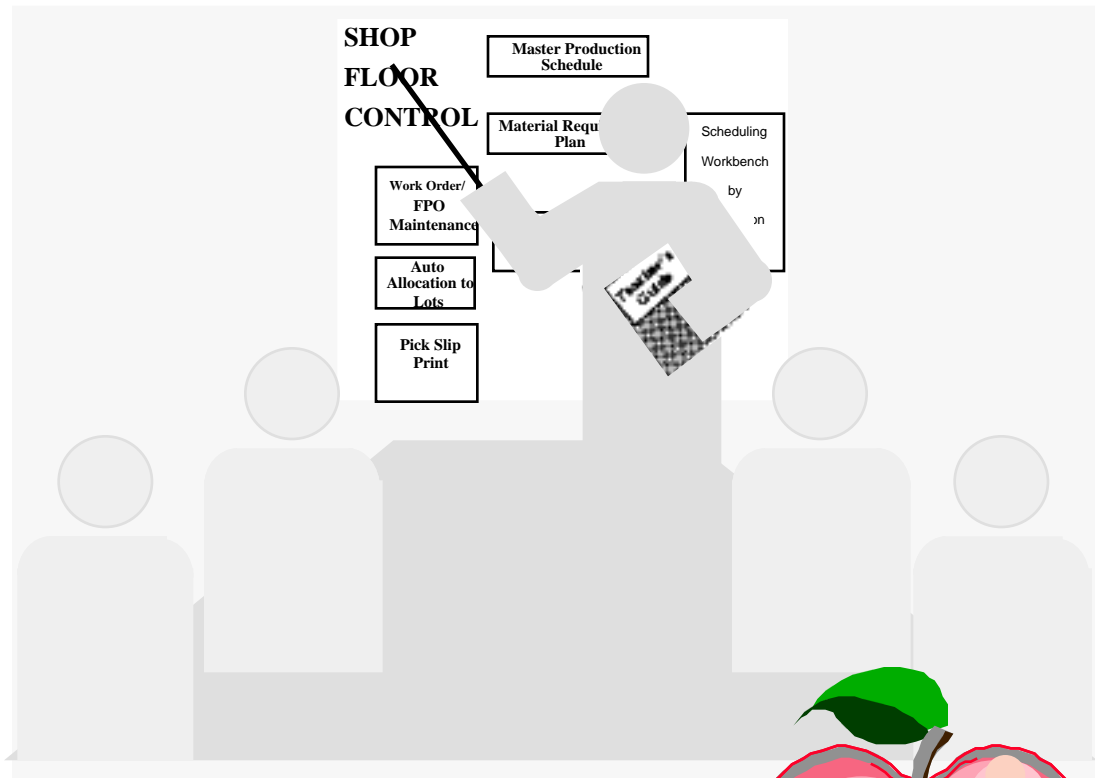
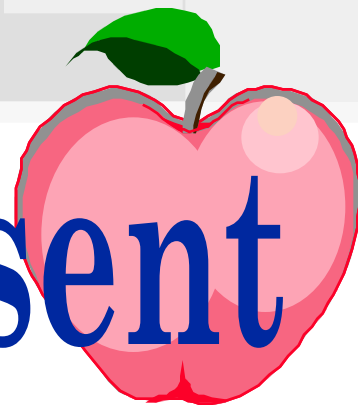


PRMS™ Router Training



RMS/Present



Version 2.3

A Product of

MXB - Managing the Business

100 N. Freeman Road

Tucson, AZ 85748

(520) 886-5914

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Sample Agenda

Morning

Router Concepts and Impacts
Pre-Requisite Master Files

Workshop

Afternoon

Routing Maintenance

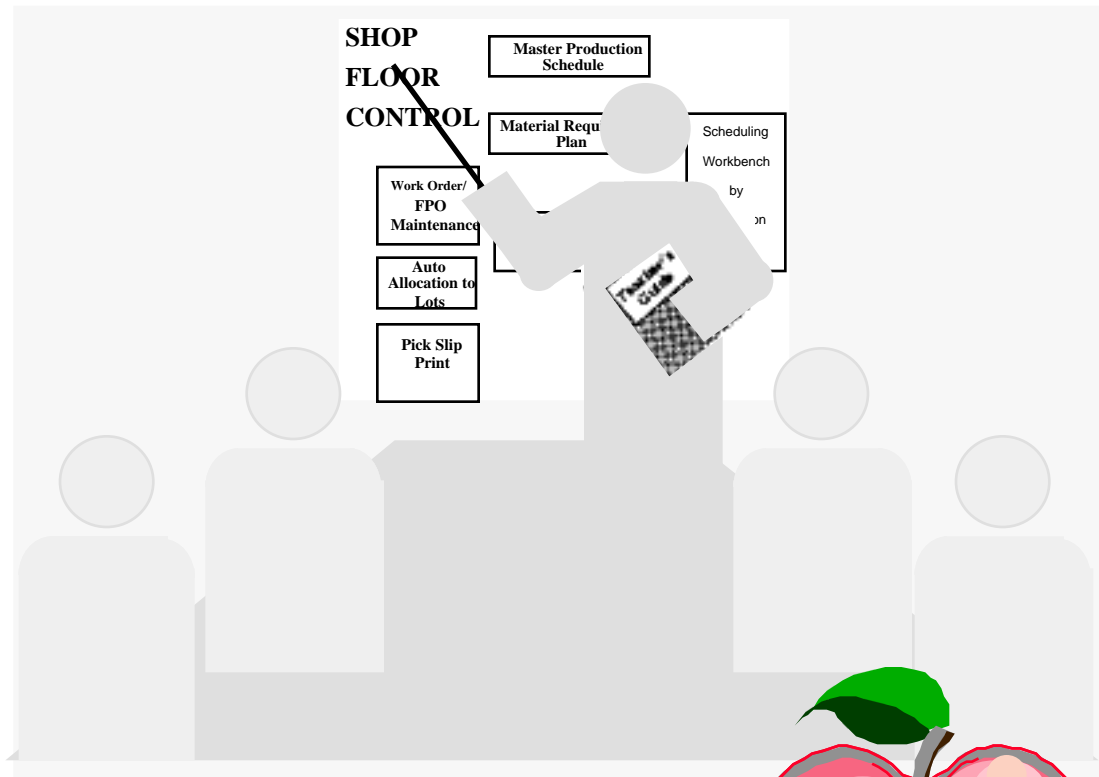
Workshop

Outside Operations

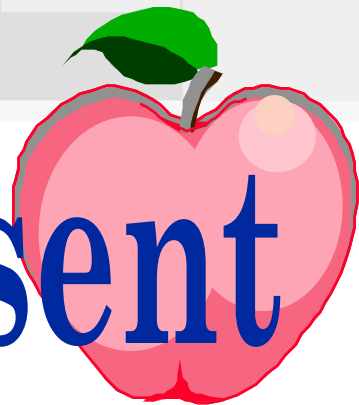
Policy and Procedure Review

Routings

And the Necessary Shop Data Functions to Support Them



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What Is a Router?

Describes and Defines the Manufacturing Process

**BY OPERATION, WHERE, HOW, AND HOW LONG THE
PROCESS IS**

DEFINES THE VALUE ADDED COSTING

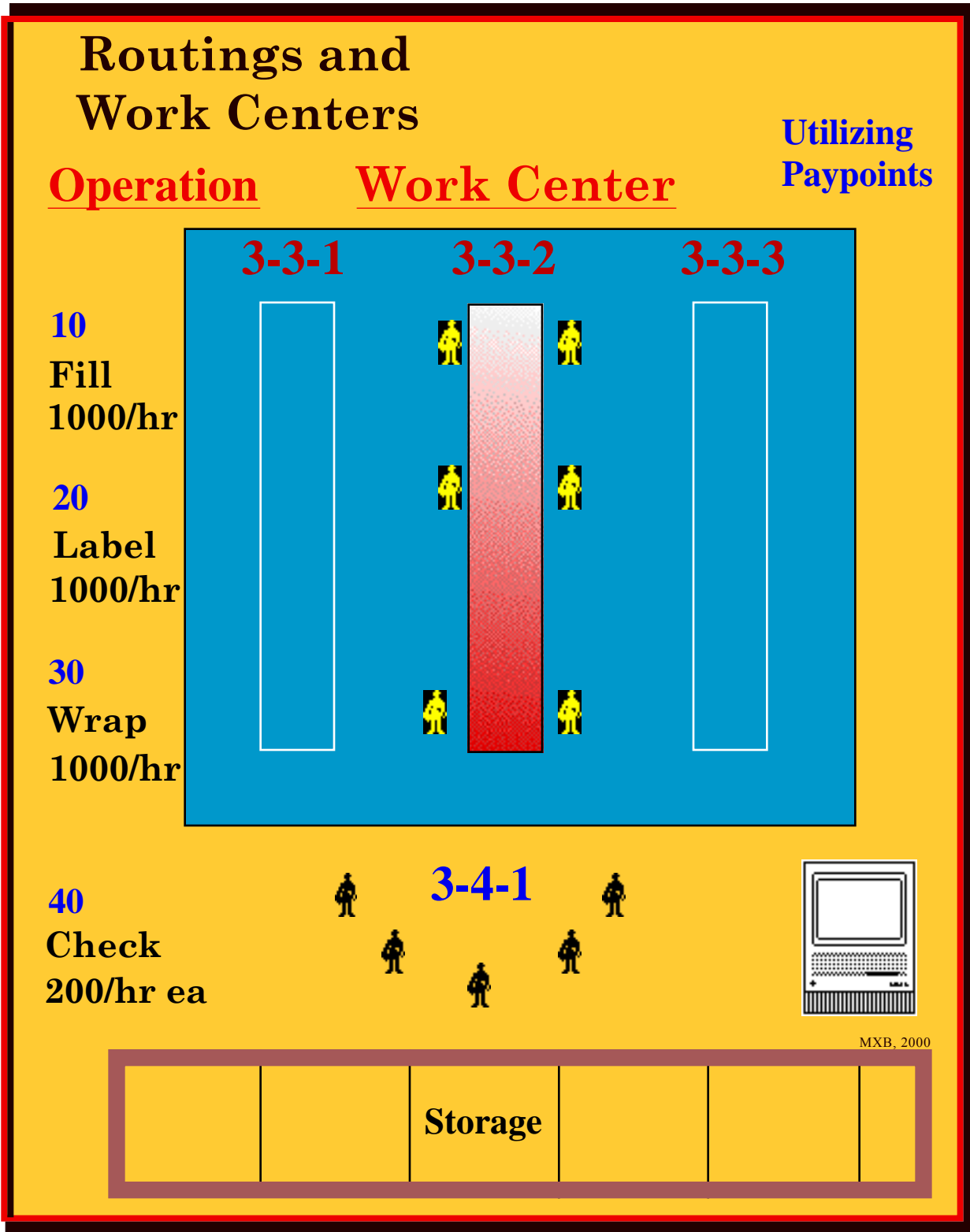
Base, Current, Going To

Labor, Setup, Burden (5), Outside Operation

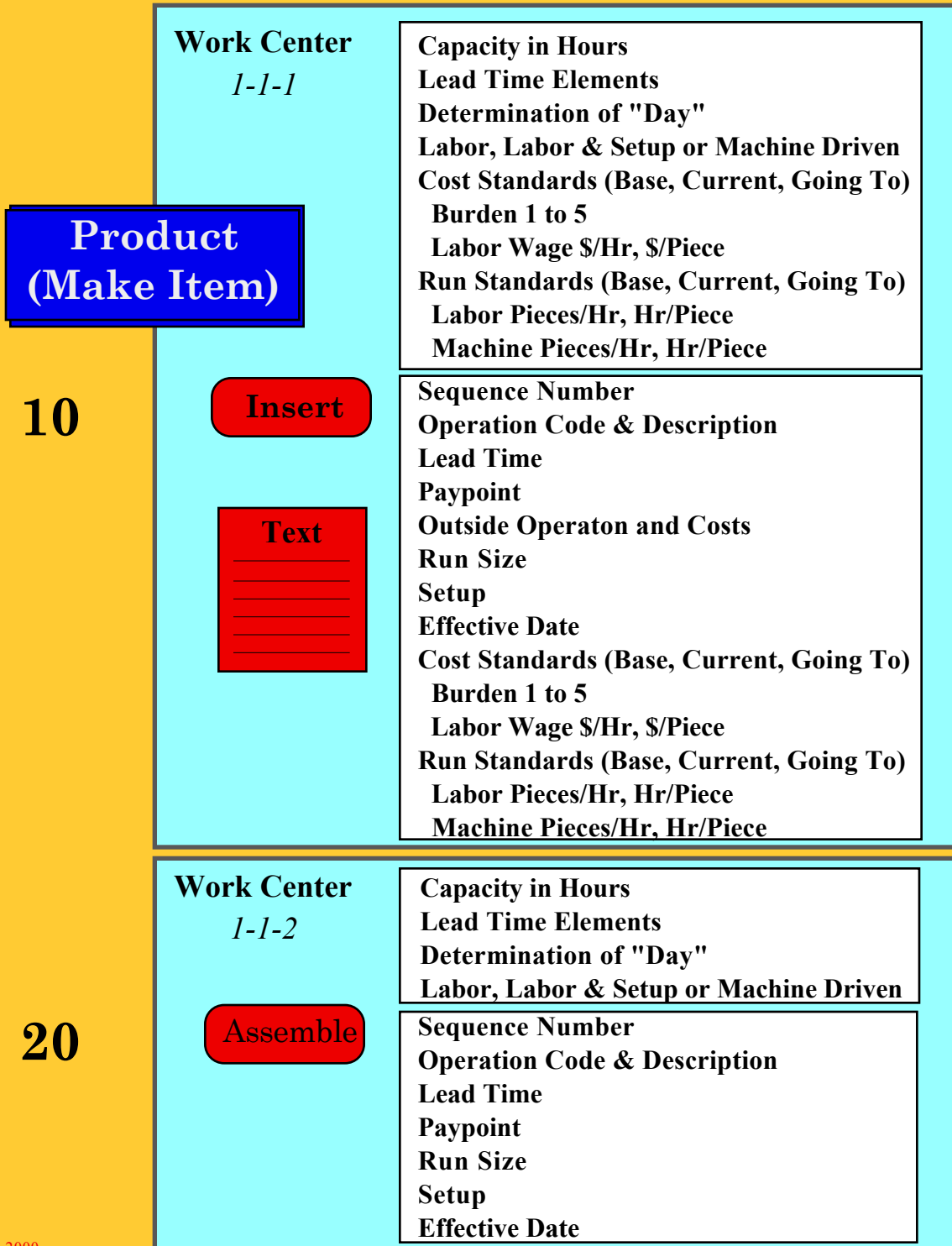
**DEFINES WHICH OPERATIONS THAT QUANTITY GOOD
AND QUANTITY SCRAPPED IS EXPECTED TO BE
REPORTED**

**DRIVES LOAD FOR CAPACITY REQUIREMENTS
PLANNING**

What Is a Router?



What is a Router?



MXB.2000

Concepts & Features

**LABOR AND BURDEN STANDARDS AT PRODUCT
OPERATION OR WORK CENTER LEVEL**

PAY POINT DESIGNATION

CALCULATED OR STATIC OPERATION LEAD TIMES

**If Calculated, separate Queue, Move, Setup and Run
Time Components**

INSIDE AND OUTSIDE OPERATIONS

ALTERNATE ROUTING STEPS

PRODUCT OR OPERATION SHRINK

JOB SPECIFIC AND GENERIC PROCESS TEXT *8.3*

Impacts on the Integrated System

SHOP FLOOR

**What, Where and How Production is Scheduled
Process Instructions**

Considerations

Configuration of Work Centers

Operation Lead Times

Material Delivery Methods

Determination of Paypoints

Type of Manufacturing Order/Schedule

Overhead and G/L Responsibility

Performance Measurement

PRODUCT COSTS

Labor

Setup

Burden

Outside Operation Costs

Considerations

Configuration of Work Centers

Operation Lead Times

Material Delivery Methods

Determination of Paypoints

Type of Manufacturing Order/Schedule

Overhead and G/L Responsibility

Performance Measurement

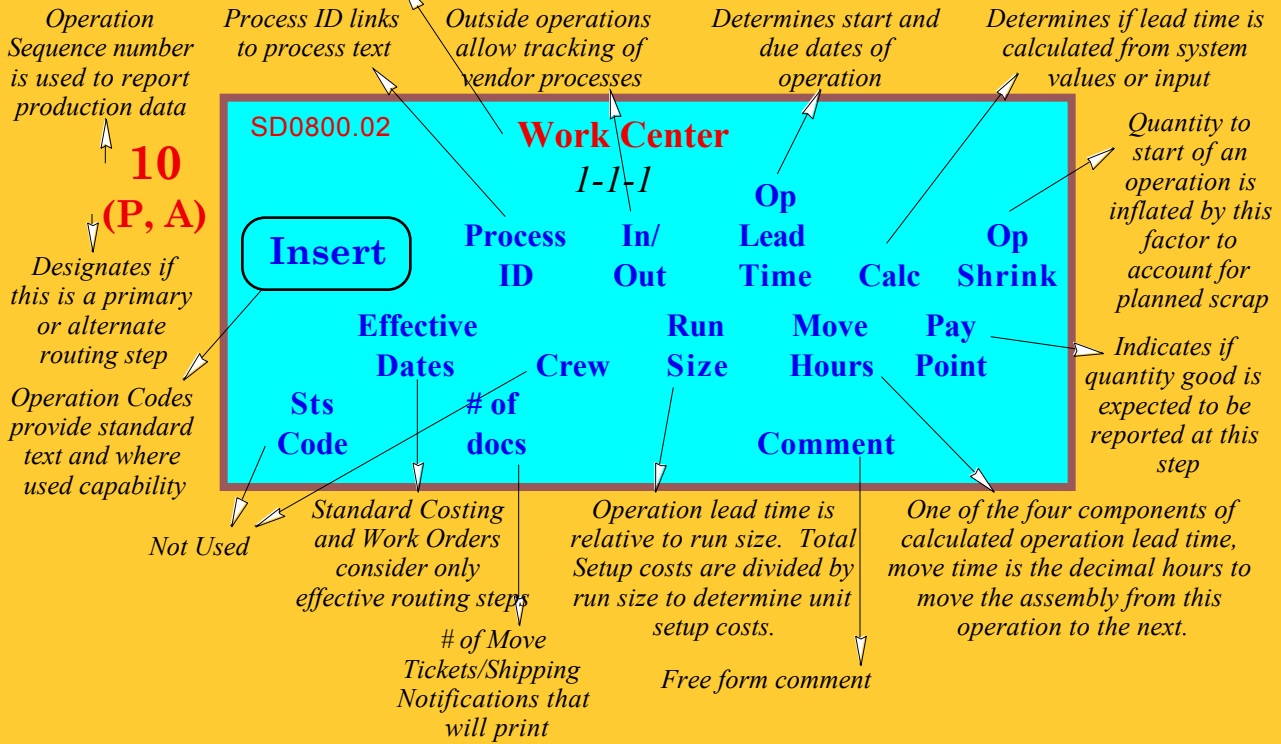
LOAD FOR CAPACITY ANALYSIS

Considerations

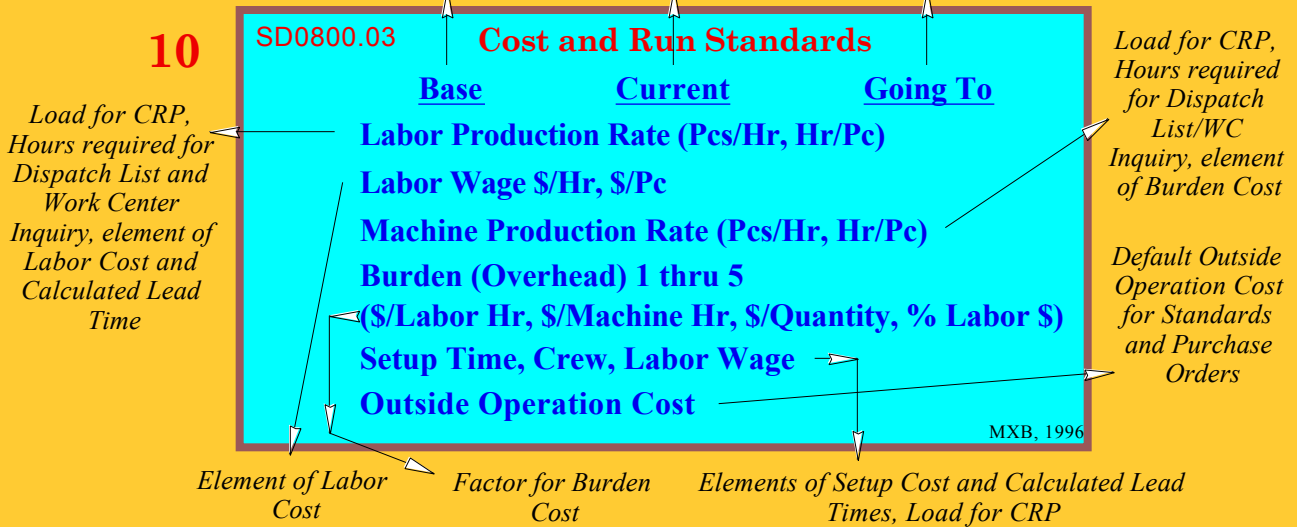
Configuration of Work Centers

Router Impacts by Field

Used by Dispatch List and Work Center Inquiry for scheduling, Material Pick List for delivery of components, WIP Valuation Report, Shortage Reporting selection, CRP for capacity center.



Values for Base (frozen) standard are used by Standard Cost Update to determine total standard cost, the standard from which variances are measured. Current standard is used as default for work order standards. Going To is for next year standards development.



Product Master

(MS0825)

ITEM TYPE - MAKE

MANUFACTURING METHOD

1 - Discrete - 1

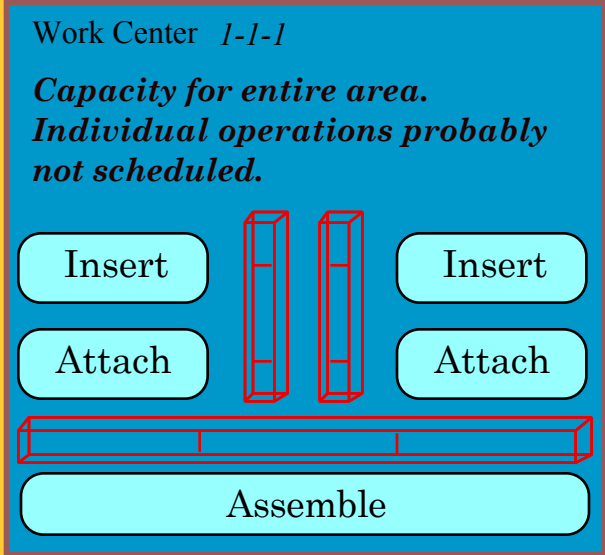
Discrete utilizes Work Orders for the execution of manufacturing. Work Orders consist of a bill of materials and a router. Operations of the router are back scheduled from the order due date by the operation lead time to yield a start date and due date for each operation. Component materials may be designated to be "first op where used" so that deliveries may be made to specific operations in the work center.

2 - Repetitive - 2, 3

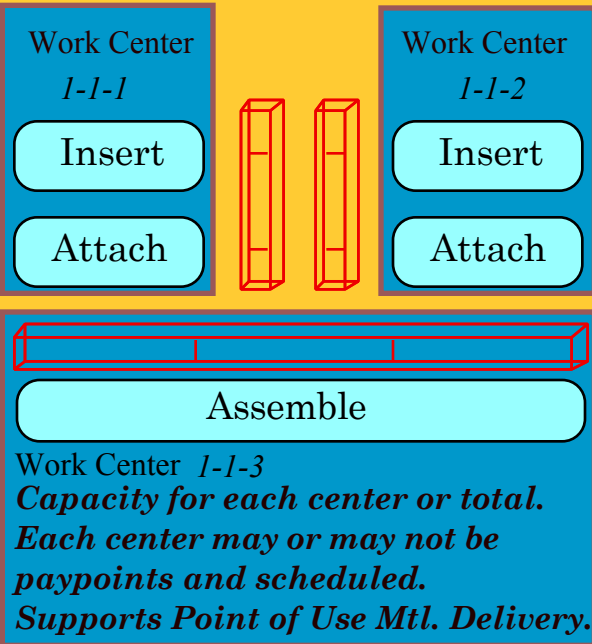
Repetitive items are scheduled with the Production Scheduling Workbench (SF0310) via Production Lines that are defined by a rate per hour and number of hours available per shift. A "run" is backward or forward scheduled according to the capacity of the line (or product) according to a single threaded application of the capacity to the schedule. The execution orders are Flow Orders and Orderless Shop Floor schedules. Requires establishment of Production Line (SD0301).

Work Center Perspectives

Discrete (Mfg Method 1)

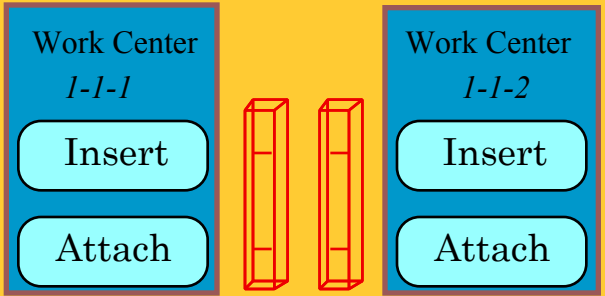


Work Orders (SF0010, SF0019)



MXB, 1996

Repetitive (Mfg. Method 2, 3)



Flow Orders
Orderless Production Schedules (SF0310)

Single threaded finite scheduling expressed in rates per hour at Production Line or Product Master. Each Production Line has its own calendar to determine capacity by shift.



Work Center 1-1-3

*Production is scheduled with Scheduling Workbench.
Overlays work centers and operations for standard costing.*

Lead Times are a result of production rate, not the lead times in the router.

Work Center Maintenance

(SD0801, MFWKP100)

WORK CENTER NUMBER

TWO DESCRIPTIONS

NUMBER OF SHIFTS

NUMBER OF MACHINES

WORK CENTER BUILDING (NAME)

OF EMPLOYEES PER JOB

Used as factor in calculating operation lead times for work centers that have a prime load code of labor or labor and setup.

OF MACHINES PER JOB

Used as factor in calculating operation lead times for work centers that have a prime load code of machine.

MOVE AND QUEUE TIME IN DECIMAL HOURS

For each shift

PLANNED LENGTH

Used by CRP and used to determine how many hours in a day when converting operation lead times in decimal hours to decimal days.

PLANNED # EMPLOYEES

PLANNED CAPACITY

USED BY CRP

MAXIMUM CAPACITY

MAXIMUM # EMPLOYEES

MAXIMUM CAPACITY

UTILIZATION

EFFICIENCY

Input Fields

(SD0801)

Used in Work Center Performance Mgr.'s Report

TYPE OF MEASUREMENT (LABOR HOURS, MACHINE HOURS, QUANTITY)

POINT OF CALCULATION (WHEN OPERATION IS COMPLETE, AS SOON AS REPORTED)

TYPE OF TOLERANCE (% OF MEASUREMENT, UNITS OF MEASUREMENT)

Used by CRP

CRITICAL RESOURCE (LIMITED, UNLIMITED-CALCULATE LOAD, UNLIMITED-DO NOT CALCULATE LOAD)

PRIME LOAD CODE (MACHINE, LABOR, LABOR AND SETUP)

G/L Accounts

Material Usage Variance

Labor Price Variance

Labor Usage Variance

Factory Overhead Efficiency Variance

Factory Overhead Applied

Factory Wages Payable

Abnormal Scrap

Standards

Discussed in Routing Maintenance

Operation Code Maintenance

(SD0802, SFOPP100)

Code to Identify Standard Operation Text

Attached to Routing Step

CODE ID

SHORT DESCRIPTION

LONG DESCRIPTION

Production Line Maintenance

(SD0301, MFLIP100)

FOR REPETITIVE MAKE ITEMS, THE PRIMARY PRODUCTION LINE WHERE THIS ITEM IS SCHEDULED

SCHEDULER ID

Capacity calculations and access in Production Scheduling Workbench (SF0310) is by Scheduler ID

GATEWAY WORK CENTER

The first or gateway work center the production line passes through

STANDARD LINE RATE (BY SHIFT)

The default quantity per hour that can be produced. May be overridden in Product Master

SHIFT LENGTH (BY SHIFT)

Default hours of run time in a shift. Used for capacity calculations and as default when creating the Line Calendar (SF0312).

DEFAULT SET-UP TIME

Amount of time that is added by default to each order that is scheduled to consume capacity. May be overridden in Scheduling Workbench (SF0310).

PRODUCT # FOR LABOR TRANSACTIONS

Not used

IN USE FLAGS

Indicates if the Batch Order Create or Scheduling Workbench functions are currently in use

(SF0330)

Batch Request function to create or update calendars used by Production Scheduling Workbench

REQUEST SELECTION

Line

Shop Calendar (Y,N)

Use the Shop Calendar as Default or use from Line Selected

Starting Month/Year

Update Changed Only

If "Y", only specific shifts that have been updated in current session are updated, preversing any previously customized settings

Add Calendar

When there is not a calendar for a selected line in a month/year, add the calendar or ignore

UPDATE REPORT AVAILABLE UPON REQUEST

Rate Code Maintenance

(SD0803, MFRCP100)

Defines Values to Maintain Work Center or Router Standards

RATE CODE

RATE DESCRIPTION

TYPE OF RATE

- 1 - Labor Production (1 or 2)**
- 2 - Machine (1 or 2)**
- 3 - Burden (3 through 6)**
- 4 - Outside Operation (8)**
- 5 - Labor Wage (3 or 8)**

TIME BASIS

- 1 - Pieces per Hour**
- 2 - Hours per Piece**
- 3 - \$ per Labor Hour**
- 4 - \$ per Machine Hour**
- 5 - \$ per Quantity Produced**
- 6 - % of Labor Dollars**
- 8 - \$ per Unit**

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Education & Reference					
General			Manufacturing		
Welcome to PRMS	99.00	199.00	Product Definition	199.00	349.00
PRMS Overview	199.00	349.00	Manufacturing Planning	199.00	349.00
Version 9 Enhancements	99.00	199.00	Shop Floor Control	199.00	349.00
'Canned' Reports & Inquiries	99.00	199.00	Router Training	149.00	299.00
Distribution			Inventory		
Forecasting Workbench	149.00	299.00	Inventory Control	99.00	199.00
Customer Order Processing	199.00	349.00	Cycle Count & Phys. Inv.	99.00	199.00
Order Entry Training	149.00	299.00	Lot Control	99.00	199.00
RGA's & C/D Memos	149.00	299.00	Financial		
Replenishment Orders	99.00	199.00	Standard Costing	149.00	299.00
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