirm by clicking Yes.

3 Use WIP Lot Inventory Status Report (3.22.13.13) to view the WIP lot/serial QOH balances for this work order.

Work Order Receipts

Record the completion of finished material, similar to an Advanced Repetitive backflush at the last operation. You will be prompted to enter a list of output queue WIP lot/serials to consume. Tracing data will be recorded to show the consumption of the WIP lot/serials entered and the production of the finished-material lots entered. QOH balances are adjusted accordingly.

1 Use Work Order Receipt (16.11) to process the receipt, enter the work order number of the work order created earlier.

2 Advance to the WIP Lot Output Queue Issue Data frame and enter the following:

Field	Data
Lot/Serial	L1
Ref	[Blank]
Qty	1

Repeat the above using the following data:

Field	Data
Lot/Serial	L2
Ref	[Blank]
Qty	2

3 In the main data entry frame, enter the following:

Field	Data
Quantity	3
Site	10-200
Location	200
Lot/Serial	FGL2

Complete the transaction by clicking next until the Is all information correct? message appears, confirm.

4 Use Operation Transaction Detail Inq (17.13.9) to review the operation transaction detail. It should default to your last transaction (RECEIPT).

5 Advance to the WIP Lot Trace Data frame.

The data displayed shows the material lots consumed and produced as a result of your last transaction.

Note The WIP material will be listed with an item number the same as the parent item number.

6 Use WIP Lot Convert Trans Report (3.22.13.15) to view the same detail in report format.

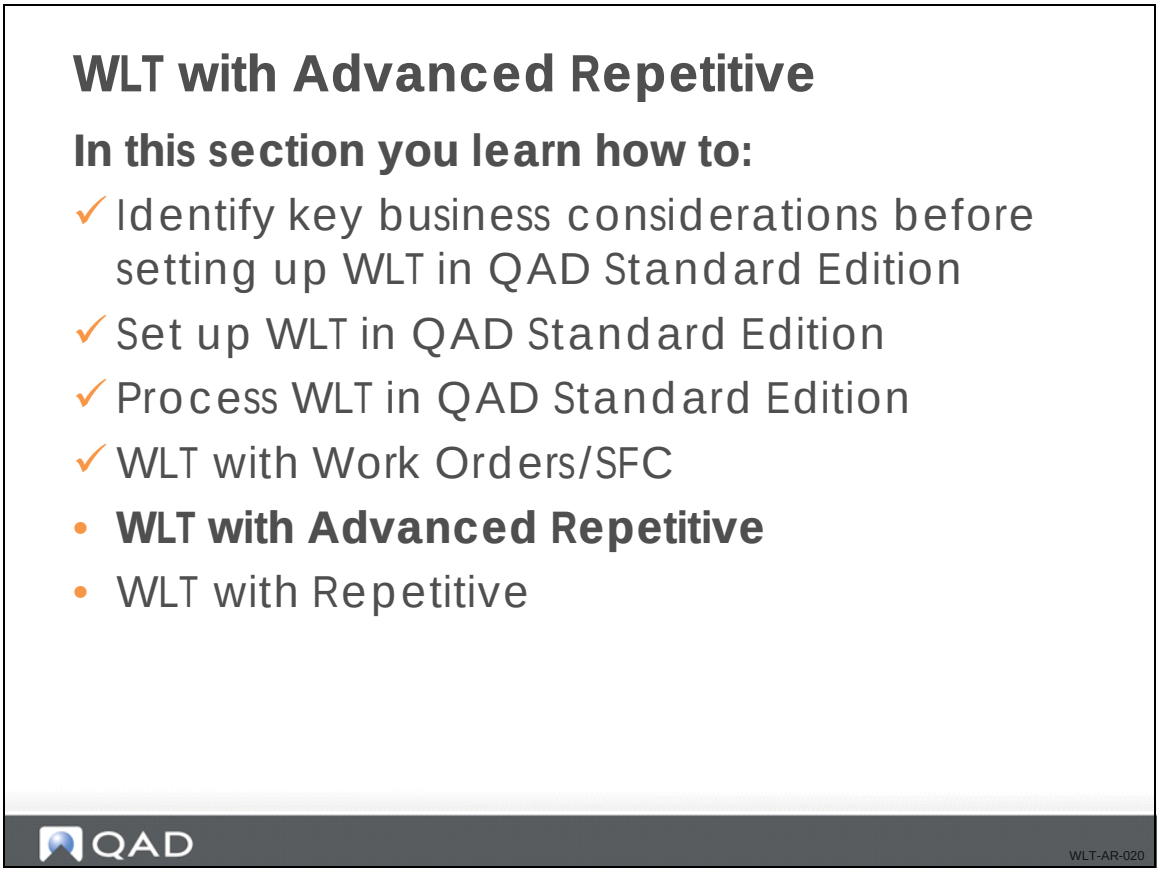
7 Use WIP Lot Where-Used Report (3.22.13.19) to view downstream traceability.

8 Use WIP Lot Actual Bill Report (3.22.13.20) to view composed-of traceability.

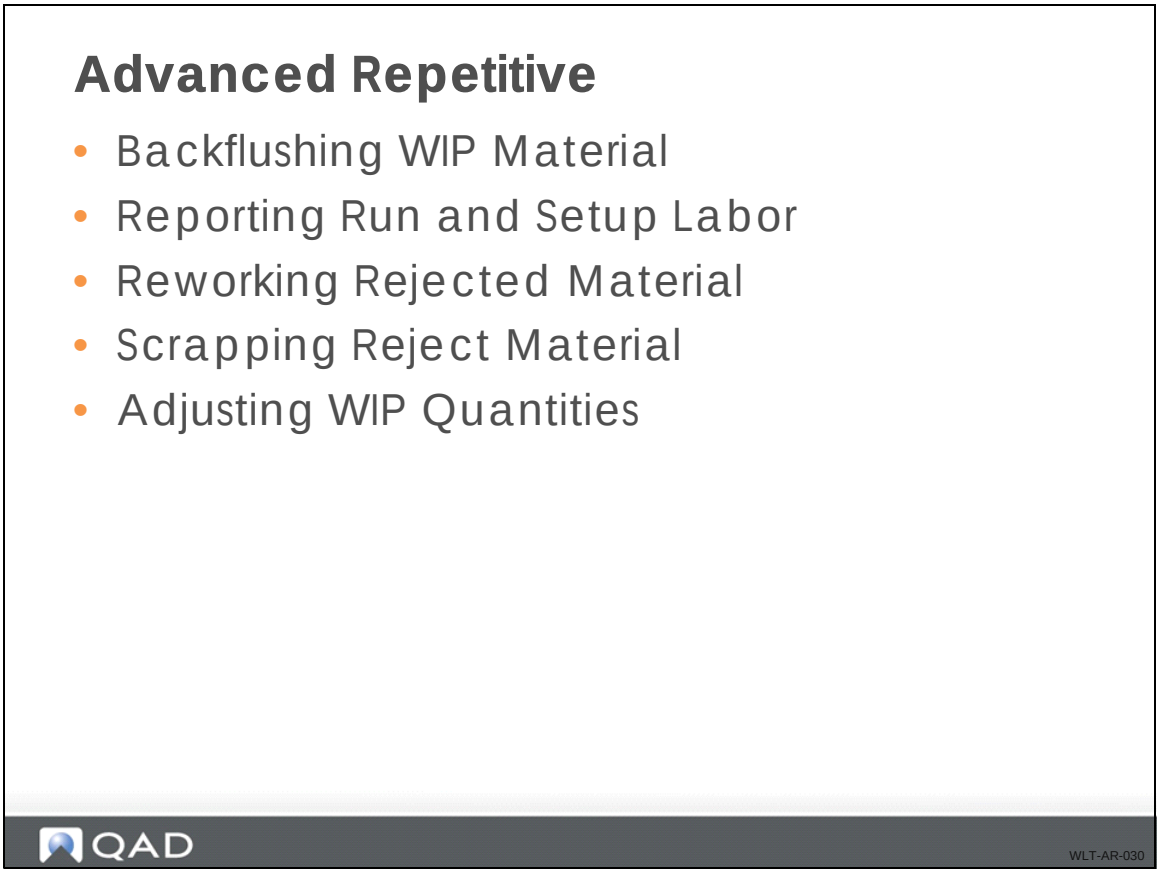
Chapter 6

WLT with Advanced Repetitive

Course Overview

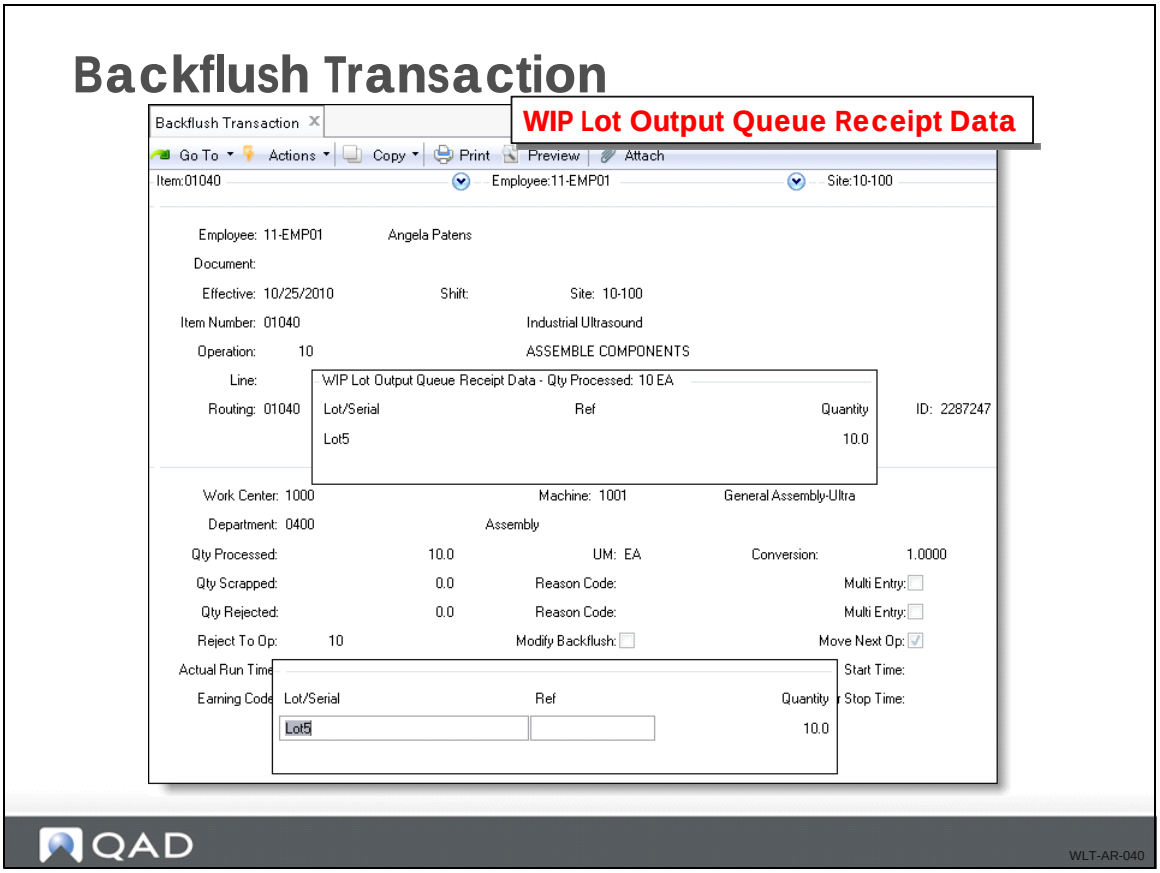


Advanced Repetitive



When processing a cumulative order in the Advanced Repetitive module, the system uses WLT data collection frames to collect tracing information if the cumulative order is WLT controlled.

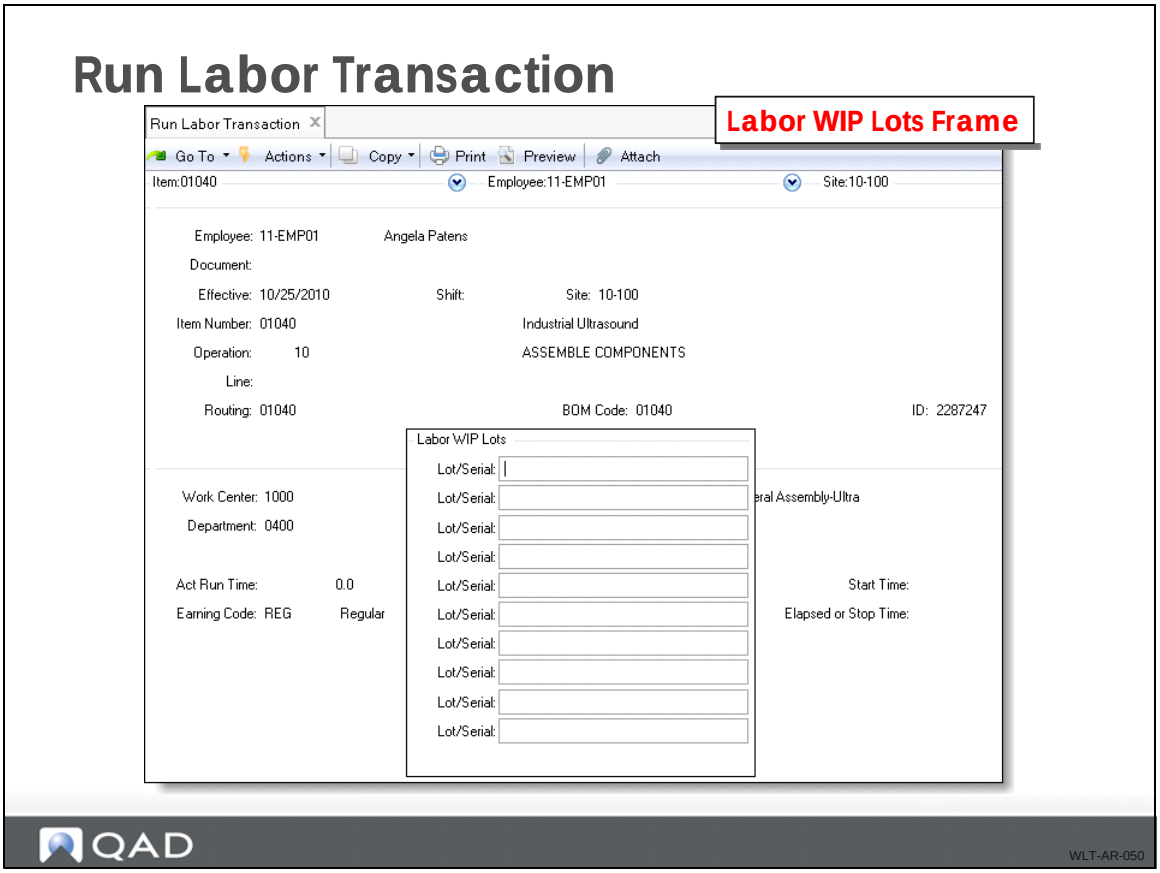
Backflush Transaction



Use Backflush Transaction to report production activity at advanced repetitive manufacturing operations. When WLT is active, the following WLT data collection frames display:

- Destination Work Center and Machine
  - Appears only if Move Next Op is set to Yes
- WIP Lot Input Queue Issue Data
- WIP Lot Output Queue Receipt Data
- WIP Lot Scrap Data
  - Appears only if you enter a value in the Qty Scrapped field
- WIP Lot Reject Data
  - Appears only if you enter a value in the Qty Rejected field

Run Labor Transaction

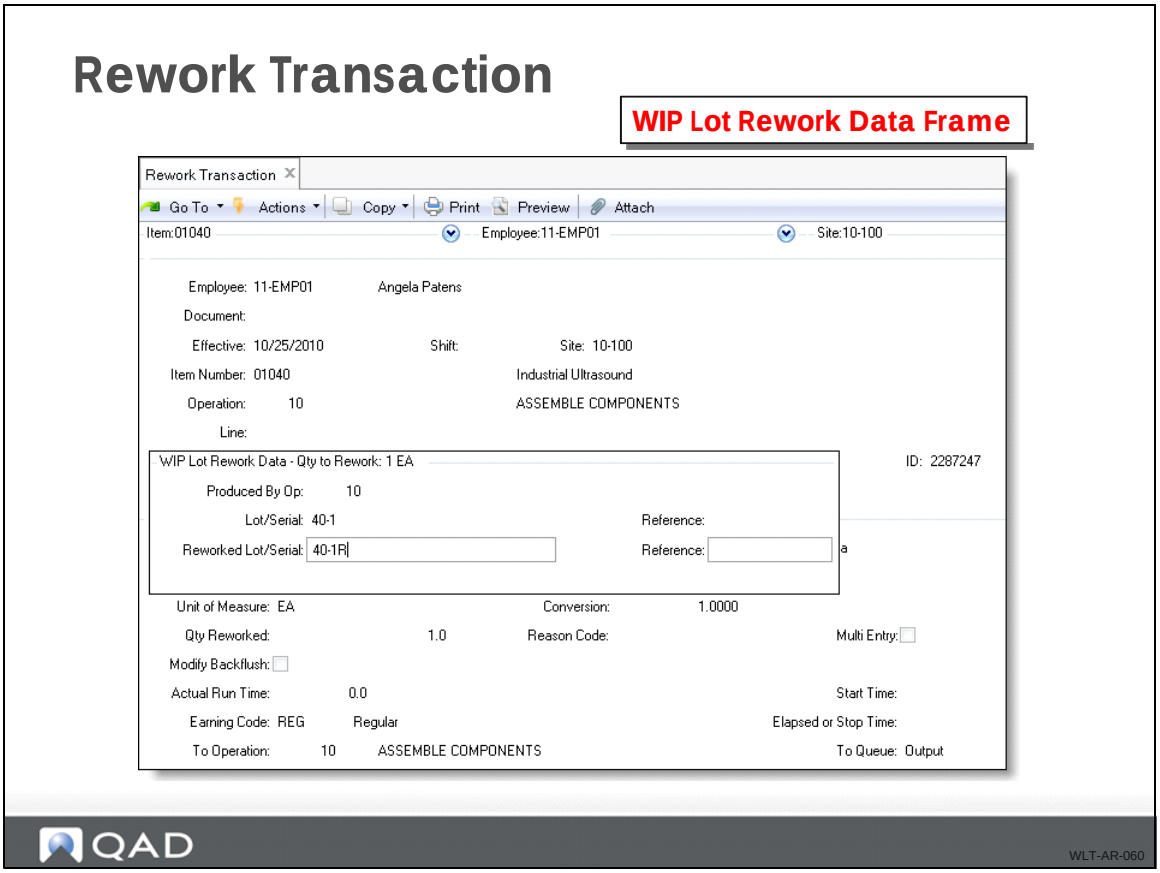


Use Run Labor Transaction to report labor performed for WLT controlled lot/serial numbers. You do this using the WLT data collection frame:

- Labor WIP Lots

Note Setup Labor Transaction (18.22.15) works similarly.

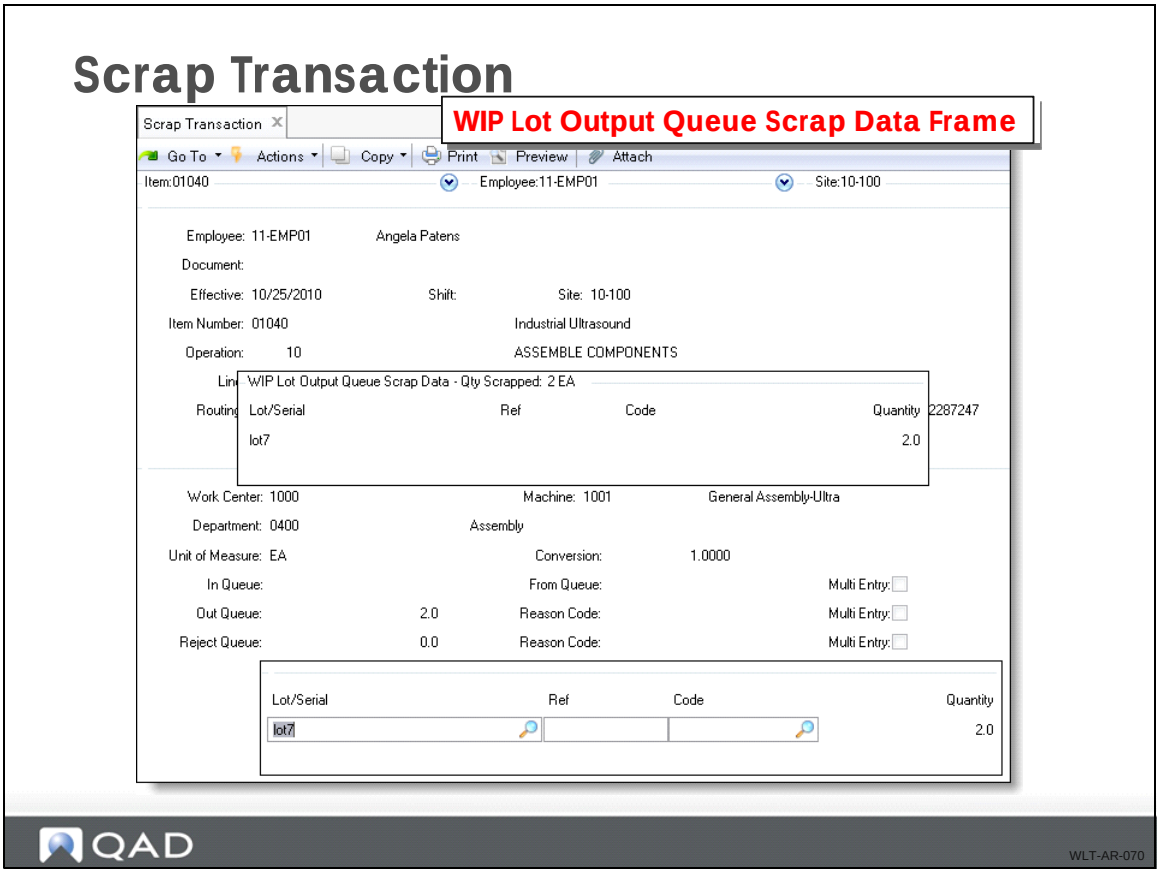
Rework Transaction



Use Rework Transaction to move previously rejected WLT-controlled material back into production. The following WLT data collection frames display:

- Destination Work Center and Machine
- WIP Lot Rework Data

Scrap Transaction

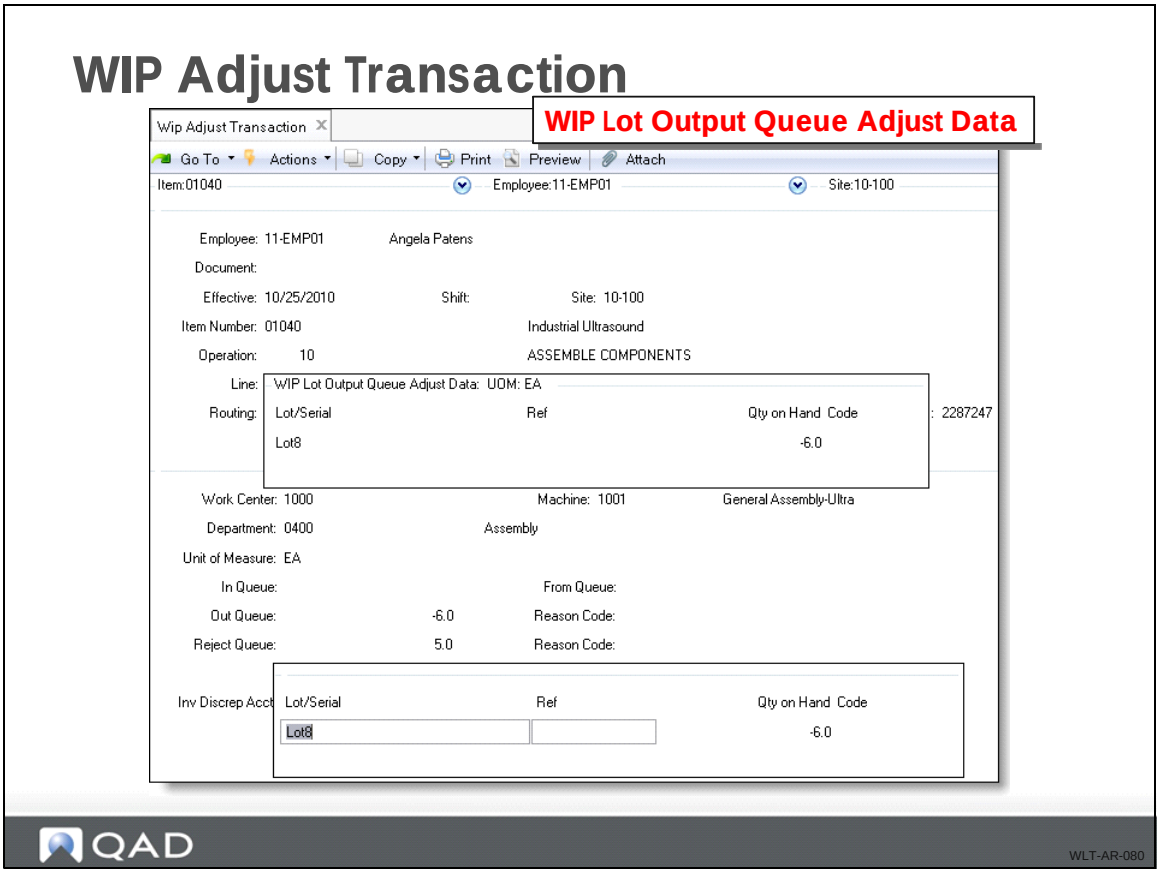


Use Scrap Transaction to scrap or remove WIP quantities from any queue of an operation without backflushing. Depending on which queue you are scrapping material from, one or more of the following WLT data collection frames will appear:

- WIP Lot Input Queue Scrap Data
  - Enter a value in the In Queue field
- WIP Lot Output Queue Scrap Data
  - Enter a value in the Out Queue field
- WIP Lot Reject Queue Scrap Data
  - Enter a value in the Rjct Queue field

The system reduces the WIP QOH at each queue by the quantity scrapped at the indicated work center and machine (specified in the second frame). It also adds the quantity scrapped to the cumulative scrapped quantity for the specified lot/serials.

WIP Adjust Transaction



Use WIP Adjust Transaction to adjust quantities at an operation's input, output, and reject queues. The following WLT data collection frames display:

- WIP Lot Input Queue Adjust Data
- WIP Lot Output Queue Adjust Data
- WIP Lot Reject Queue Adjust Data

Note When using WLT, the In Queue, Out Queue, and Rjct Queue fields are not available. You must enter the WLT data collection frames to enter adjustments to QOH balances for the WIP lot/serials in each queue.

Exercise: Work with Advanced Repetitive

Set up Lot Trace

Use WIP Lot Trace Control (3.22.13.24) to configure global settings for WIP Lot Trace. Set Trace Parents and Trace Components to Yes.

Field	Data
Enable WIP Lot Trace	Yes
Trace Parents	Yes
Max Lot Size	0
WIP Lot Number Sequence ID	WIPLOT
Split WIP Lots	Yes
Combine WIP Lots	Yes
WIP Lot Overissue	Yes
Trace Components	Yes
Trace Reference	Yes
Combine Component Lots	Yes

Backflush

Backflush the first operation of your parent item's routing, then you will be prompted to enter the lot numbers of the WIP that was produced by the material conversion event. Because this is the first operation, you are not prompted for input WIP lot/serials to consume.

1 Use Backflush Transaction (18.22.13) to perform backflush.

Field	Data
Employee	[Use your Down Arrow to select the first record]
Site	10-200
Item Number	02001
Operation	10
Line	2130
Qty Processed	300

Record the cumulative order ID (displays in the lower-right corner of the first frame):

_____

2 Accept the destination work center and machine.

3 Advance to the WIP Lot Output Queue Receipt Data frame and enter the following:

Field	Data
Lot/Serial	L1
Ref	[Leave blank]
Qty	100

Create a second entry by entering the following:

Field	Data
Lot/Serial	L1
Ref	[Leave blank]
Qty	100

View Tracing Data

1 Use Operation Trans Detail Inquiry (18.22.4.2) to review the operation transaction (BACKFLSH) detail.

2 View the WIP Lot Convert Trans Report (3.22.13.15). Enter your cumulative order ID in the ID and To fields.

The data displayed shows the material lots consumed and produced as a result of your backflush transaction, similar to Operation Trans Detail Inquiry. WIP material is listed with Type of WIP and with an Item Number the same as the parent item number.

Note WIP Lot Convert Trans Report is called that because tracing data is recorded only when material is converted (e.g., fabricated, assembled, reworked, etc.).

3 Use WIP Lot Actual Bill Report (3.22.13.20) to print a WIP Lot Actual Bill Report:

Field	Data
Material Type (Item/WIP)	WIP
Item Number	02001
Produced by ID	[Cumulative order ID]
Produced by Op	10
Lot/Serial	L1
To	L2

4 Review the report and take note of the following:

- The component you backflushed as the level 1 line.
- The Qty value is the total quantity of this lot/serial that was consumed.
- Each level 1 line is followed by a level 2 line.
- The level 2 lines represent the material that was consumed to produce their respective level 1 lines.
- The Qty value is the quantity consumed into its respective level 1 line.

View WIP Lot Inventory

1 Use WIP Status Inquiry (18.22.12) to view the on-hand balances:

Field	Data
Effective	[Accept the default]
Site	10-200
Item Number	02001
Operation	20
Line	2130

Note You need view operation 20 because Move To Next Op in the Backflush Transaction is set to Yes.

2 Review the report. Look at the WIP Lot Inventory section. This section displays a list of the WIP lots at this operation.

3 Use WIP Lot Inventory Status Report (3.22.13.13) to print the WIP Lot Inventory Status Report. Enter the ID of the cumulative order in the ID and To fields.

4 Review the report. You will see the two WIP lots you entered in the Backflush Transaction.

Run Labor Transaction

Record labor against an operation. You will be prompted to enter the lot numbers of the WIP to which this reported labor will be associated.

1 Use Run Labor Transaction (18.22.14) to record labor.

Field	Data
Employee	[Use your Down Arrow to select the first record]
Site	10-200
Item Number	02001
Operation	10
Line	2030
Act Run Time	500

2 Advance to the Labor WIP Lots frame and enter L1 in the first Lot/Serial field.

3 Use Operation Trans Detail Inquiry (18.22.4.2) to review the operation transaction detail. It should default to your last transaction (LABOR).

4 Advance to the WIP Lot Trace Data frame. The data displayed shows the WIP lot/serial entered with a quantity of 0.0 (zero). This tracing record is created in order to associate the reported labor with the “production” of the WIP lot/serial.

Note Setup Labor Transaction (18.22.15) works similarly.

WIP Adjust Transaction

Modify WIP lot/serial QOH balances at an operation.

1 Use WIP Adjust Transaction (18.22.21) to adjust the data.

Field	Data
Employee	[Use your Down Arrow to select the first record]
Site	10-200
Item Number	02001
Operation	10
Line	2130

2 Advance to the WIP Lot Input Queue Adjust Data frame.

This frame presents a list of the input queue WIP lot/serials and QOH balances for this operation.

3 Enter several WIP lot/serials and quantities. Entries in the list will be added or updated.

4 Advance to the WIP Lot Output Queue Adjust Data frame and enter several WIP lot/serials and quantities.

5 Advance to the WIP Lot Reject Queue Adjust Data frame and enter several WIP lot/serials and quantities.

6 Cycle back through the transaction. You should see your updated entries.

7 WIP Status Inquiry (18.22.12) and WIP Lot Inventory Status Report (3.22.13.13) to view the updated WIP lot/serial QOH balances.

8 Use Operation Trans Detail Inquiry (18.22.4.2) to review the operation transaction detail. It should default to your last transaction (WIPADJ-x).

9 Advance to the WIP Lot Processed frame.

This frame shows the WIP lot/serial that was adjusted by this transaction. Notice that there will be one Operation History record written for each WIP lot/serial adjusted.

Note You can also use WIP Lot Non-Convert Trans Report (3.22.13.16) to display this information.

Scrap Transaction

Scrap quantities of WIP lot/serial QOH balances at an operation.

1 Use Scrap Transaction (18.22.18) to begin the scrap process.

Field	Data
Employee	[Use your Down Arrow to select the first record]
Site	10-200
Item Number	02001
Operation	10
Line	2130

2 Advance to the second (lower) frame. Enter 2 in the In Queue, Out Queue and Reject Queue fields.

3 Advance to the WIP Lot Input Queue Scrap Data frame. Press the Lookup key to display a list of WIP lot/serials at that operation. Select one and enter 10 in Qty.

Note You can enter a non-existent WIP lot/serial if necessary.

4 Repeat the process for the WIP Lot Output Queue Scrap Data frame and the WIP Lot Reject Queue Scrap Data frame.

5 Use WIP Status Inquiry (18.22.12) and WIP Lot Inventory Status Report (3.22.13.13) to view the updated WIP lot/serial QOH balances.

6 Review the transaction history for your last transaction (SCRAP-x).

7 Advance to the WIP Lot Processed frame.

This frame shows the WIP lot/serial that was scrapped by this transaction. Notice that there will be one Operation History record written for each WIP lot/serial scrapped.

Note You can also use WIP Lot Non-Convert Trans Report (3.22.13.16) to display this information.

Move Transaction

This function moves WIP from the output queue of one operation to the input queue of the following operation. You use this transaction when manual control over moving WIP to the next operation is desired; for example, when Move Next Op is set to No in Routing Maintenance (14.13.1).

1 Use Move Transaction (18.22.19).

Field	Data
Employee	[Use your Down Arrow to select the first record]
Site	10-200
Item Number	02001
Operation	10
Line	2130
Qty to Move	10

2 Advanced to the WIP Lot Move Data frame.

Field	Data
Lot/Serial	L1
Quantity	10

3 Use WIP Status Inquiry (18.22.12) and WIP Lot Inventory Status Report (3.22.13.13) to view the updated WIP lot/serial QOH balances.

Reject Transaction

This function rejects WIP lot/serials from the output queue to the reject queue.

1 Use Reject Transaction (18.22.16) to run the reject process.

Field	Data
Employee	[Use your Down Arrow to select the first record]
Site	10-200
Item Number	02001
Operation	10
Line	2130
Qty Rejected	1

2 Advance to the WIP Lot Reject Data frame.

Field	Data
Lot/Serial	L2
Quantity	1

3 Use WIP Status Inquiry (18.22.12) and WIP Lot Inventory Status Report (3.22.13.13) to view the updated WIP lot/serial QOH balances.

Rework Transaction

Use this function to register the rework of WIP lot/serials. This involves moving WIP lot/serials from the reject queue back to the output queue.

1 Use Rework Transaction (18.22.17) to register the rework.

Field	Data
Employee	[Use your Down Arrow to select the first record]
Site	10-200
Item Number	02001
Operation	10
Line	2130
Qty Reworked	1

2 Advance to the WIP Lot Rework Data frame.

Field	Data
Lot/Serial	L1
Reworked Lot/Serial	L1-R

3 Use Operation Trans Detail Inquiry (18.22.4.2) to review the operation transaction detail. It should default to your last transaction (REWORK).

4 Advance to the WIP Lot Processed frame.

This frame lists the WIP lot/serial processed by this transaction.

5 Advance to the WIP Lot Trace Data frame.

The data displayed shows the material lots consumed and produced as a result of the Rework Transaction. This tracing data is recorded only because the entered Reworked Lot/Serial value is different from the Lot/Serial value.

Note You can also use WIP Lot Non-Convert Trans Report (3.22.13.16) or WIP Lot Convert Trans Report (3.22.13.15) to display this information.

Close Cumulative Order

Close the Advanced Repetitive cumulative order that you have been working with.

Use Cumulative Order Close (18.22.10) to close the cumulative order.

Field	Data
ID	[Your cumulative order ID]
To	[Your cumulative order ID]
End Effective	[End effective date of your cumulative order]
Transfer WIP	Yes
Update	Yes

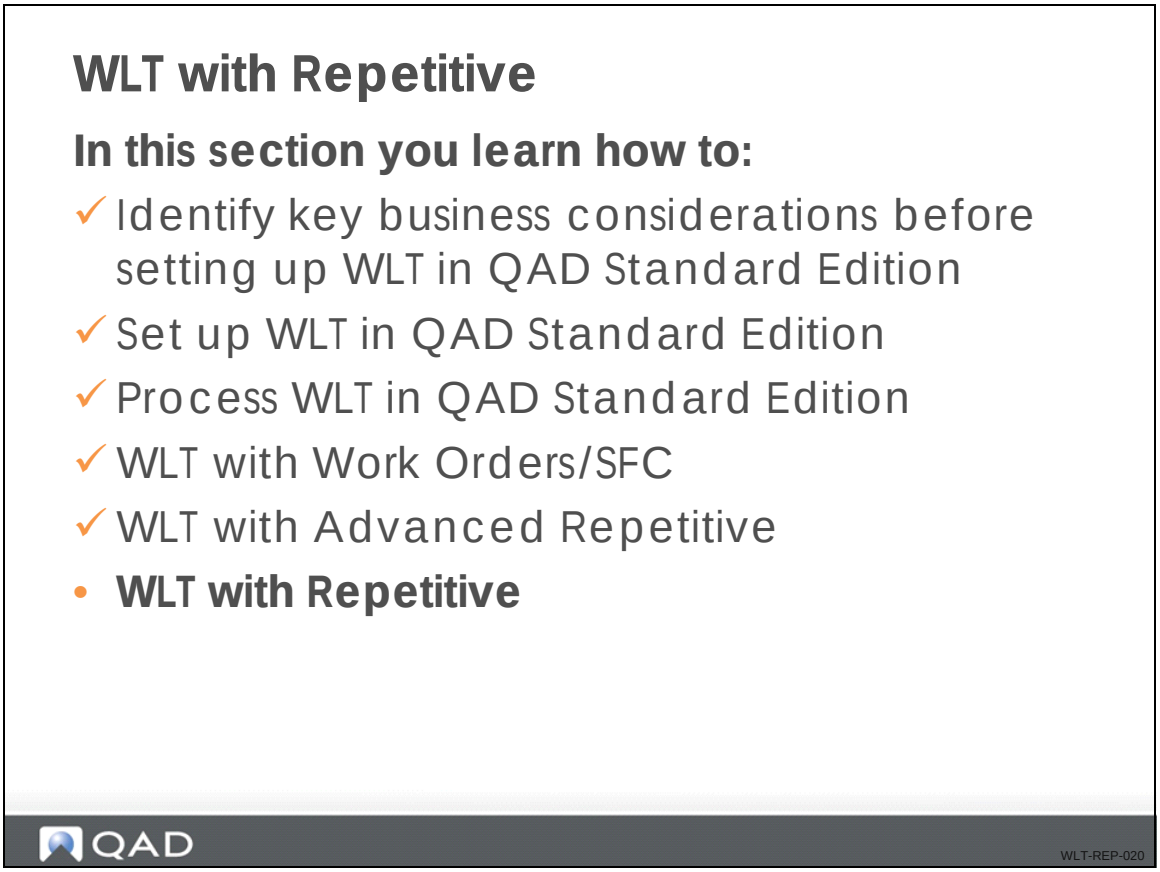
Note If you do not know the end effective date of your cumulative order, you can find it by running Cumulative Order Report (18.22.8).

This function closes your cumulative order and transfers its WIP lot/serials to the new cumulative order. The report output contains a list of the WIP lot/serials transferred to the new cumulative order.

Chapter 7

WLT with Repetitive

Course Overview

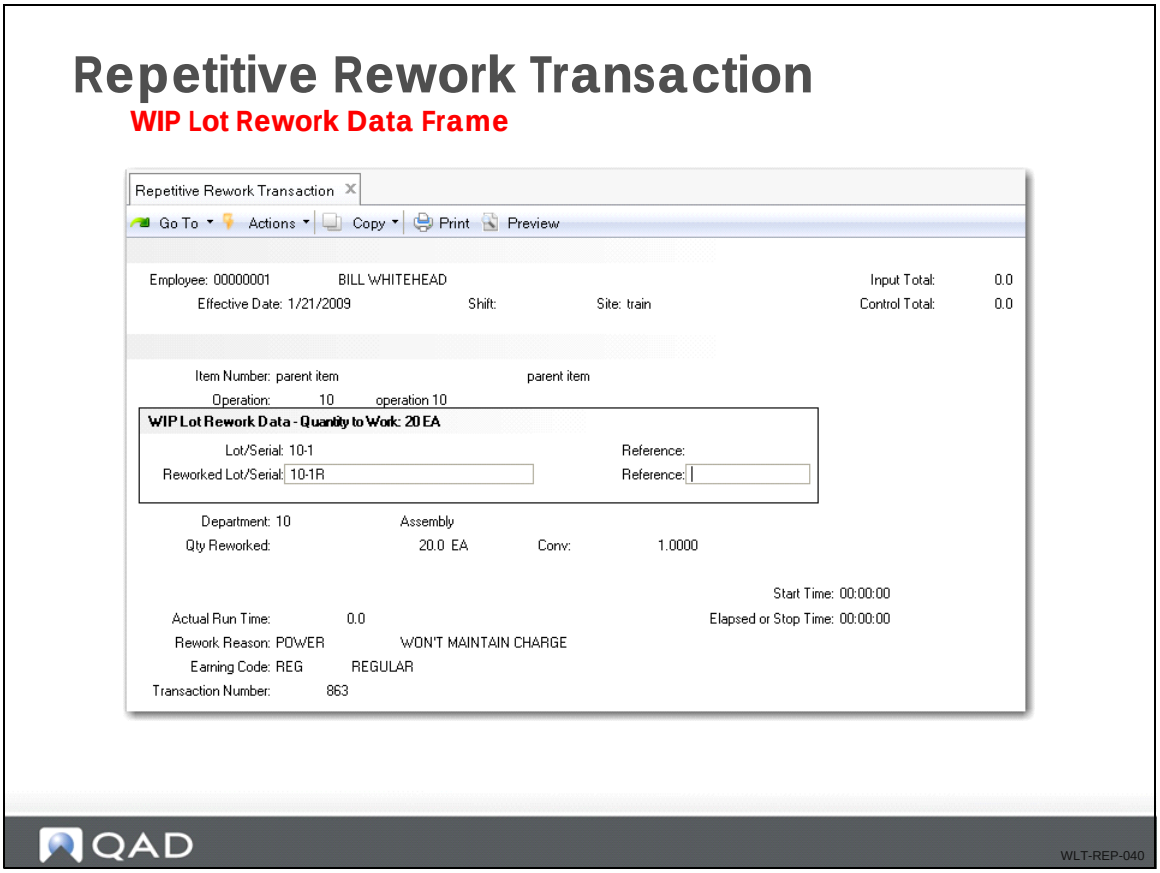


Repetitive

When processing a cumulative order in the Repetitive module, the system uses WLT data collection frames to collect tracing information if the cumulative order is WLT controlled.

- WLT has been enabled

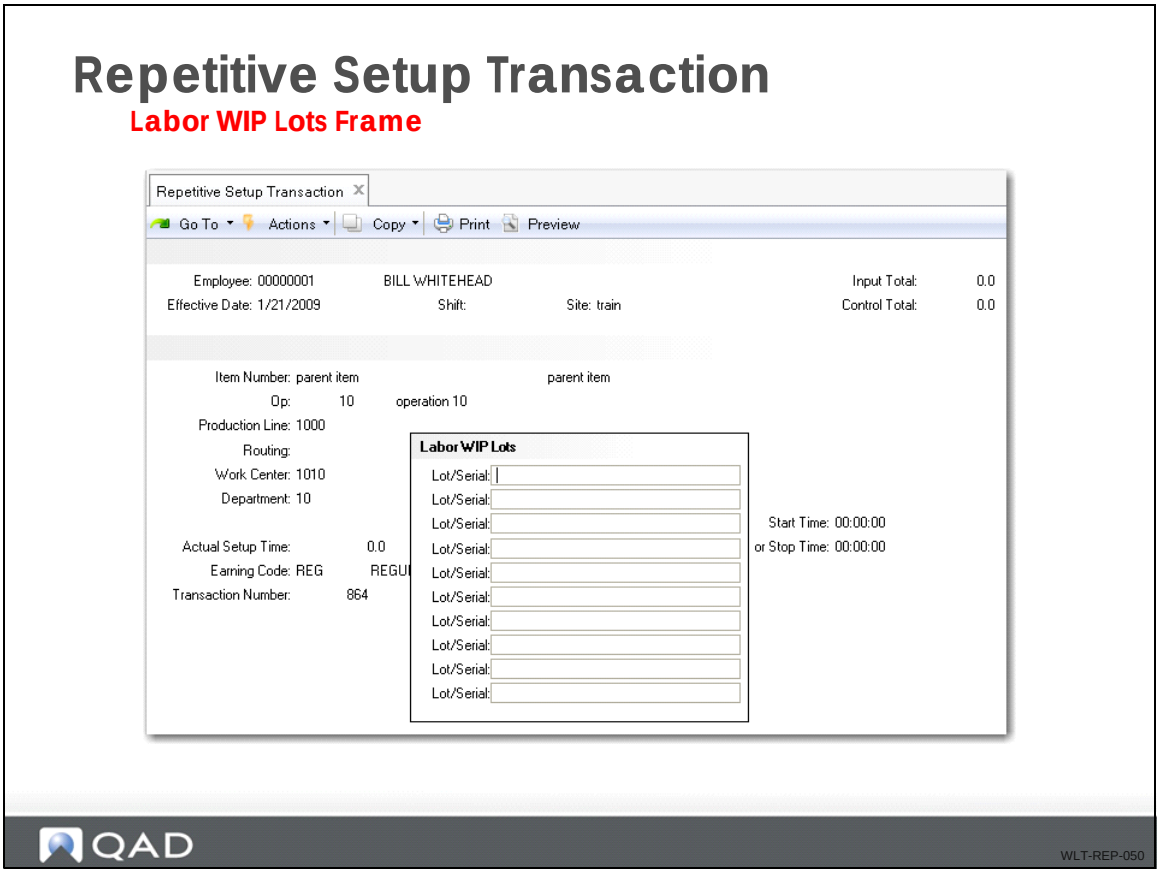
Repetitive Rework Transaction



Use Repetitive Rework Transaction to do move previously rejected WLT-controlled material back into production. The following WLT data collection frames display:

- Destination Work Center and Machine
- WIP Lot Rework Data

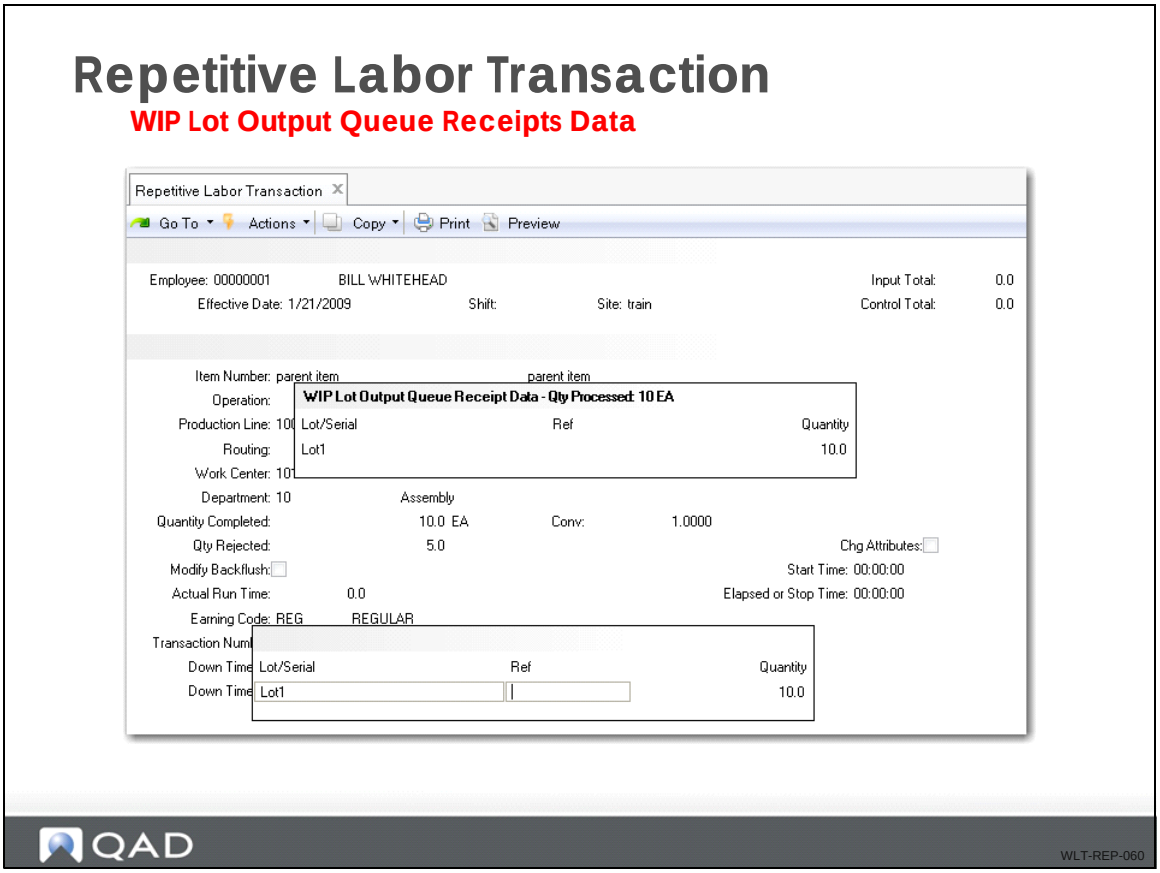
Repetitive Setup Transaction



Use Repetitive Setup Transaction to report labor performed for WLT controlled lot/serial numbers. You do this using the WLT data collection frame:

- Labor WIP Lots

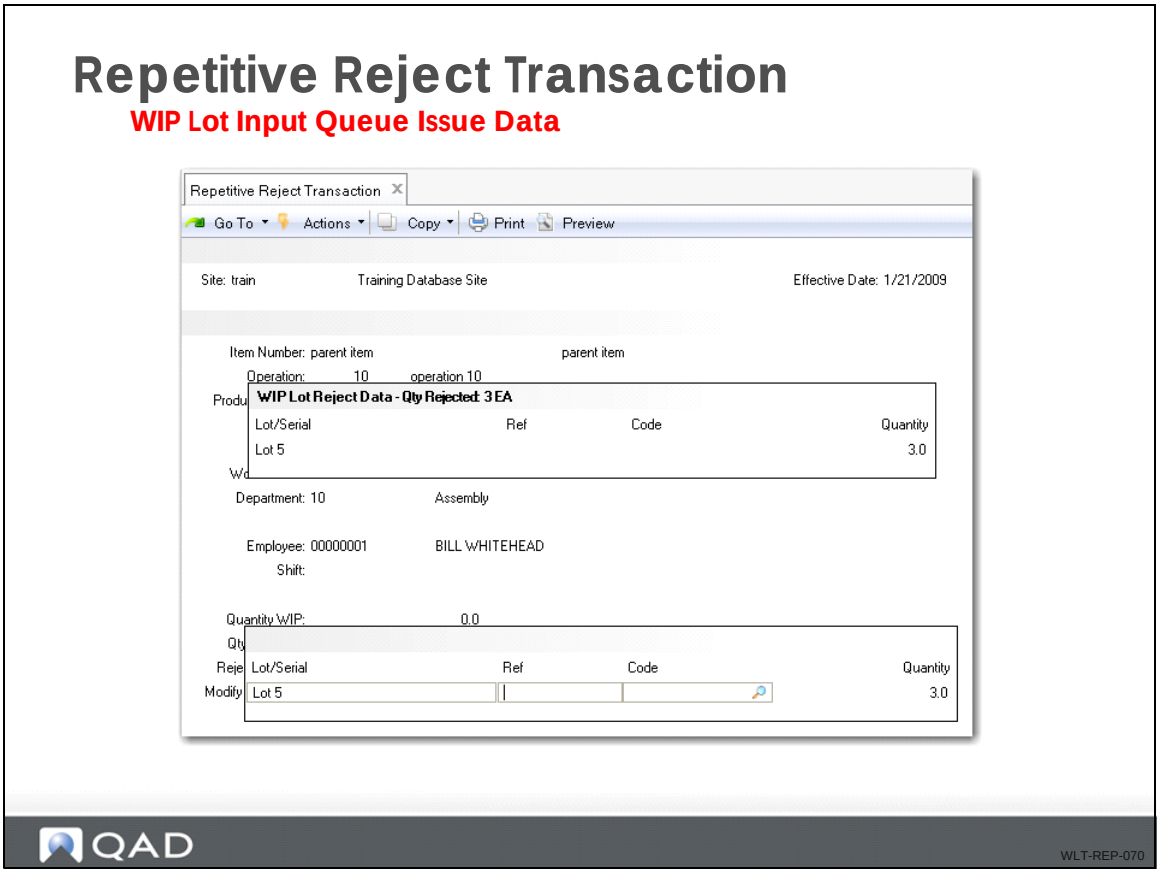
Repetitive Labor Transaction



Use Repetitive Labor Transaction to report production activity (input, output, reject) at repetitive manufacturing operations. When WLT is active, the following WLT data collection frames display:

- Destination Work Center and Machine
- WIP Lot Input Queue Issue Data
- WIP Lot Output Queue Receipt Data
- WIP Lot Reject Data
  - Appears only if you enter a value in the Qty Reject field

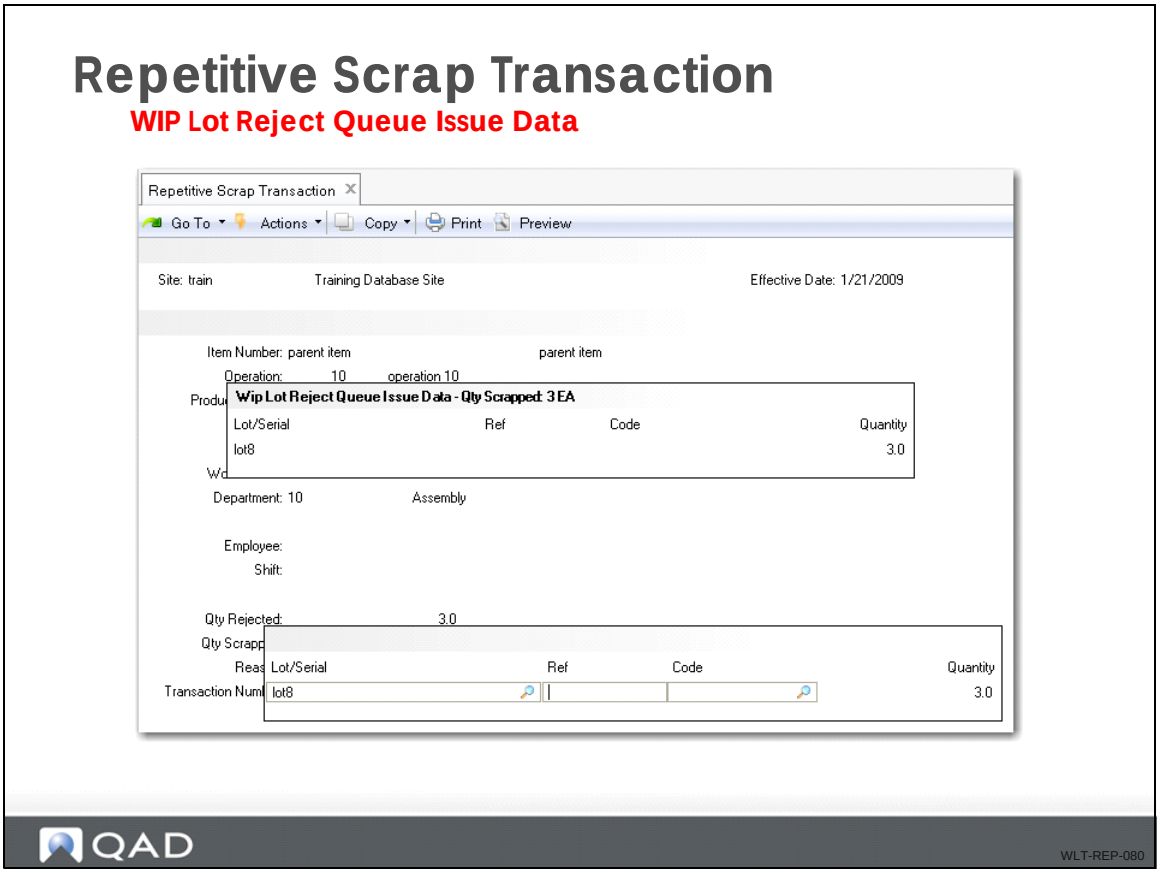
Repetitive Reject Transaction



Use Repetitive Reject Transaction to enter reject material information for an operation. The following WLT data collection frames display:

- WIP Lot Input Queue Issue Data
- WIP Lot Reject Data

Repetitive Scrap Transaction

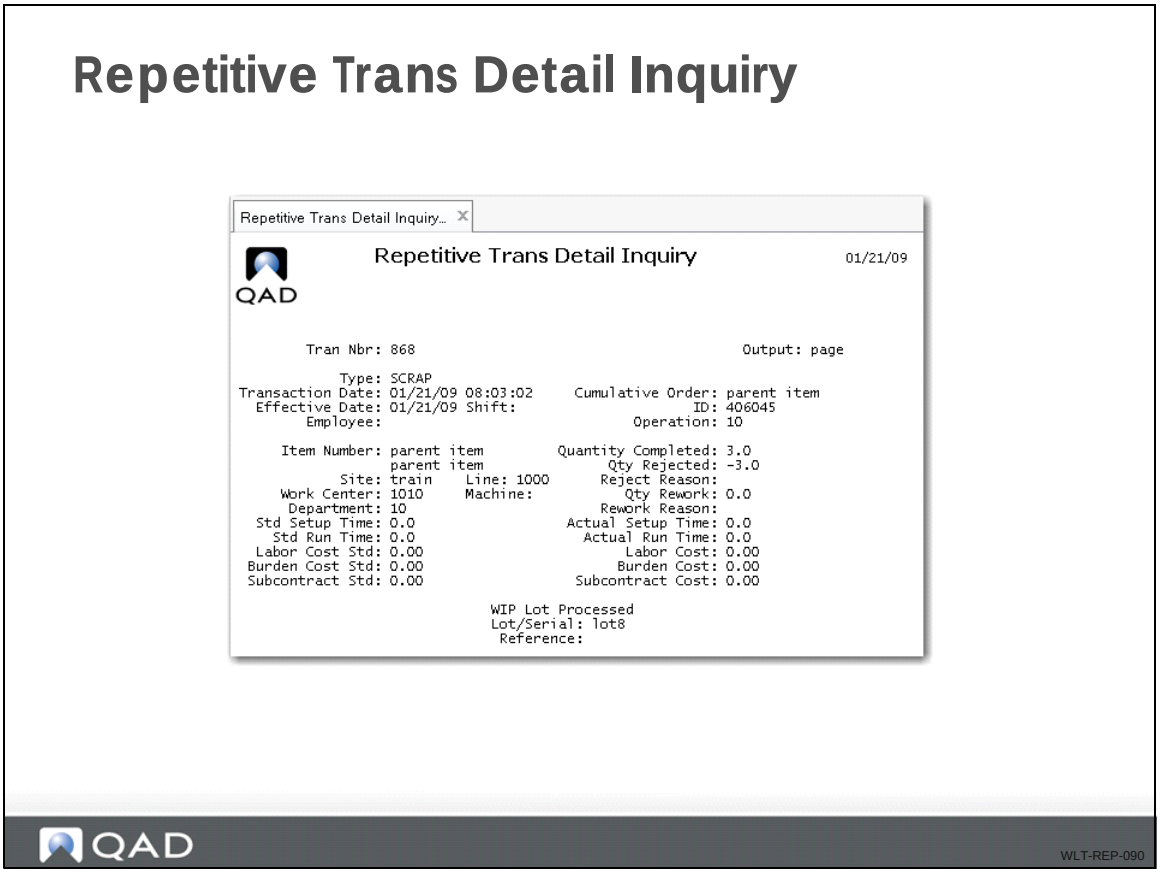


Use Repetitive Scrap Transaction to scrap or remove WIP quantities of an operation. The following WLT data collection frame appears:

- WIP Lot Reject Queue Scrap Data

The system updates tracing history records and WIP lot/serial QOH balances.

Repetitive Trans Detail Inquiry



Use Repetitive Trans Detail Inquiry to display WIP lot/serial information connected with an operation history record. Also displayed are:

- Tracing records associated with the operation history record
- WIP lot/serials recorded by a scrap, reject, rework, or adjust transaction

Exercise: Use WIP with Repetitive

Setup

Before proceeding, you need to enable the system to use Repetitive. The first step will be to report all expired or open Advanced Repetitive cumulative orders. The next step will be to close them. The next step will be to delete them. The last step is to set the control file such that Advanced Repetitive is no longer enabled.

1 Use Cumulative Order Report (18.22.8) to get a list of all cumulative orders and their end-effective dates.

2 Use Cumulative Order Close (18.22.10) to close the cumulative order for each different end effective date.

Field	Data
End Effective	[End effective date of the cumulative orders being closed]
Transfer WIP	No
Update	Yes

3 Use Cumulative Order Maintenance (18.22.6) to delete all cumulative orders.

4 Use Repetitive Control (18.22.24) to turn off new repetitive by setting Enable New Repetitive to No.

Labor Transaction

Use this function to issue material and labor and record completions at the third operation. It is very similar in concept to the Advanced Repetitive Backflush Transaction. Use Repetitive Labor Transaction (18.14) to record labor feedback.

Field	Data
Employee	[Use your Down Arrow to select the first record]
Site	10-200
Item Number	02001
Op	30
Production Line	2130
Qty Completed	3

5 Advance to the Issue Data Input frame and for the component item listed enter:

Field	Data
Quantity	3
Lot/Serial	30-1

6 Advance to the WIP Lot Input Queue Issue Data frame and enter the following:

Field	Data
Lot/Serial	30-1
Ref	[Blank]
Qty	3

7 Advance to the WIP Lot Output Queue Receipt Data frame and delete the default entry.

8 In the WIP Lot Output Queue Receipt Data frame enter the following:

Field	Data
Lot/Serial	30-1
Ref	[Blank]
Qty	3

9 Use Repetitive Trans Detail Inquiry (18.4.2) to review the repetitive transaction detail. There will be two Operation History records created of type LABOR. Select the first one.

10 The data displayed shows the material lots consumed and produced as a result of this transaction.

Note You can also use WIP Lot Convert Trans Report (3.22.13.15) to display this information.

Setup Transaction

Record setup labor against an operation. You will be prompted to enter the lot numbers of the WIP to which this reported labor will be associated.

This function is very similar to Run Labor Transaction (18.22.14) and Setup Labor Transaction (18.22.15).

1 Use Repetitive Setup Transaction (18.13) to record setup labor against an operation.

Field	Data
Employee	[Use your Down Arrow to select the first record]
Site	10-200
Item Number	02001
Op	10
Production Line	2130
Actual Setup Time	5

2 Advance to the Labor WIP Lots frame and enter 30-1 in the first Lot/Serial field.

3 Use Repetitive Trans Detail Inquiry (18.4.2) to review the repetitive transaction detail. It should default to your last transaction (LABOR).

4 Review the WIP Lot Trace Data. The data displayed shows the WIP lot/serial entered with a quantity of 0.0 (zero). This tracing record is created in order to associate the reported labor with the “production” of the WIP lot/serial.

Reject Transaction

This function lets you issue material and labor, record completions at an operation, and immediately disposition the completed material as rejected. The completed WIP material will be placed in the Reject Queue of the operation, where it waits for disposition by the user (either scrap or rework).

1 Use Repetitive Reject Transaction (18.17) to record the completions.

Field	Data
Site	10-2--
Item Number	02001
Operation	30
Production Line	2130
Employee	[Use your Down Arrow to select the first record]
Qty Reject	3

2 Advance to the Issue Data Input frame and for the component item listed enter:

Field	Data
Quantity	3
Lot/Serial	30-1

3 Advance to the WIP Lot Input Queue Issue Data frame, enter the following:

Field	Data
Lot/Serial	30-1
Ref	[Blank]
Qty	3

4 Advance to the WIP Lot Reject Data frame, delete any default entry, and enter the following:

Field	Data
Lot/Serial	30-1
Ref	[Blank]
Qty	3

5 Use Repetitive Trans Detail Inquiry (18.4.2) to review the repetitive transaction detail. There will be two Operation History records created of type LABOR. Select the first one.

6 Review the WIP Lot Trace Data. The data displayed shows the material lots consumed and produced as a result of this transaction. Select the second one.

7 Review the WIP Lot Processed. This shows the rejected WIP lot/serial entered above.

Note You can also use WIP Lot Non-Convert Trans Report (3.22.13.16) and WIP Lot Convert Trans Report (3.22.13.15) to display this information.

8 Use WIP Lot Inventory Status Report (3.22.13.13) to run the WIP Lot Inventory Status Report by entering the cumulative order ID in the ID and To fields. You can use the Lookup icon to select the cumulative order ID.

9 Review the report. You will see the rejected WIP lot in the operation's reject queue.

Rework Transaction

Change the disposition of rejected material back to good material. For WIP lot/serials, this involves moving them from the reject queue of the reporting operation to the input queue of the following operation. If at the last operation, it involves moving to finished material inventory.

1 Use Repetitive Rework Transaction (18.16) to change the rejected material back to good material, enter the following:

Field	Data
Employee	[Use your Down Arrow to select the first record]
Site	10-200
Item Number	02001
Operation	10
Production Line	2130
Qty Rework	3

2 Advance to the WIP Lot Rework Data frame. Enter 30-1 in the Lot/Serial field and in the Reworked Lot/Serial field enter 30-1R.

3 Use Repetitive Trans Detail Inquiry (18.4.2) to review the repetitive transaction detail. It should default to your last transaction (LABOR).

4 Review the WIP Lot Processed frame. This lists the WIP lot/serial processed by this transaction.

5 Review the WIP Lot Trace Data frame. The data displayed shows the material lots consumed and produced as a result of your rework transaction. This tracing data is recorded only because the entered Reworked Lot/Serial value is different from the Lot/Serial value.

Note You can also use WIP Lot Non-Convert Trans Report (3.22.13.16) and WIP Lot Convert Trans Report (3.22.13.15) to display this information.

Scrap Transaction

Use this function to scrap material previously rejected. For WIP lot/serials, this entails reducing their QOH balances at the reject queue of the reporting operation.

1 Use Repetitive Scrap Transaction (18.18) to scrap the rejected material.

Field	Data
Site	10-200
Item Number	02001
Operation	10
Production Line	2130
Qty Scrapped	3

2 Advance to the WIP Lot Reject Queue Issue Data frame. Click the Lookup icon to display a list of WIP lot/serials at that operation. Select one and enter 3 in Qty.

Note You can enter a non-existent WIP lot/serial if necessary.

3 Use Repetitive Trans Detail Inquiry (18.4.2) to review the repetitive transaction detail. It should show your last transaction (SCRAP) as the default.

4 Review the WIP Lot Processed frame. This shows the WIP lot/serial that was scrapped by this transaction. Note that there will be one Operation History record written for each WIP lot/serial scrapped.

Note You can also use WIP Lot Non-Convert Trans Report (3.22.13.16) to display this information.