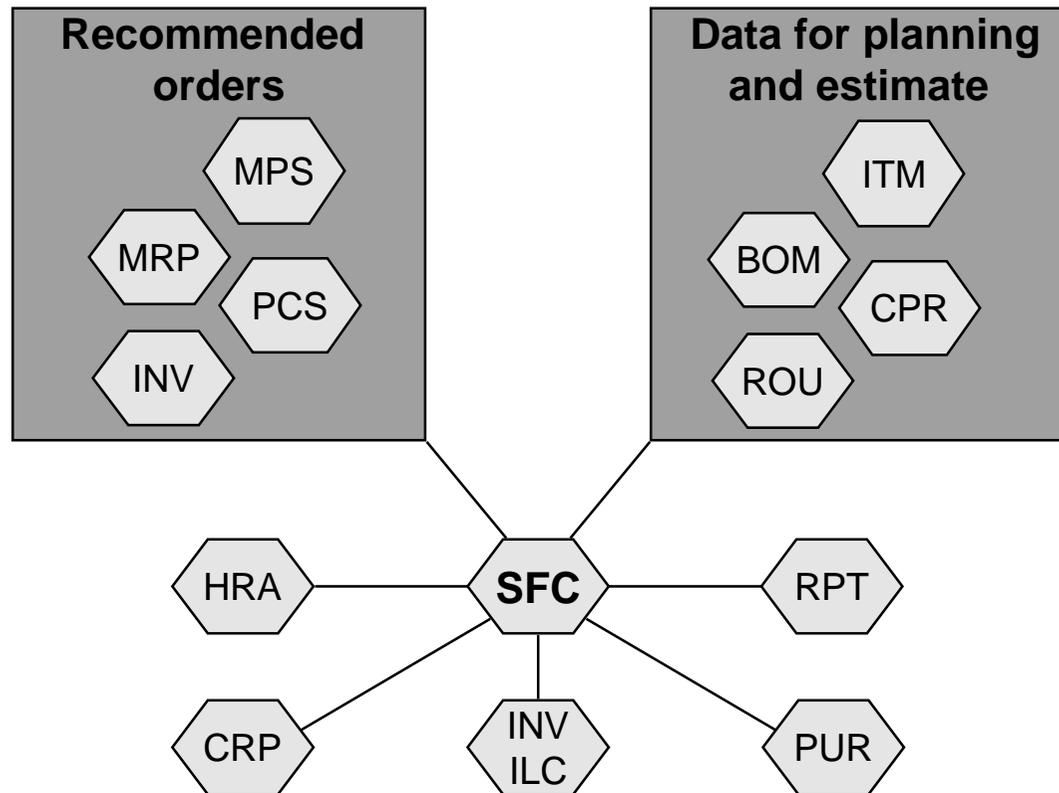
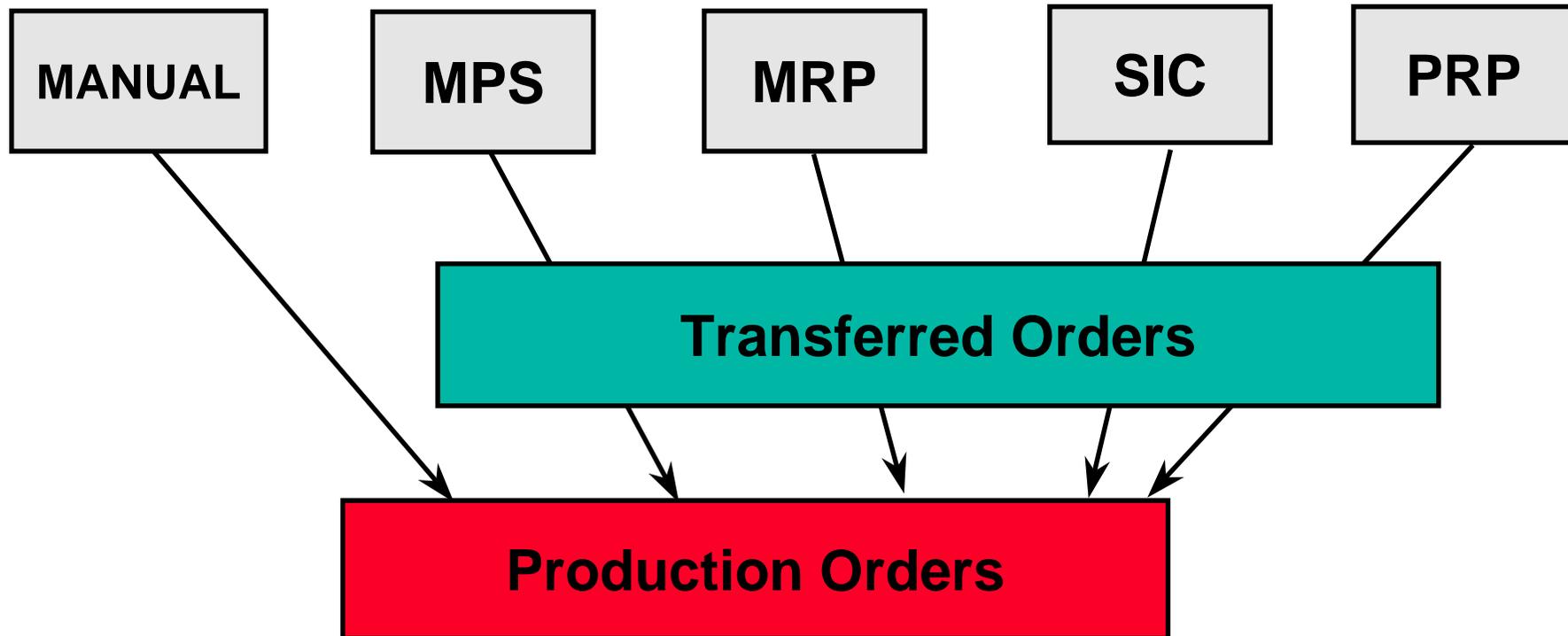

Shop Floor Control

(SFC)

Module Relationships

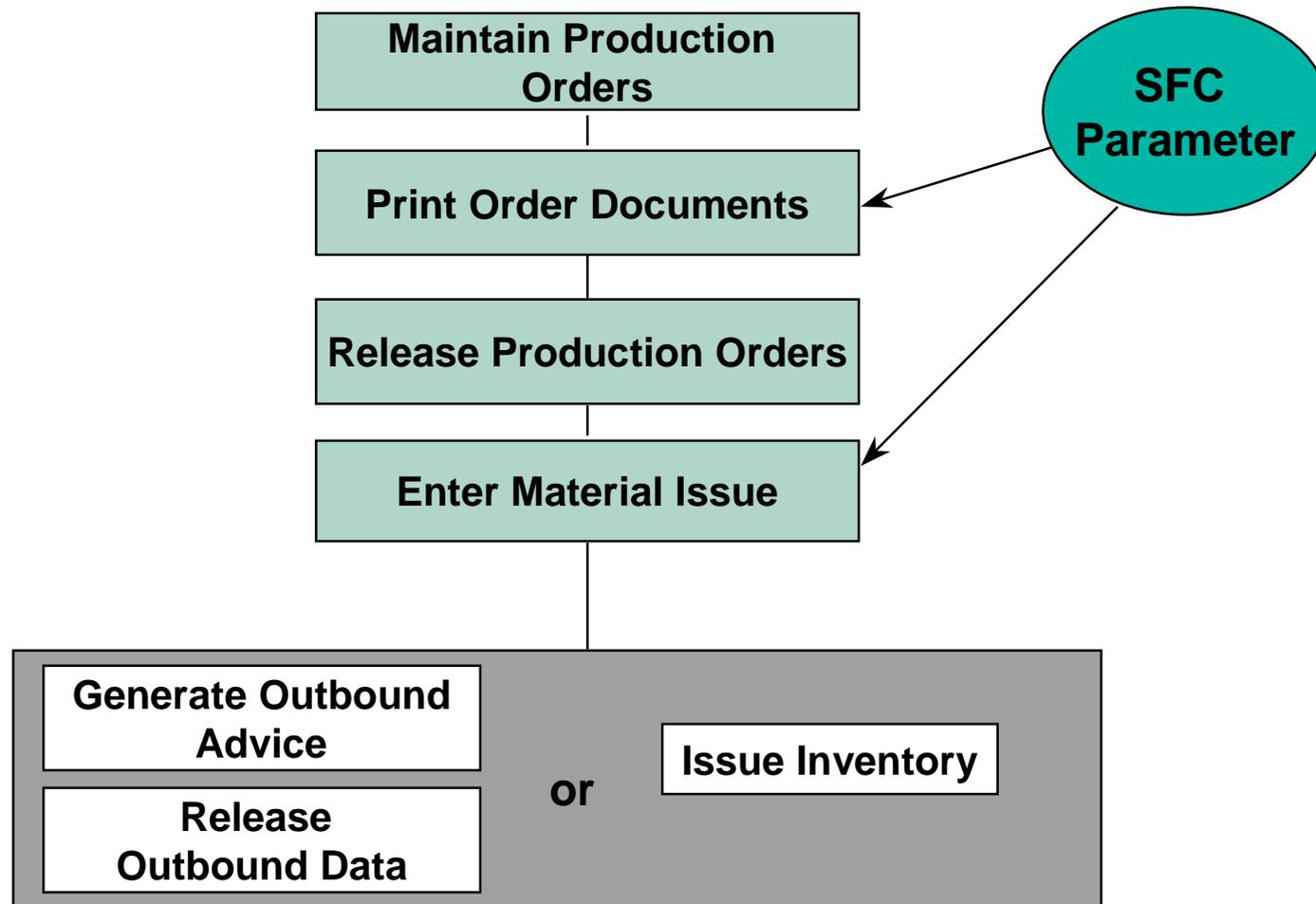


Production Order Origin



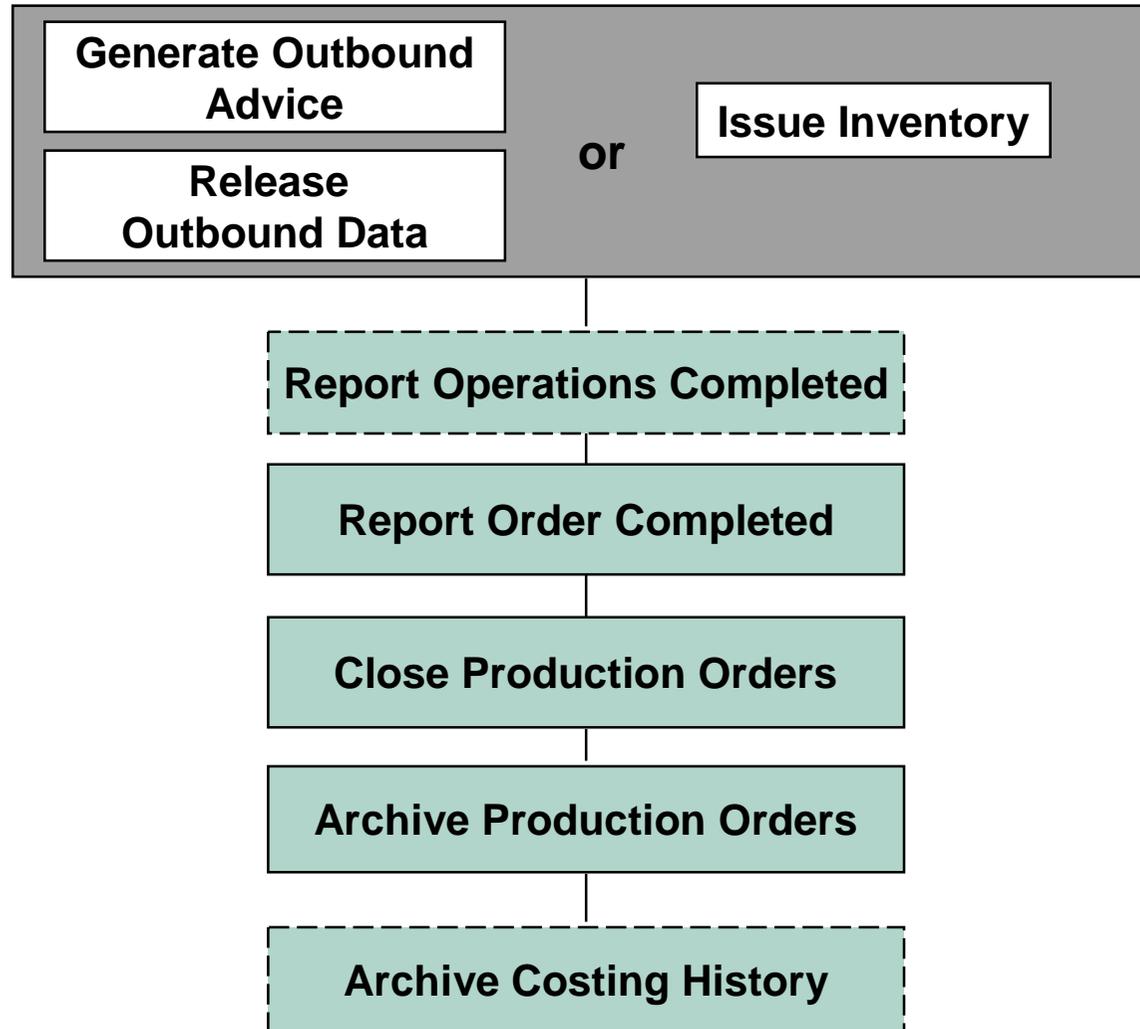
SFC Flow

Part 1



SFC Flow

Part 2



Order Status

Part 1

Maintain Production Orders
(tisfc0101m000)

planned

Print Order Documents
(tisfc0408m000)

order documents printed

Release Production Orders
(tisfc0204m000)

released

cancelled

Process Hours Accounting
(tihra1210m000)

active

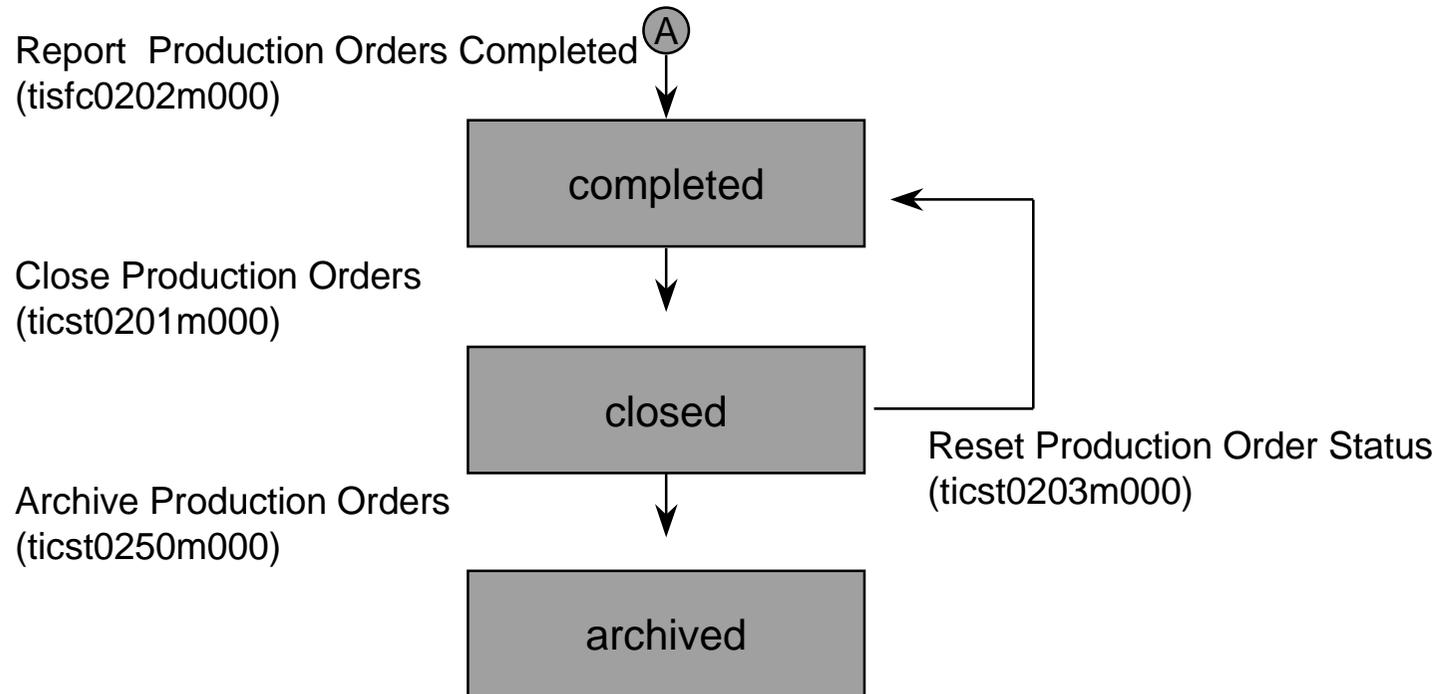
Cancel Production Orders
(tisfc0203m000)

cancelled

A

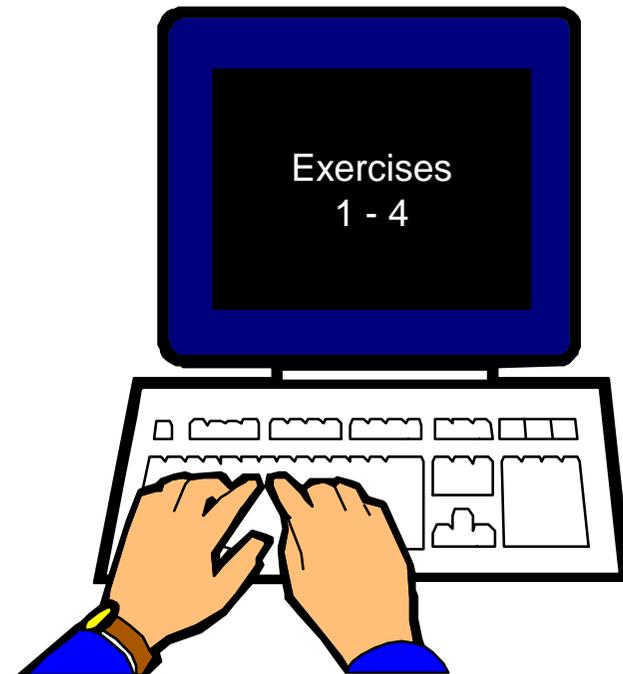
Order Status

Part 2



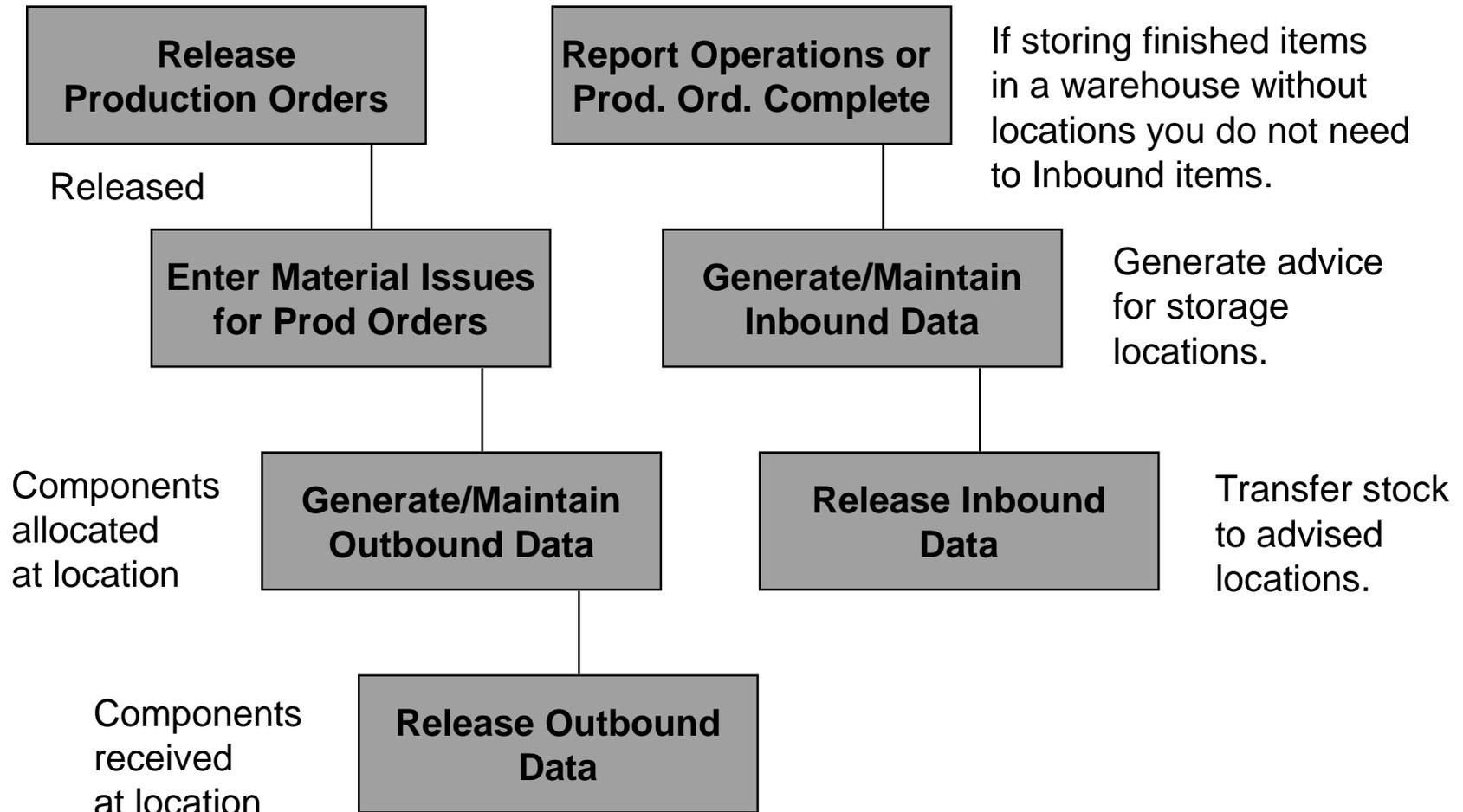
Exercises

- Define master data
- Implement ILC
- Set parameters
- Generate planned MRP orders



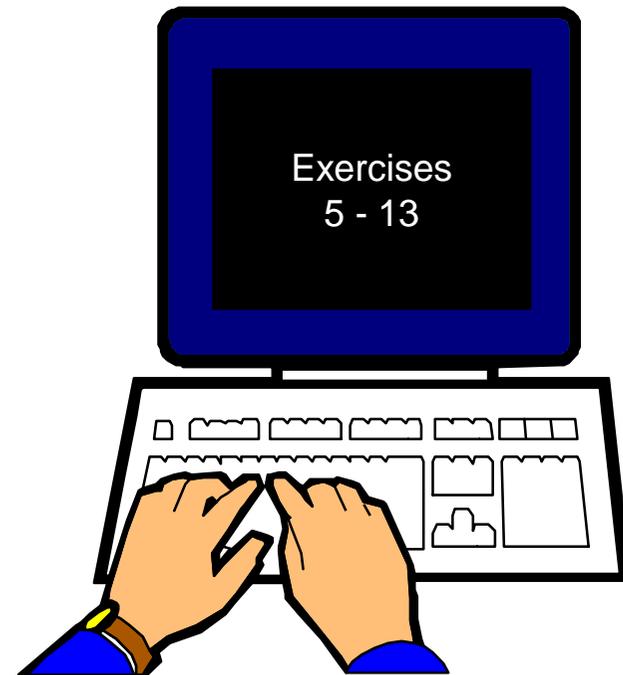
ILC Procedure

Outbounding and Inbounding Data



Exercises

- Transfer planned MRP production orders
- Process production orders



Operation Lead Time

Operation Lead-time formulas

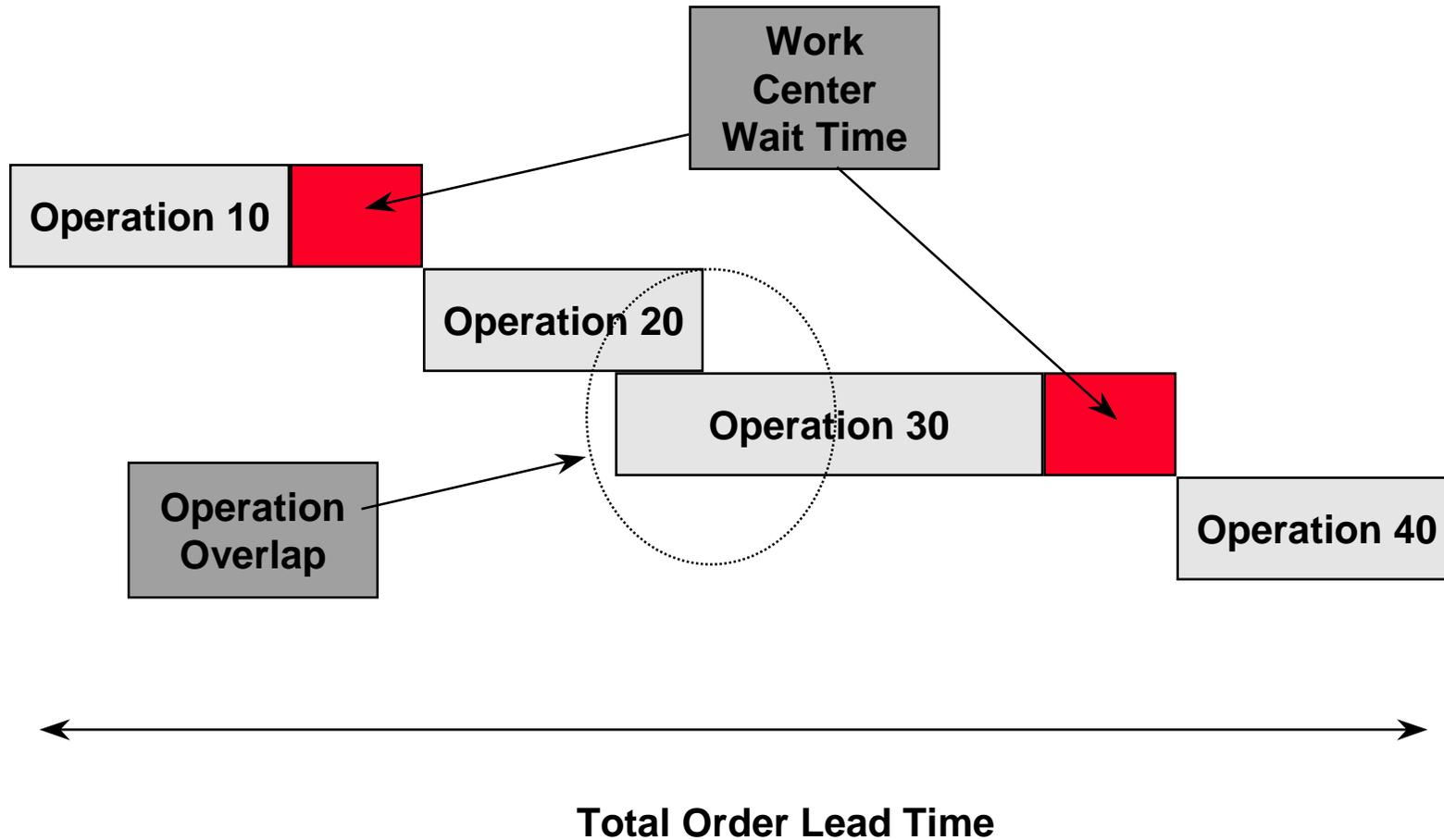
Critical Capacity Type in Work Center = Machine

$$\text{Lead Time} = \frac{\text{Setup} + (\text{Order Quantity} \times \text{Run Time})}{\text{number of resource units} \times \text{normal cap. (h/dy)}}$$

Critical Capacity Type in Work Center = Man

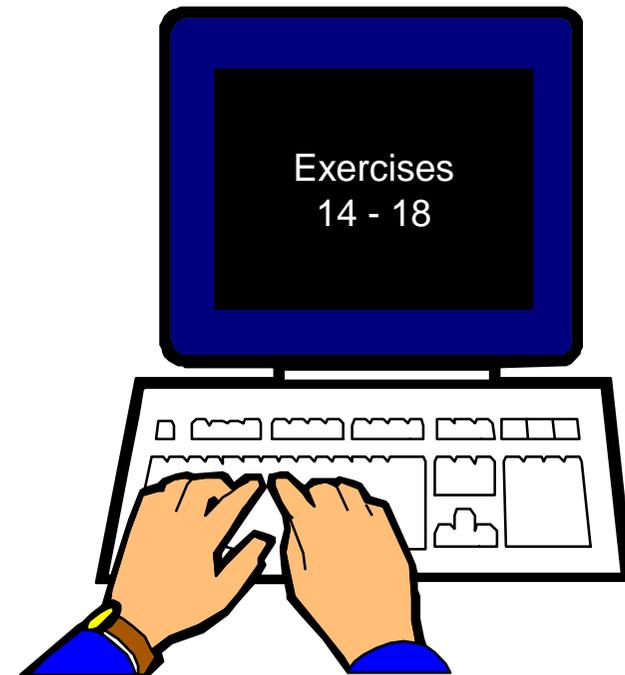
$$\text{Lead Time} = \frac{\text{Setup} + (\text{Order Quantity} \times \text{Run Time})}{\text{number of res. units} \times \text{normal cap. (h/dy)} \times \# \text{ of shifts}}$$

Order Lead Time



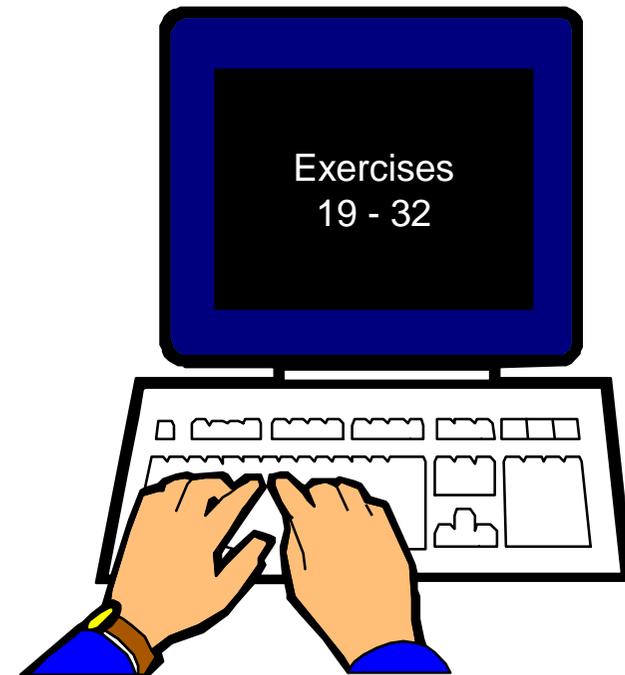
Exercises

- Plan production orders



Exercises

- Subcontract operations



Operation Time

Machine-hours:	$\frac{\text{setup time} + (\text{run time} \times \text{order quantity})}{60}$
Man-hours:	$\frac{\text{man occupation}}{\text{machine occupation}}$

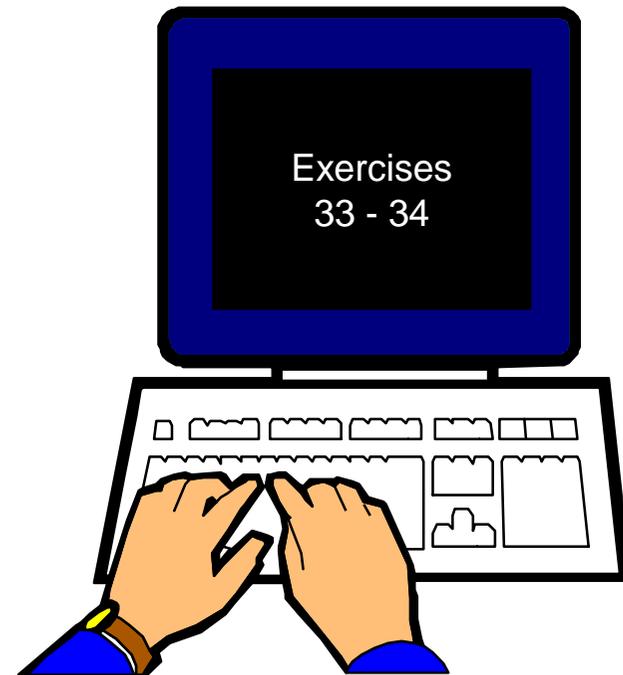
Man-hours:	$\frac{\text{setup time} + (\text{run time} \times \text{order quantity})}{60}$
Machine-hours:	0

Sources of Costs

	Standard Cost Price	Estimated Order Cost	Actual Order Costs
Material Cost	Quantity in Production BOM X Standard Cost	Quantity of Estimated Materials X Standard Cost	Actual Material Quantity Issued X Standard Cost
Labor Cost	Operation Times from Routing X Operation Rates at Work Center or Task (As defined in CPR)	Operation Times from Prod. Planning X Operation Rates at Work Center or Task (Update Cost Estimate?)	<p>If <i>Estimated Rates</i>: Operation Times as recorded in HRA X Operation Rates at Work Center or Task OR</p> <p>If <i>Man and Machine Rates</i>: Operation Times as recorded in HRA X Man Rates (Employee File) Machine Rates (Machine File) Overhead (W/C as defined in CPR)</p> <p>HRA Actual Operation Rates Parameter</p>

Exercises

- Review production order costs
- Display production order history



Backflushing Set Up

Item Default Data

Item Type:	
Item Group:	
BKFLSH MATERIALS	Y/N
BKFLSH IF MATERIALS	Y/N
BKFLSH HOURS	Y/N

Item Master

Item : 14101 SIDE PART	
BKFLSH MATERIALS	Y/N
BKFLSH IF MATERIALS	Y/N
BKFLSH HOURS	Y/N

Routing

ITEM: 14101		
<u>OPER.</u>	<u>TASK</u>	<u>BF</u>
10	2001	Y/N
20	2002	Y/N
30	2005	Y/N

Tasks

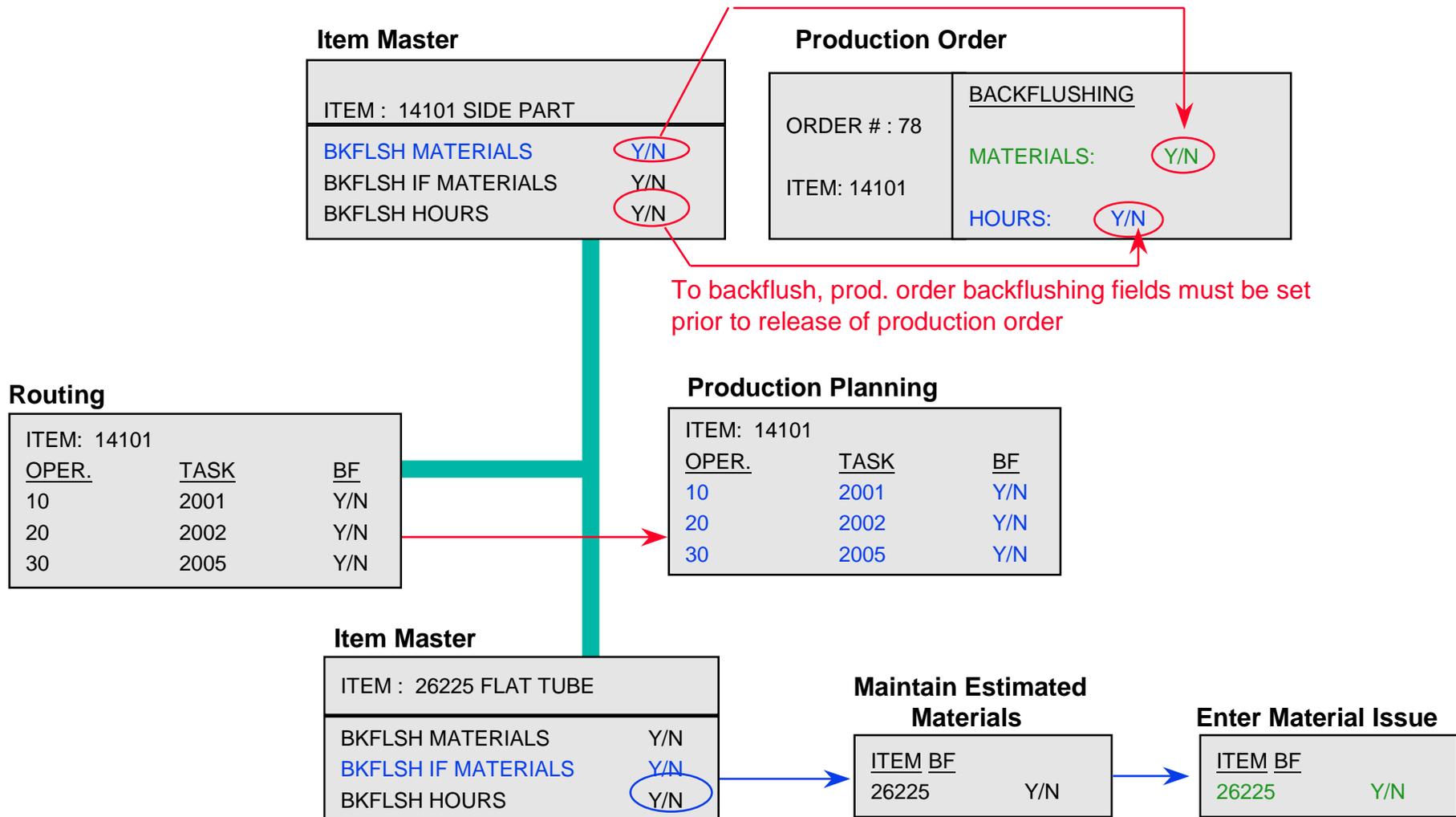
<u>TASK</u>	<u>BKFLSH</u>
2001	Y/N
2002	Y/N
2005	Y/N

Item Master

ITEM : 26225 FLAT TUBE	
BKFLSH MATERIALS	Y/N
BKFLSH IF MATERIALS	Y/N
BKFLSH HOURS	Y/N



Backflushing Default Logic



Exercises

- Define master data
- Set parameters
- Process production orders
- Review backflushing results

