

Apparel & Footwear

Production

User Guide

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Introduction

The next document explains the production process in Module Apparel and.

1. Production Orders

Production Orders are a set of instructions for planning and assembling a production item. It tracks all the material transactions and costs involved in the production process.

1.1 Create a Production Order

To create a production order, please go to:

Apparel and Footwear → Production → AF Production Order.

By default, the order opens with **Planned** status.

There are different ways to create a production order:

- Create production directly from Sales order form. Right click on the sales order and click on 'Copy Order to Manufac. Order'.

The screenshot shows the SAP Sales Order form for Customer C0003 (MAX Fashion). A right-click context menu is open over the item list, displaying various actions. The 'Copy Order to Manufac. Order' option is highlighted at the bottom of the menu. The item list contains three items: Casual Trousers in Green, Green, and Pink. The summary table on the right shows a total value of INR 35,360.00.

#	Item No.	BP Catalog No.	Item Description	Quantity
1	CT002-GRN		Casual Trousers 2 Green	
2	CT002-GRU		Casual Trousers 2 Grun	
3	CT002-PNK		Casual Trousers 2 Pink F	
4				

Total (LC)	Whse
INR 17,000.00	01
INR 10,200.00	01
INR 6,800.00	01
Total	
INR 34,000.00	
%	
INR 1,360.00	
Total	
INR 35,360.00	

- Open an AF production order, right click on the form and click on 'Import Sales Order'

Manufacturing Order

Order Number	47	Cut Ticket Date	11/02/17	User	manager
Doc. Numbering Code	Manual	Due Date		Customer	
		PDC Segmentation			

Contents Details Operations Cost Summary Planning UDF

Set all status to

#	PO Entry	PO No.	Status	Model Product	Item Code	Item Description	Planned Qty	Planned Date

≡

#	Item Code	Item Description	Base Stock	On Hand	In Progress	Available To Promise

Remarks

Add Cancel Add Any Item Add A, F, Items

Copy

- View Balance
- Reload BOM
- Report Completion
- Bar Code Printing
- Add Any Item
- Import Sales Order**
- Close all lines
- Release Order
- Copy Prod. Orders generated from MRP
- Print Production Order
- Copy from Demand Planing (Valogix)
- Import Individual orders
- Production Cost Summary
- View allocation Data

- Open an AF production order, click on Add A.F. Items and choose the Apparel segmentation to select items from the matrix.

[illegible]

Manufacturing Order

Order Number: 47, Cut Ticket Date: 11/02/17, User: manager
 Doc. Numbering: Manual, Due Date: , Customer: , Priority: , Type: Standard
 Code: , PDC Segmentation: ,

Contents Details Operations Cost Summary Planning UDF

Set all status to:

PO Entry PO No. Status Mod

Style: TS001, Color: BLU, GRN, PNK, RED, Scale: SHIRT, Warehouse: 01, Requested delivery date:

Color	Color De...	S	M	L	XL	XXL	XXXL
BLU	Blue	24.00	0.00	0.00	34.00	0.00	0.00
GRN	Green	0.00	13.00	0.00	0.00	0.00	0.00
PNK	Pink	0.00	0.00	27.00	0.00	16.00	0.00
RED	Red	0.00	0.00	0.00	18	0.00	0.00

Discount: 0.00, Item: TS001-RED-XL, BOM: , In Stock: 0.00, Committed: 0.00, Ordered: 0.00, Available: 0.00

BP Catalog: , Ship date: , Planned delivery date: , ATP Quantity: 0.00

Remarks:

Add Cancel Calculate ATP View ATP View ATP overall details

Add Any Item Apparel

➤ Import MRP Recommendations

Manufacturing Order

Order Number: 24, Cut Ticket Date: 24/01/2019, Due Date: , PDC Segmentation:

Contents Details Operations Cost Summary Planning UDF

Set all status to:

#	PO Entry	PO No.	Status	Model Product	Item Code	Item Description

#	Item Code	Item Description	Base

Paste
 Select All
 View Balance
 Reload BOM
 Date Selection
 Report Completion
 Bar Code Printing
 Add Any Item
 View allocation Data
 Import Sales Order
 Close all lines
 Release Order
 Copy Prod. Orders generated from MRP
 Print Production Order
 Copy from Demand Planning (Valogix)
 Import Individual orders
 Production Cost Summary
 Import Sales Quotation
 Load Segmentation by Size

1.2 Release Production Order

The production order can be released automatically based on apparel general settings or can be released manually.

Manufacturing Order

Order Number36Cut Ticket Date05/12/16Usermanager

Doc. NumberingManualDue Date05/12/16Customer

Code36PDC SegmentationPriorityTypeStandard

ContentsDetailsOperationsCost SummaryPlanningUDF

Set all status toReleasedChoose AllClear Selection

#	Update	PO Entry	PO No.	Status	Model Product	Item Code	Item Description	Planned	Recived From Contractor	Completed
1	<input checked="" type="checkbox"/>	296	296	Planned	000165	000165-BLU-34	Jeans Blue Pant 34	1.00	0.00	0.00
2	<input checked="" type="checkbox"/>	297	297	Planned	CT001	CT001-GOL-36	Jeans Golden Zipper Large	1.00	0.00	0.00
3	<input checked="" type="checkbox"/>	298	298	Planned						
4	<input checked="" type="checkbox"/>	299	299	Planned						

System Message

The operations will be created automatically when Manufacturing Order is updated.

Ok

#	Item Code	Item Description	Base	Planned	Issued	Available
1	Jeans1-BLK-28	Jeans Fabric Black Jeans Fabric 28	1.00	1.00	0.00	4,757.96
2	ZIPPER-13-L	Zipper for Jeans Golden Zipper Large	1.00	1.00	0.00	930.00
3	OP001	Cutting	1.00	1.00	0.00	0.00
4	OP002	Sewing	1.00	1.00	0.00	0.00
5	O001	Packing	1.00	1.00	0.00	0.00
6	O002	QA	1.00	1.00	0.00	0.00

Remarks

UpdateCancel

Add Any ItemApparel

After releasing the production order, jobs will be created automatically.

Manufacturing Order

Order Number36Cut Ticket Date05/12/16Usermanager

Doc. NumberingManualDue Date05/12/16Customer

Code36PDC SegmentationPriorityTypeStandard

ContentsDetailsOperationsCost SummaryPlanningUDF

Operation CodeMAN

Stage	Item Description	Operation No.	Description	Status
1	141	OP002	Sewing	Open
2	142	O001	Packing	Open
3	143	O002	QA	Open
4	144	OP001	Cutting	Open

Contractor	User	Barcode	Planned Qty	Issue Qty	Bad Qty	Received Qty	Comments
	manager	0000014100017	1.00	1.00	0.00	0.00	
	manager	0000014100024	1.00	1.00	0.00	0.00	
	manager	0000014100031	1.00	1.00	0.00	0.00	
	manager	0000014100048	1.00	1.00	0.00	0.00	

OKCancel

Mat / OperAdd Any ItemApparel

1.3 Release Raw Materials

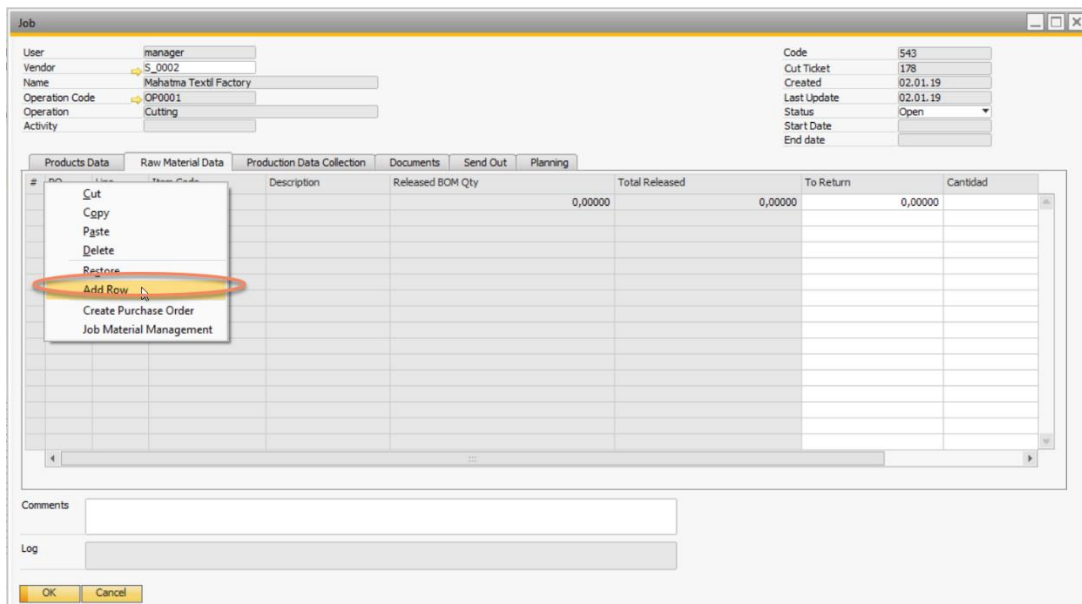
SAP allows to Release the Components from BOM in the Manufacturing Order with 2 methods:

- i. Manual – individual components of a parent item are issued manually. Serial or batch-managed items must be issued manually. Release the child items (with a manual issue method) from inventory using the Issue for Production method.
- ii. Backflush – components of a parent item are automatically issued to the Production Order once you report the completion of the parent item. Child items with a backflush issue method are issued automatically for the production order.

1.4 Link Raw Materials to an operation

In case the raw materials were not link in the cost sheet, it can be link later with the following steps:

- From the job, right click to display the menu,
- Select option Add Row



- Select the Raw Materials, and then Add

Job

User: manager
 Vendor: S_0002
 Name: Mahatma Textil Factory
 Operation Code: OP0001
 Operation: Cutting
 Activity:

Code
 Cut Tick
 Created
 Last Upd
 Status
 Start Da
 End date

Products Data Raw Material Data Production Data Collection Documents Send Out Planning

#	PO	Line	Item Code	Description	Released BOM Qty	Total Released	To F
Select Materials							
			ItemCode	ItemName	PlannedQty		
			3MTF	3M Thinsulate Featherless	15,00000		
			ET #608078-21	Etiqueta Nike TOR Rouge	15,00000		
			FB_0002-BLK	DrFit Fabric Black	22,50000		

Comments

Log

Add Cancel

OK Cancel

- And Finally Update the Job

Job

User: manager
 Vendor: S_0002
 Name: Mahatma Textil Factory
 Operation Code: OP0001
 Operation: Cutting
 Activity:

Code: 543
 Cut Ticket: 178
 Created: 02.01.19
 Last Update: 02.01.19
 Status: Open
 Start Date:
 End date:

Products Data Raw Material Data Production Data Collection Documents Send Out Planning

#	PO	Line	Item Code	Description	Released BOM Qty	Total Released	To Return	Cantidad
1	883	3	3MTF	3M Thinsulate Featherless	5.000.000,00000	0,00000	0,00000	
2	884	3	3MTF	3M Thinsulate Featherless	5.000.000,00000	0,00000	0,00000	
3	885	3	3MTF	3M Thinsulate Featherless	5.000.000,00000	0,00000	0,00000	
4	883	2	ET #608078-21	Etiqueta Nike TOR Rouge	5.000.000,00000	0,00000	0,00000	
5	884	2	ET #608078-21	Etiqueta Nike TOR Rouge	5.000.000,00000	0,00000	0,00000	
6	885	2	ET #608078-21	Etiqueta Nike TOR Rouge	5.000.000,00000	0,00000	0,00000	
7	883	1	FB_0002-BLK	DrFit Fabric Black	7.500.000,00000	0,00000	0,00000	
8	884	1	FB_0002-BLK	DrFit Fabric Black	7.500.000,00000	0,00000	0,00000	
9	885	1	FB_0002-BLK	DrFit Fabric Black	7.500.000,00000	0,00000	0,00000	

Comments

Log

Update Cancel

1.5 Send out Process

1.5.1 Setup – Vendor Warehouse

Business Partner Master Data			
Code	Manual	V99	Vendor
Name	Maquilladora		
Foreign Name			
Group	Proveedores		
Currency	Peso argentino		
Fiscal ID No.	CUIT	234466	
Account Balance → Local Currency -4,00 Goods Receipt POs 0,00 Purchase Orders → -2.904,00			
General	Contact Persons	Addresses	Payment Terms
Add RM Percentage		0,00	
Is EDI			
Factor			
Factor Account			
Label File Name			
EDI Receiver ID			
FOB Code			
Edi Vendor			
EDI 856 Level			
EDI 810 Level			
EDI 850 Level			
Uses Allocation Module		No	
Allocation Priority			
Allocation Default Warehouse		Almacén general	
Allocation Warehouse Bin			
Payment Run			
Belongs to Eu Community		No	
Accounting			
Properties			
Remarks			
Attachments			
UDFs			
eDogs			

Default vendor can also be linked to the manufacturing operation. When releasing the order, the job is automatically linked to this Vendor id.

Item Master Data

Item No.	Manual	Corte	<input type="checkbox"/> Inventory Item
Description		Cortee	<input type="checkbox"/> Sales Item
Foreign Name			<input checked="" type="checkbox"/> Purchase Item
Item Type		Items	
Item Group	Artículos		
UoM Group	Manual		
Price List	Listado de precios 01		
Model			

Bar Code: [] Unit Price: Primary Curr []

Gen... Purchasing ... Sales ... Inventory ... Planning D... Production D... Proper... Rema... Attache... Product...

Preferred Vendor: V99

Mfr Catalog No. []

Purchasing UoM Name []
Items per Purchase Unit: 1

Packaging UoM Name []
Quantity per Package: 1

Customs Group: Custom

Purchase Tax Code []

Preferred Vendors

#	BP Code	BP Name	Price List	Item Price	Last Price
1	V99	Maquilla sa	Listado de precios		22,00 EUR
2	PCM	PCM	Listado de precios 0		5,00 ARS
3					

OK Cancel Set as Default

1.5.2 Setup – Link material to manufacturing operation

When consuming or taking stock during manufacturing process and send out it is important to automate the process by linking the raw material to the consuming manufacturing operation. This happens during costing the style and then transfer to the next levels (BOMs, Cutting Tickets, etc.)

The screenshot shows the 'Manufacturing Order' window in SAP. The 'Product' tab is active, displaying fields for 'Doc. Numbering', 'Code', 'Description', 'Foreign Description', 'Model Source', 'Status', 'Product Line', 'Product Group', 'AT Segmentation', 'SAP Item Group', 'Season', 'Collection', 'Sub-Collections', 'Composition', 'Care Instruction', 'Gros', 'Brand', 'Designer', 'Division', 'Year', 'Owner', 'Country of Origin', 'Drop', 'Ship Start Date', 'Ship Cancel Date', 'Customer', 'Vendor', 'Main Warehouse', 'Secondary Warehouse', 'Price List', 'Currency', and 'Price'. A 'Preview File' button is visible next to a small image of a sneaker. The 'Cost Sheet' tab is also visible, showing a table with columns for 'Item No.', 'Item Description', 'Vendor', 'In Stock', 'Quantity', and various cost codes (C/GT, C/GT1, C/GT2, C/GT3, C/GT4, C/GT5, C/GT6, C/GT7, C/GT8, C/GT9, C/GT10, C/GT11, C/GT12, C/GT13, C/GT14, C/GT15, C/GT16, C/GT17, C/GT18, C/GT19, C/GT20). The table lists materials like ET12, Button, and MP1-C_001, with their respective quantities and costs.

1.5.3 Send out- Process

The process begins creating a Cutting Ticket or manufacturing order in the AFS module. The Bill of Materials screen shows all the production operations associated to a style. Once a production order gets created, all the operations are picked from the bill of materials and an ID is generated that's linked to a detail of the quantities of each operation for the production order. After your release the order the bar codes are created in the system to track each style-color-size or variant.

Manufacturing Order

Order Number: 32, Cut Ticket Date: 21/01/2020, Due Date: 22/01/2020, User: manager, Customer: , Priority: , Type: Standard

Contents | Details | Operations | Cost Summary | Planning | UDF

Set all status to: Released, Choose All, Clear Selection

#	Update	PO Entry	PO No.	Status	Model Product	Item Code	Item Description	Planned	Received From Contractor	Completed	Rejected	Wa...
1		144	144	Released	Zapa	Zapa-C/424-37	Zapatilla urbana EE Escala urbana 3	2,000	0,000	0,000	0,000	01
2		145	145	Released	Zapa	Zapa-C_001-37	Zapatilla urbana white Escala urbana	2,000	0,000	0,000	0,000	01

Total Units: 4.00

#	Item Code	Item Description	Base	Planned	Issued	Available	UoM	Warehouse
1	ETIQ	Etiqueta Gral	1,000	2,000	0,000	122,426,000		01
2	Button	Button extra	1,000	2,000	0,000	234,513,000		01
3	bolsillo-C_001-37	bolsillo white Escala urbana 37	1,000	2,000	0,000	-29,000		01
4	MPI-C_001		1,000	2,000	0,000	-2,000		01
5	Corte	Cortee	2,000	4,000	0,000	0,000		01
6	sewing	sewing	1,000	2,000	0,000	0,000		01
7	packaging	packaging	1,000	2,000	0,000	0,000		01

Remarks:

OK | Cancel | Cut Plan | Mat / Oper | Add Any Item | Add A. F. Items

From the manufacturing job. It copies all bar codes from the job to the send out. If some codes are not being sent out the user can remove the codes

Manufacturing Order

Order Number: 32, Cut Ticket Date: 21/01/2020, Due Date: 22/01/2020, User: manager, Customer: , Priority: , Type: Standard

Contents | Details | Operations | Cost Summary | Planning | UDF

Operation Code: Estandar

Stage: 76, Job Number: 76

User: manager, Vendor: V99, Name: Maquila sa, Operation Code: Corte, Operation: Cortee, Activity:

Code: 76, Cut Ticket: 32, 21/01/2020, Open

Products Data | Raw Material Data | Production Data Collection | Documents

#	Item Code	Item Description	Bar Code	Issued
1	Zapa-C/ Zapatilla urbana EE Escala urbana 37	0000007600012	2,000	
2	Zapa-C_ Zapatilla urbana white Escala urbana	0000007600029	2,000	

Contractor: V99

Bad Qty: 0,000, 0,000

Comments:

Context Menu: Cut, Copy, Paste, Delete, Cancel, Issue For Production, Create Purchase Order, Send Out, Production Data Collection, Job Material Management

1.5.4 The send out form

This form allocates all SKUs to be send out to an external vendor. The document allows users to track the barcodes, vendor, planned delivery date, materials issued to vendors and transactional documents processed.

Send Out

Vendor: V99
 Name: Maquila sa
 Contact Person:
 Employee: Lopez, Maria

Code: 13
 Posting Date: 21/01/2020
 Due Date:
 Status: Open

#	Bar Code	CutTick#	Model Code	Description	Color	Size Chart	Size	Variable	Stage	Operation Code	Operation	Qty	Vendor Price	Currency
1	0000007600012	32	Zapa	Corte	C/424	Urbana	37		76	Corte		2,000	4,50	ARS
2	0000007600029	32	Zapa	Corte	C_001	Urbana	37		76	Corte		2,000	4,50	ARS
												0,000	0,00	

Add Cancel

1.5.5 Vendor Price list

The supplier list helps the user to search and setup prices by operation, garment type or model level. Go to production → Supplier Price List

Vendor - Price List

Vendor: V99
 Operation: Corte

C. Vendor	Operation	Oper. Name	Product Group	Model	Currency	Price
V99	Corte	Corte		Zapa	ARS	4,50

OK Cancel

Then, in the Sent Out → Show Vendor's Price

Manufacturing Order

Order Number: 32
 Doc. Numbering: Manual
 Code: 32

Cut Ticket Date: 21/01/2020
 Due Date: 23/01/2020
 PDC Segmentation:
 User: manager
 Customer:
 Priority: Standard
 Type:
 Status: Open

Contents: Details: Operations: Cost Summary: Planning: UDF:

Operation Code: 76
 Stage: 76
 Job Number: 76

Operation Code: 76
 Description: Corte
 Status: Open

Job

User: manager
 Vendor: V99
 Name: Maquila sa
 Operation Code: Corte
 Operation: Corte
 Activity:
 Code: 76
 Out Ticket: 32
 Created: 21/01/2020
 Last Update: 21/01/2020
 Status: Open
 Start Date:
 End Date:
 Due Date:
 Vendor:
 Send Out:
 Show Vendor's Price:
 Copy:
 Create Purchase Order:
 Add: Cancel

Bar Code	CutTick#	Model Code	Description	Color	Size Chart	Size	Variable	Stage	Operation Code	Operation	Qty	Vendor Price	Currency
0000007600012	32	Zapa	Cortee	C/424	Urbana	37		76	Corte		2,000	4,50	ARS
0000007600029	32	Zapa	Cortee	C_001	Urbana	37		76	Corte		2,000	4,50	ARS
											0,000	0,00	

Then create a purchase Order

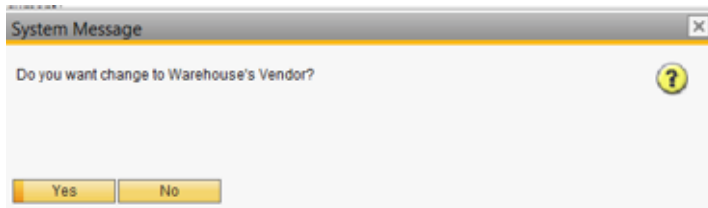
#	Quantity	Type	Item No.	Item Description	Inventory UoM	No. of Packages	Unit Price	Discount %	Rate	Price
1	2,000			Style= Zapa-C/424-37 - Planned Quantity= 2		4	8,000 ARS	0,00	0,0000	€
2				Style= Zapa-C_001-37 - Planned Quantity= 2				0,00	0,0000	

1.5.6 Changing the raw material warehouse to the vendor warehouse

Companies usually own the raw materials. During the manufacturing process, there are scenarios where raw materials need to be transferred and consumed from the vendor warehouse and not from the operating company. When processing a send out from a job, the system allows you to change the warehouse form the raw materials linked and also review how much stock the vendor has for a particular raw material.

Select the raw materials needed to be transferred or consumed from the vendor warehouse. The quantity is taken from all styles in the cut ticket and can be modified by the user.

When adding the send out the system, the warehouse can be changed if the user selects yes to the message, so the cut ticket is updated with the warehouse previously linked to the vendor

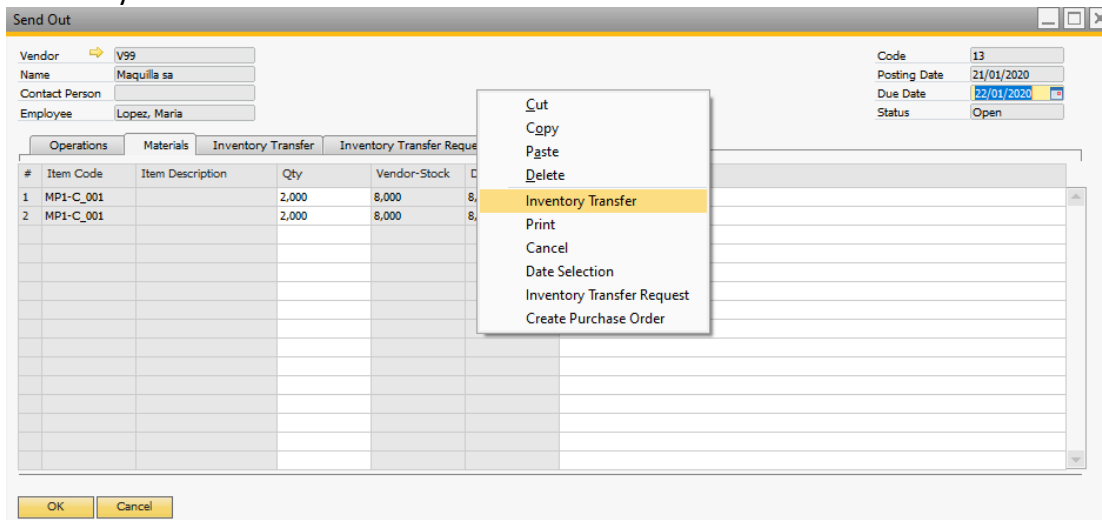


Transferring raw material to the vendor warehouse

If the stock is managed by vendor there are two options:

1. Backflush. Once the final product is received the raw material is consumed from the vendor warehouse and the product cost updated.
2. Manual. The user needs to issue the material from the vendor warehouse.

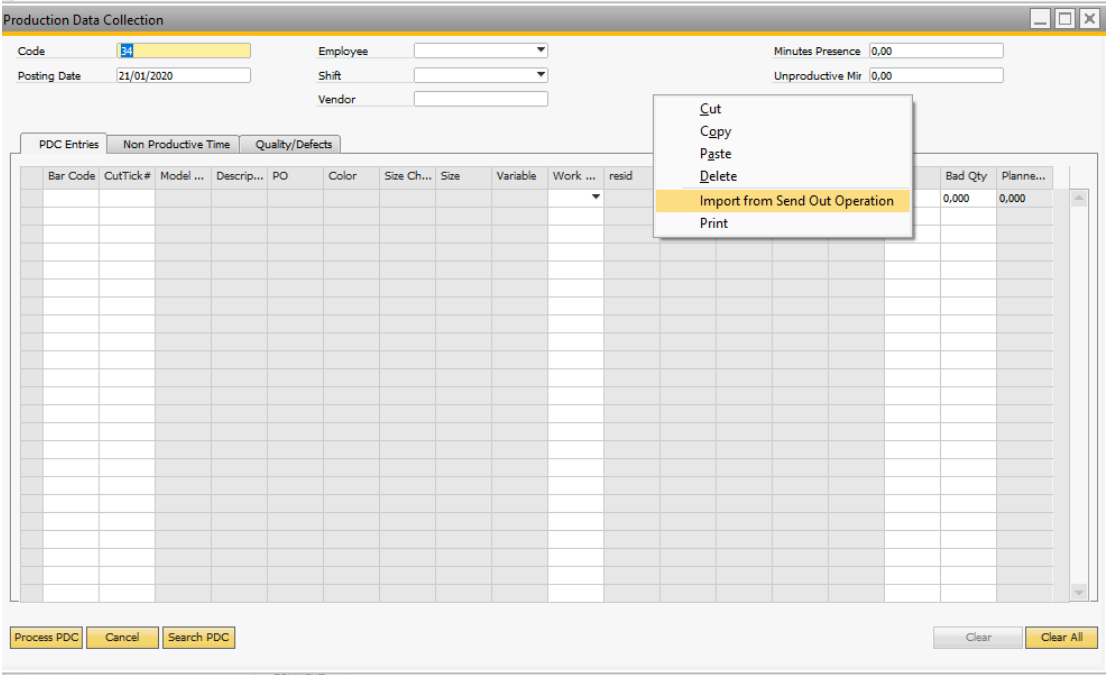
For both cases you need to transfer the material needed if the vendor warehouse falls in negative inventory stock. Otherwise the materials remain in the internal warehouse



Once de document is generated the stock is increases in the vendor warehouse and The transfer document gets linked to the process for future reference.

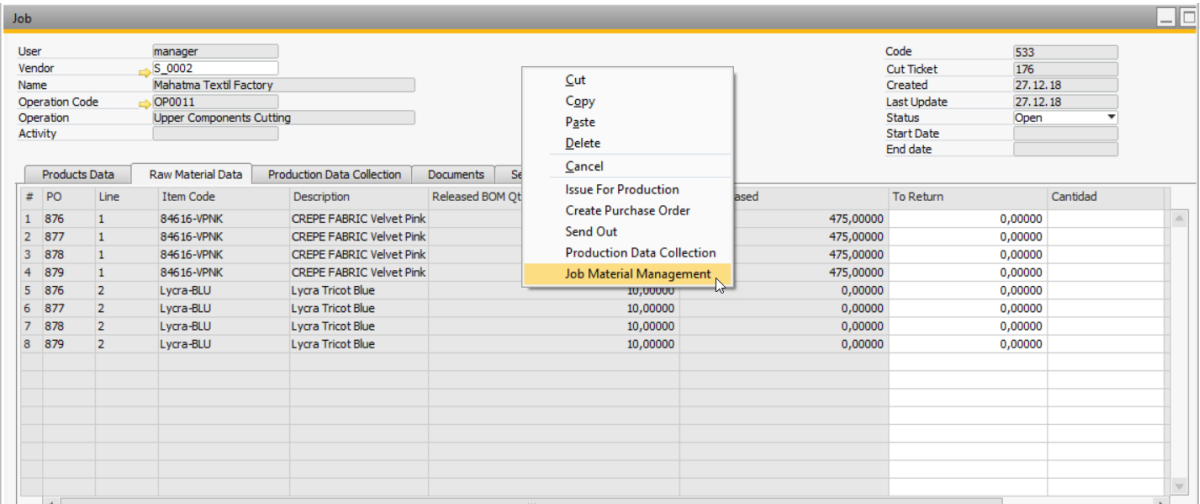
1.5.7 Receiving items from vendor

Once the styles arrive from the vendor, the user can copy the send out content to the Production data collection and print the goods receipt



1.6 Raw material inventory returns from production orders

When running a job, a user can specify the components (raw material) that are returned to its original warehouse from WIP. The wizard will apply the returned quantity to each SKU in the cut ticket. Select the option Job material management to open the quantity to return of materials that are already issued or not.



UsermanagerCode141VendorCut Ticket36NameOperation CodeOP002OperationSewingActivity

Products DataRaw M

#	Item Code	Item Description
1	000165-BL	Jeans Blue Pant 34
2	CT001-GR	Casual Trouser Green
3	JP001-BLK	Jeans Black Pant 34
4	JP001-BLK	Jeans Black Pant 32

CommentsLog

OKCancel

Materials

Item Code	Description	Total Released	returned
ZIPPER-13-L	Zipper for Jeans t 0.00		1
ZIPPER-13-M	Zipper for Jeans t 0.00		0.00
ZIPPER-13-S	Zipper for Jeans t 0.00		0.00

UpdateCancel

The wizard will ask the user to return the material during runtime. Click yes if you want to create the return components document. Click no to create the document when closing the job.

System Message

Do you want to create Return Component Document?

YesNo

The wizard opens the quantity assigned to each SKU. In this case total quantity returned was 400 mts of fabric. The return document will allocate 400 to each SKU to apply the cost.

Materials Details - Batch

Items

Production Order	Line	Item Code	Item Description	Whse	Quantity	Total
195	4	RM0012001	Standard Cotton Fabric Navy Blue	01	100.000	100.000
196	4	RM0012001	Standard Cotton Fabric Navy Blue	01	100.000	100.000
197	4	RM0012001	Standard Cotton Fabric Navy Blue	01	100.000	100.000
198	4	RM0012001	Standard Cotton Fabric Navy Blue	01	100.000	100.000
					400.000	

Available Batches

SystNu...	Batches	Available	Selected
-----------	---------	-----------	----------

Selected Batches

Batches	Quantity	DistNu...
---------	----------	-----------

UpdateCancel

If the fabric or trim is managed by batch, then the batch selection window will show available batches. Once you click the update button, the document is generated and is linked to the job document tabs.

Job

User: manager
 Vendor:
 Name:
 Operation Code: OP01
 Operation: Cutting / Corte
 Activity:
 Code:
 Cut Ticket:
 Created:
 Last Update:
 Status:
 Start Date:
 End date:

Products Data | Raw Material Data | Production Data Collection | Documents | Send Out | Planning

Document Type	Code	Doc. Number	Business Partner	Doc Date	Due D
Issue Prod	18	9		10/04/16	10/04/16
Receipt From Production	16	7		10/04/16	10/04/16
Receipt From Production	18	8		10/04/16	10/04/16

Receipt from Production

Number: 8 | Series: Primary | Posting Date: 10/04/16 | Ref. 2

#	Order No.	Series No.	Type	Item No.	Item Description	Trans. Type	Quantity	Unit ...
1	170	Primary	Item	RM0012001	Standard Cotton Fabric Navy Blue		100	\$
2	171	Primary	Item	RM0012001	Standard Cotton Fabric Navy Blue		100	\$
3	172	Primary	Item	RM0012001	Standard Cotton Fabric Navy Blue		100	\$
4	173	Primary	Item	RM0012001	Standard Cotton Fabric Navy Blue		100	\$

Comments:
 Log:

1.7 Production – Material Management

An option to manage materials in batch for cut tickets is available.

Manufacturing Order

Order Number: 45 | Cut Ticket Date: 10/04/16
 Doc. Numbering: Manual | Due Date: 11/27/17
 Code: 45 | PDC Segmentation:

Contents | Details | Operations | Cost Summary | Planning | UIDF

Operation Code: OPS

Stage	Item Description	Operation No.
1	74	OP01
2	75	OP02
3	76	OP03

Contractor	User	Barcode	Planned Qty
	manager	0000007400018	100.000
	manager	0000007400025	100.000

OK | Cancel

- Cut
- Copy
- Paste
- Delete
- Filter Table
- View Balance
- Reload BOM
- Date Selection
- Report Completion
- Bar Code Printing
- Add Any Item
- Material Management**
- Import Sales Order
- Close all lines
- Release Order
- Copy Prod. Orders generated from MRP
- Print Production Order
- Copy from Demand Planning (Valogix)
- Import Individual orders
- Add to Planning
- Set CutTicket Number
- Production Cost Summary
- View allocation Data
- Allocation
- Generate Receipt from Production from Soft Allocation

The wizard allows the users to:

1. Replace materials (replace fabrics, trims, etc.)
2. Adjust material quantity (for example if items are planned and then the fabric used is less or more than planned based on cutting report)

Changes the quantity total in the material. The adjustment ratio is applied for all raw materials / BOMs.

The screenshot shows the 'Material Management' window with the 'Replacement' tab selected. A 'List of Items' dialog is open, displaying a list of materials. A red arrow points to the 'RM010' item in the list.

#	PostDate	Item Code	Item Name	QtyPro...	New It...	New It...
1	10/04/16	RM0012920	Standard Cotton Fabric R	400.000		
2	10/04/16	RM010	Hantag	400.000		
3	10/04/16	RM011	Polybag	400.000		
4	10/04/16	RM0012001	Standard Cotton Fabric N	400.000		

List of Items

Find:

#	Item No.	
198	RM0011000	Sta
199	RM0011010	Sta
200	RM0012001	Sta
201	RM0012920	Sta
202	RM0012991	Sta
203	RM010	Har
204	RM011	Pol
205	S1001-1000-5	Din
206	S1001-1000-5.5	Din
207	S1001-1000-6	Din

Buttons: Choose, Cancel, New

3. Add new lines (if an additional item is needed)

Adds new material to ALL BOMS that are selected.

The screenshot shows the 'Material Management' window with the 'Add New Lines' tab selected. The table displays the current material list with additional columns for 'Total Plan' and 'Qty Real'. A new line is being added at the bottom.

#	Item Code	Item Name	QtyPro...	Total Plan	Qty Real
1	RM0012920	Standard Cotton Fabric R	400.000	1,200.000	0.000
2	RM010	Hantag	400.000	1,200.000	0.000
3	RM011	Polybag	400.000	400.000	0.000
4	RM0012001	Standard Cotton Fabric N	400.000	9,200.000	0.000
	A001	A011	0.000	0.000	2
			0.000	0.000	0.000

Buttons: Cancel, Back, Next, Update

1.8 Productive / Non-Productive Time

A table has been added to the solution to add non-productive times code and default times. This is important to keep track of times that employees were not working in the workflow and identify bottlenecks.

[illegible]

Open the shift window and enter the different shifts and the total hours per shift.

[illegible]

Link the default shift for employees.

Employee Master Data

First Name: Lucas Employee No.: 1
 Middle Name: M Ext. Employee No.:
 Last Name: Designer ☒ Active Employee
 Job Title:
 Position: Designer Office Phone:
 Department: Production Ext.:
 Branch: US Mobile Phone:
 Manager: Pager:
 User Code: manager Home Phone:
 Sales Employee: -No Sales Employ Fax:
 E-Mail:

Address Membership Administration Personal Finance Remarks Attachments Productiv

Default Operation: OP01
 Default Shift: DAY

OK Cancel

In the PDC the total productive minutes expected are loaded with the non-productive time. The user can change these values. This is important to make reports.

1. Employee performance
2. Non-productive time bottlenecks

Production Data Collection

Code: 1 Employee: Barrionuevo, Emilia
 Posting Date: 07/09/2015 Shift: Vendor:

Minutes Presence
 Unproductive Minutes

PDC Entries Non Productive Time Quality/Defects

#	Bar Code	CutTick#	PO	Model Code	Description	Color	Scale	Size	Variable	Work Center	Resource	Stage	Operation Code	Operation	Qty	Bad Qty	PlanQty
1	0000000100X	1		BUZ001	Buzo Volcom	2032	S-XL	S				1	OP001	Corte	100,000	0,000	0,000
1	0000000100X	1		BUZ001	Buzo Volcom	2032	S-XL	M				1	OP001	Corte	200,000	0,000	0,000
1	0000000100X	1		BUZ001	Buzo Volcom	2032	S-XL	L				1	OP001	Corte	100,000	0,000	0,000

OK Cancel

1.9 Bad Quantities

Set the Bad Qty Warehouse

Apparel And Footwear Setup

Item Master Data | Document Settings | **Production** | Critical path | Allocation | Factoring | Labeling | Path | OITM | UDF | Display

Default Price List: Liste de prix 01
 Default Sales Price List: Prix de Vente
 Default Currency: MAD
Bad Qty Warehouse: M-DCH

☐ Use Standard Exchange Rate
 Standard Exchange Rate Date:
☐ Use Exchange Rate Date from Cost Sheet
☐ Use Patterns in Cost Sheet

Cut Ticket
☐ Display a warning in Cut Tickets when components falls into negative stock
☐ Block Cut Tickets when components falls into negative stock
☐ Check Previous Operation is Completed
 Cut Ticket PDC Segmentation:
☐ Show only Models with BOM

Send Out
 Goods Issue Decrease Account:
 BarCode:
☐ Use Group Number
 Extra Cost Item:

General
☐ Beas Integration
☐ Use Default Warehouse From Item Master
☐ Use Phantom Item
☐ Release Raw Materials from Vendor Warehouse
☐ Auto Release
☐ Issue from Production Automatically
☐ Create Good Issue Autom. Special Orders
☐ Use Advance Cost Sheet
☐ Consumption By Pattern

OK Cancel

The Item must have the warehouse added so we can create bad quantities for that SKU.

Item Master Data

Item No. Manuelle BQ-AZUL-40
 Description BQ AZUL 40
 Foreign Name BQ
 Item Type Items
 Item Group PRODUITS FINIS
 UoM Group Manuellement
 Price List Liste de prix 01
 Model BQ

☒ Stock Item
☐ Sales Item
☐ Purchase Item

Bar Code:
 Unit Price: Primary Curre 8,0000 EUR

General | Purchasing Data | Sales Data | **Stock Data** | Planning Data | Production Data | Properties | Remarks | Attachments | Production

Set Stock Method By: Item Group
☐ Manage Stock by Warehouse
Stock Level
 Required (Purchasing UoM):
 Minimum:
 Maximum:

#	Whse Code	Whse Name	Locked	First Bin Location	Enforce Default ...
1	01	Magasin général	<input type="checkbox"/>		<input type="checkbox"/>
2	M-DCH	Magasin 2ème Choix	<input type="checkbox"/>		<input type="checkbox"/>
3			<input type="checkbox"/>		<input type="checkbox"/>

On a Production order, you can enter a Bad qty for the system to reprocess the job.

The steps to reprocess those bad quantities, below:

- I. Open a Job
- II. With right click, open PDC, add Bad Qty

Production Data Collection

Code: 10 Employee: Shift: Minutes Presence: 0,00
 Posting Date: 26/11/2018 Vendor: Unproductive Minutes: 0,00

PDC Entries Non Productive Time Quality/Defects

#	Bar Code	CutTick#	PO	Model Code	Description	Color	Scale	Size	Variable	Work Center	Resource	Stage	Operation Code	Operation	PlanQty	Qty	Bad Qty
0000000800013	6	23	Mod_01	Mod_var2	C_001	Scale_001	S	V2	Corte	Cortadora 1	8	⇒	Corte	Cortee	1,000	1,000	1,000
0000000800020	6	24	Mod_01	Mod_var2	C_001	Scale_001	M	V2	Corte	Cortadora 1	8	⇒	Corte	Cortee	1,000	1,000	0,000
0000000800037	6	25	Mod_01	Mod_var2	C_001	Scale_001	L	V2	Corte	Cortadora 1	8	⇒	Corte	Cortee	1,000	1,000	0,000
0000000800044	6	26	Mod_01	Mod_var2	C_002	Scale_001	S	V2	Corte	Cortadora 1	8	⇒	Corte	Cortee	1,000	1,000	0,000
0000000800051	6	27	Mod_01	Mod_var2	C_002	Scale_001	M	V2	Corte	Cortadora 1	8	⇒	Corte	Cortee	1,000	1,000	0,000
0000000800068	6	28	Mod_01	Mod_var2	C_002	Scale_001	L	V2	Corte	Cortadora 1	8	⇒	Corte	Cortee	1,000	1,000	0,000
															0,000		

Add Cancel Clear All Clear

- III. Click Yes on Reworking

System Message

Do you want to Add Bad Qty for Reworking?

Yes No

- IV. Close window
- V. A new bar code will be generated for the bad quantities on the Job

Job

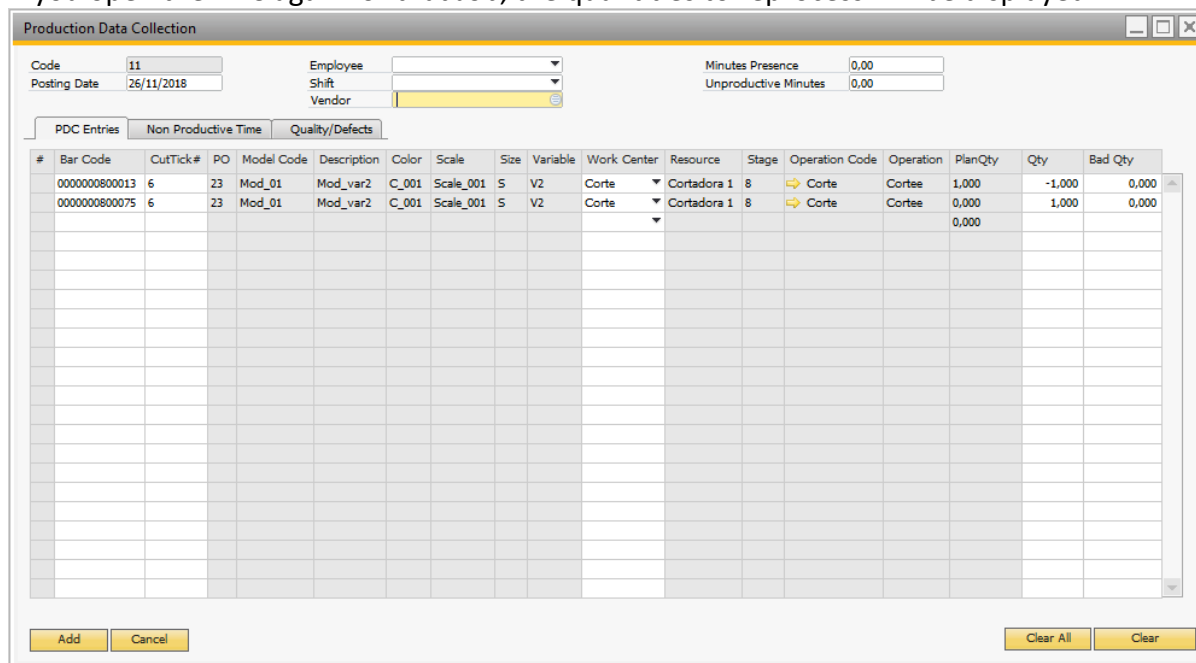
User: manager Code: 22
 Vendor: Cut Ticket: 9
 Name: Created: 27/11/2018
 Operation Code: ⇒ Corte Last Update: 27/11/2018
 Operation: Cortee Status: Open
 Activity: Start Date: End date:

Products Data Raw Material Data Production Data Collection Documents Send Out Planning

#	Item Code	Item Description	Group#	Bar Code	Issued	Planned	Received	Bad Qty	Comments
1	⇒ Pijama-C_004-S	Pijama T-Rex Azul Scale_Jean S	9-36-Pijama-C_004-S	0000002200019	3,000	3,000	3,000	0,000	
2	⇒ Pijama-C_004-M	Pijama T-Rex Azul Scale_Jean M	9-37-Pijama-C_004-M	0000002200026	3,000	3,000	3,000	0,000	
3	⇒ Pijama-C_004-L	Pijama T-Rex Azul Scale_Jean L	9-38-Pijama-C_004-L	0000002200033	3,000	3,000	3,000	0,000	
4	⇒ Pijama-C_004-XL	Pijama T-Rex Azul Scale_Jean XL	9-39-Pijama-C_004-XL	0000002200040	3,000	3,000	3,000	0,000	
5	⇒ Pijama-C_005-S	Pijama T-Rex Verde Scale_Jean S	9-40-Pijama-C_005-S	0000002200057	4,000	4,000	2,000	2,000	
6	⇒ Pijama-C_005-M	Pijama T-Rex Verde Scale_Jean M	9-41-Pijama-C_005-M	0000002200064	4,000	4,000	4,000	0,000	
7	⇒ Pijama-C_005-L	Pijama T-Rex Verde Scale_Jean L	9-42-Pijama-C_005-L	0000002200071	4,000	4,000	4,000	0,000	
8	⇒ Pijama-C_005-XL	Pijama T-Rex Verde Scale_Jean XL	9-43-Pijama-C_005-XL	0000002200088	4,000	4,000	4,000	0,000	
9	⇒ Pijama-C_005-S	Pijama T-Rex Verde Scale_Jean S		0000002200095	2,000	0,000	0,000	0,000	Rework

Comments: Log: OK Cancel

If you open the PDC again for that Job, the quantities to reprocess will be displayed:



The PDC window displays a table with the following data:

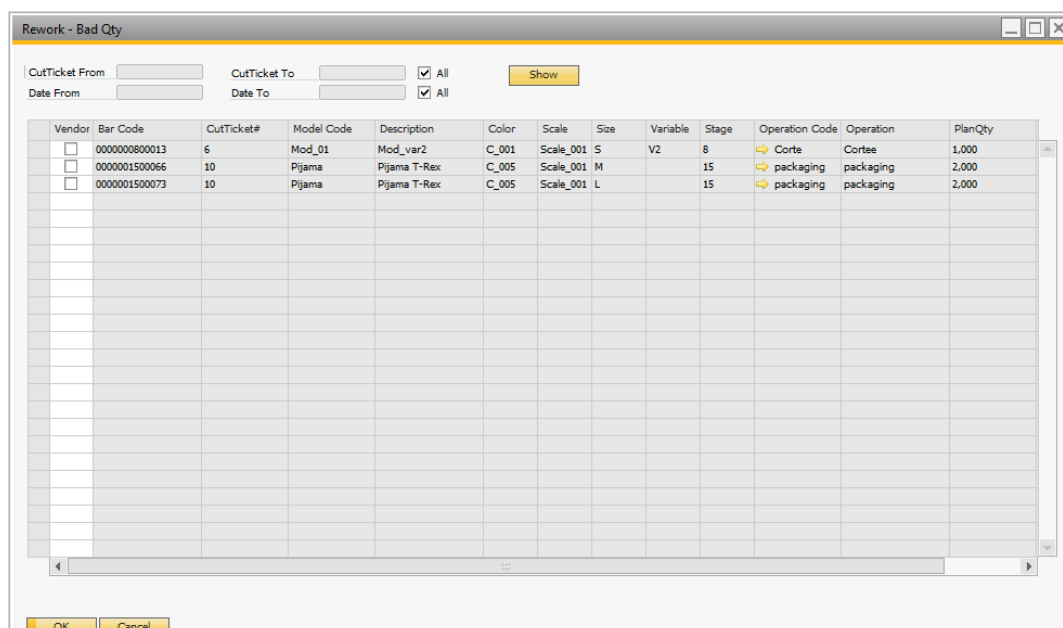
#	Bar Code	CutTick#	PO	Model Code	Description	Color	Scale	Size	Variable	Work Center	Resource	Stage	Operation Code	Operation	PlanQty	Qty	Bad Qty
0000000800013	6	23	Mod_01	Mod_var2	C_001	Scale_001	S	V2	Corte	Cortadora 1	8	⇒ Corte	Cortee	1,000	-1,000	0,000	
0000000800075	6	23	Mod_01	Mod_var2	C_001	Scale_001	S	V2	Corte	Cortadora 1	8	⇒ Corte	Cortee	0,000	1,000	0,000	

Then, continue the process adding the PDC for the bad quantities.

1.10 Rework – BAD Qty

Also, it's possible to confirm later that a Production barcode will be rework from the Menu. This is useful if the products need a final inspection in order to confirm if they are possible to be rework. Production → REWORK – BAD Qty

Shows the bad quantities according to the filters that have been set:



The Rework - Bad Qty window displays a table with the following data:

Vendor	Bar Code	CutTicket#	Model Code	Description	Color	Scale	Size	Variable	Stage	Operation Code	Operation	PlanQty
<input type="checkbox"/>	0000000800013	6	Mod_01	Mod_var2	C_001	Scale_001	S	V2	8	⇒ Corte	Cortee	1,000
<input type="checkbox"/>	0000001500066	10	Pijama	Pijama T-Rex	C_005	Scale_001	M		15	⇒ packaging	packaging	2,000
<input type="checkbox"/>	0000001500073	10	Pijama	Pijama T-Rex	C_005	Scale_001	L		15	⇒ packaging	packaging	2,000

1. Choose Bar codes to reprocess
2. Click on Update
3. The bad quantities have been reprocessed.

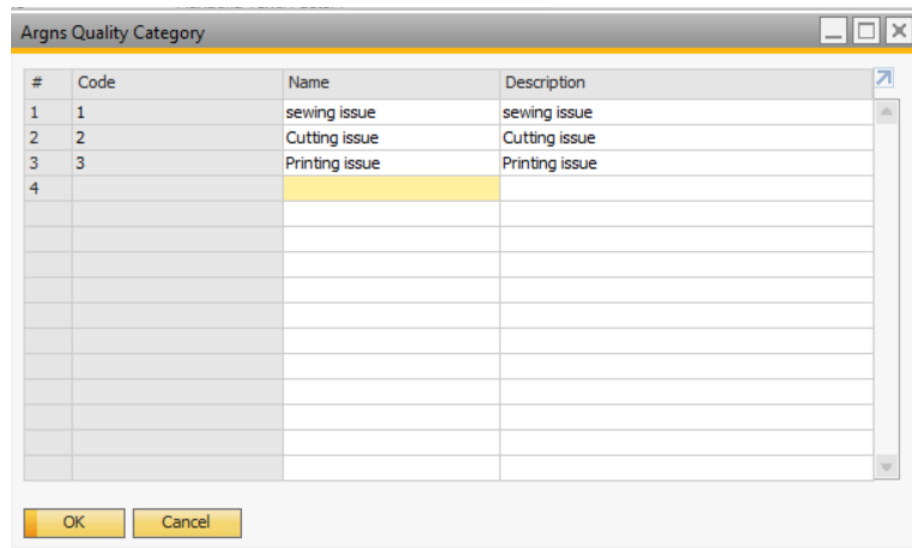
1.11 Quality Details

In PDC it's possible complete Quality details and types of defects.

Go to: Apparel and Footwear / Administration / Setup / Quality Assurance

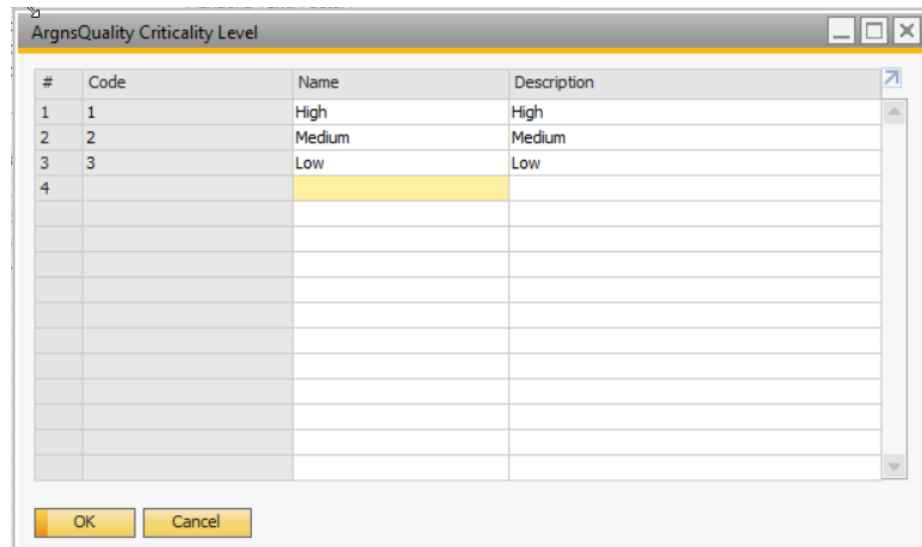
Define the following information:

 Categories.



#	Code	Name	Description
1	1	sewing issue	sewing issue
2	2	Cutting issue	Cutting issue
3	3	Printing issue	Printing issue
4			

 Criticality Level.



#	Code	Name	Description
1	1	High	High
2	2	Medium	Medium
3	3	Low	Low
4			

Then, in the PDC – Quality Tab complete the information for the Barcodes.

Select for each barcode the Category, defect and comments.

This quality details are not linked to Rework, and it's to manage information for the QA department.

1.12 Production Cost Summary Report

A window has been added to the cut ticket. Right click and select Production Cost Summary

Manufacturing Order

Order Number: 45
Doc. Numbering: Manual
Code: 45

Cut Ticket Date: 10/04/16
Due Date: 01/22/17
PDC Segmentation:

Contents Details Operations Cost Summary Planning UDF

Operation Code: OPS

Stage	Item Description	Operation No.
1	74	OP01
2	75	OP02
3	76	OP03

Contractor	User	Barcode	Planned Qty
	manager	0000007400018	100.000
	manager	0000007400025	100.000

OK Cancel

Context Menu:

- Cut
- Copy
- Paste
- Delete
- Filter Table
- View Balance
- Reload BOM
- Date Selection
- Report Completion
- Bar Code Printing
- Add Any Item
- Material Management
- Import Sales Order
- Close all lines
- Release Order
- Copy Prod. Orders generated from MRP
- Print Production Order
- Copy from Demand Planning (Valogix)
- Import Individual orders
- Add to Planning
- Set CutTicket Number
- Production Cost Summary**
- Allocation

The screen report shows three sections:

1. Material cost, showing all issue for production documents with cost, also showing materials returned from WIP.

Cost Summary Report

Code: 45
Cut Ticket No: 45

Materials Productive Operation Non-Productive Operation

#	Posting Date	Prod Ord No.	Warehouse	ItemCode	Description	Quantity	Cost	TotalCost	Operation
1	10/04/16	195	01	RM0012001	Standard Colton Fabric Navy Blue	0.000	\$ 0.96	\$ -95.83	Cutting / Corte
2	10/04/16	196	01	RM0012001	Standard Colton Fabric Navy Blue	0.000	\$ 0.96	\$ -95.83	Cutting / Corte
3	10/04/16	197	01	RM0012001	Standard Colton Fabric Navy Blue	0.000	\$ 0.96	\$ -95.83	Cutting / Corte
4	10/04/16	198	01	RM0012001	Standard Colton Fabric Navy Blue	0.000	\$ 0.96	\$ -95.83	Cutting / Corte
5	10/04/16	195	01	RM0012001	Standard Colton Fabric Navy Blue	2,300.000	\$ 0.96	\$ 2204.11	
6	10/04/16	196	01	RM0012001	Standard Colton Fabric Navy Blue	2,300.000	\$ 0.96	\$ 2204.11	
7	10/04/16	197	01	RM0012001	Standard Colton Fabric Navy Blue	2,300.000	\$ 0.96	\$ 2204.11	
8	10/04/16	198	01	RM0012001	Standard Colton Fabric Navy Blue	2,300.000	\$ 0.96	\$ 2204.11	
9	10/04/16	195	01	RM0012001	Standard Colton Fabric Navy Blue	0.000	\$ 0.96	\$ -47.92	
10	10/04/16	196	01	RM0012001	Standard Colton Fabric Navy Blue	0.000	\$ 0.96	\$ -47.92	
11	10/04/16	197	01	RM0012001	Standard Colton Fabric Navy Blue	0.000	\$ 0.96	\$ -47.92	
12	10/04/16	198	01	RM0012001	Standard Colton Fabric Navy Blue	0.000	\$ 0.96	\$ -47.92	
13	10/04/16	195	01	RM0012001	Standard Colton Fabric Navy Blue	2,300.000	\$ 0.96	\$ 2204.11	

Total Material Cost: \$ 10,445.54
Total Operation Cost: \$ 400.00
Total Non-Operation Cost: \$ 12.00

OK Cancel

2. Productive Time, showing all cost of pieces by operation (standard operation cost).

[illegible]

3. **Non-Productive Operations.** This is the average of lost time by PDC entry.

[illegible]

1.13 Production Reports

1.13.1 In Warehouse - Cost Report

A report combining warehouse and production costs has been added to the report section.

Production Stock / Cost Report

Date From10/06/16Date to10/06/16

Warehouse From01Warehouse To02

ShowCancel

SAP Business One

Apparel & Footwear

Cost Production Report

From Date 8/8/2016 To 4/10/2016

Warehouse From 03 To 03

Style Code	Description	Stock In hand	Avg. cost in Whs	Total Initial Stock	Goods Receipt For Prod Ord	Goods Receipt Avg Cost	Avialable Stock	Delivery Qty	Delivery Qty Cost	Final Stock Balance
03 - UK Allocation Warehouse										
000201	Girls Dress	0.00	23.00	0.00	0.00	0.00	-72,061.25	0.00	0.00	0.00
037484012	CACHETERO DESCADERADO LISO	118.00	123.00	2,214.30	0.00	0.00	-299.00	0.00	0.00	118.00
071.0035	SANDALIA CASUAL A GIANNINI	4,200.00	0.00	0.00	0.00	0.00	4,723.00	0.00	0.00	4,200.00
1000	Full Figure Support	0.00	17.50	0.00	0.00	0.00	0.00	0.00	0.00	0.00
1259449	UA Storm Tips Jacket	12,005.00	5.00	60,025.00	0.00	0.00	15,011.00	0.00	0.00	12,005.00
15SL022G82	METALLICÁ BOTTALATOÁ LEATHERÁ BEYAA LOA	10.00	194.61	1,566.20	0.00	0.00	1,789.00	0.00	0.00	10.00
2200101	ALGODON REFUERZO REF.30138	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
365560145	511™ Slim Fit Cut-Off Shorts	2,123.00	23.00	48,760.00	0.00	0.00	1,866.00	0.00	0.00	2,123.00
675	Funkionsjæke Damen	0.00	0.00	0.00	0.00	0.00	680.00	0.00	0.00	0.00
803000	New Ladies Shoe	11.00	0.00	0.00	0.00	0.00	-22.00	0.00	0.00	11.00
80408	Ladies Brazil	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
804081	Brazil - Ladies	486.00	0.00	0.00	0.00	0.00	378.00	0.00	0.00	486.00
AF001	City Gear Style	0.00	0.00	0.00	0.00	0.00	1,380.00	0.00	0.00	0.00
AF6325	ADIDAS ZX FLUX	1,700.00	0.00	0.00	0.00	0.00	3,140.00	0.00	0.00	1,700.00
AFS991	AFS Demo Style	0.00	3.30	0.00	0.00	0.00	0.00	0.00	0.00	0.00

1.13.2 Cost production report

Cost Summary Report

Code39

Cut Ticket No39

Filter Table

Production Costing Summary

Materials


Productive Operation

Non-Productive Operation

#	Posting Date	Prod Ord No.	Warehouse	ItemCode	Description	Quantity	Cost	TotalCost	Operation
1	09/29/16	162	01	RM0012001	Standard Cotton Fabric Navy Blue	120.000	\$ 0.96	\$ 115	Sewing / Costura
2	09/29/16	163	01	RM0012001	Standard Cotton Fabric Navy Blue	120.000	\$ 0.96	\$ 115	Sewing / Costura
3	09/29/16	164	01	RM0012001	Standard Cotton Fabric Navy Blue	120.000	\$ 0.96	\$ 115	Sewing / Costura
4	09/29/16	165	01	RM0012001	Standard Cotton Fabric Navy Blue	120.000	\$ 0.96	\$ 115	Sewing / Costura
5	09/29/16	164	01	RM011	Polybag	4.600	\$ 0.78	\$ 3.59	
6	09/29/16	163	01	RM011	Polybag	4.600	\$ 0.78	\$ 3.59	
7	09/29/16	162	01	RM011	Polybag	4.600	\$ 0.78	\$ 3.59	
8	09/29/16	165	01	RM011	Polybag	4.600	\$ 0.78	\$ 3.59	
9	09/29/16	164	01	RM010	Hantag	4.000	\$ 1.25	\$ 5	
10	09/29/16	163	01	RM010	Hantag	4.000	\$ 1.25	\$ 5	
11	09/29/16	162	01	RM010	Hantag	4.000	\$ 1.25	\$ 5	
12	09/29/16	165	01	RM010	Hantag	4.000	\$ 1.25	\$ 5	

Total Material Cost

\$ 494.36



SAP® Business One
Apparel & Footwear

Production Cost Summary

Cut Ticket No :: 195
Cut Ticket Code:: 195

Material Summary

Posting Date	Prod Ord No.	Warehouse	ItemCode	Dscription	Quantity	Price	TotalCost	Operation
3/10/2016	912	02	HNG1	Hangers	100.00	\$ 0.49	\$ 49.34	Send Out
4/10/2016	912	02	HNG1	Hangers	0.00	\$ 0.49	\$ -24.67	Send Out
4/10/2016	912	03	MP0019	Tela Jean	100.00	\$ 2.00	\$ 200.00	
4/10/2016	913	02	HNG1	Hangers	100.00	\$ 0.49	\$ 49.34	
4/10/2016	913	03	MP0019	Tela Jean	100.00	\$ 2.00	\$ 200.00	
					400.00		\$ 474.01	

Productive Operation

Posting Date	BarCode	Style	Color	Size	Variable	Operation	Qty	Cost	Total Cost
4/10/2016	0000060300010	NWARE01	334	S		OP002	100.00	1.00	\$100.00
4/10/2016	0000060300027	NWARE01	334	M		OP002	100.00	1.00	\$100.00
							100.00		200.00

Non-Productive Operation

Posting Date	PDC #	Employee Name	TotalN-Pro Time	Operation	Total Qty	Prop. Minute	Cost	Total cost
--------------	-------	---------------	-----------------	-----------	-----------	--------------	------	------------