3.3. Production line settings

In Produmex WMS a production line is always subordinate to a warehouse.

There are multiple ways of doing production:

- Production Flow: This flow handles the receipt from production and issue for production in the client
- Production Manager and Receipt from Production Flow: On the scanner/touchscreen the receipt for production is booked. The Production Manager handles the starting and stopping of the production order.

Note: Make sure you do not use the same production line for both flows.

The following settings can be defined for a production line:

3.3.1. General



Active
If it is enabled, the production line is active. A production line can only be active when the Input Location, Output Location and Rest Location fields are filled in.

Only 1 started production order allowed
If it is enabled, only one started production order is allowed for the production line.

The setting applies to the Production Manager and Receipt from Production Flow. The Production Flow always forces to have only one production order started on the production line.

Consume All Material on Production Line When Closing Production Order
With the end of the production all materials linked to the production line are issued, that is, no stock remains on the production line and the remaining quantity is 0.

The issued quantity can be equal to or higher than the planned quantity on the Issue for Production document.

Prerequisites:

- *Only 1 started production order allowed* setting on the level of the production line is enabled.
- The *Production Type* on the level of the production line is set to SPL_CONS_LOCK.

The setting applies to the following flows:

- Production with Production Manager
- Receipt from Production Flow
- Production Flow

If the production order is closed on the Production Manager, by default the used quantity equals the on-line quantity and the remaining quantity is 0. The used quantities and the remaining quantities can

be changed.

If the production order is closed during the Production Flow, by default the used quantity equals the on-line quantity and the rest quantity is zero on the *Enter quantity to consume* screen. The used quantities and the remaining quantities can be changed.

If the production order is closed during the Receipt from Production Flow, all materials on the production line are issued for the production order. The used quantity cannot be changed.

Note:

- The setting does not apply to the Put on Hold step during production.
- If the *Use Waste? (Y/N)* setting on the production controller is enabled, the remaining quantities are issued in a different document as waste materials.

Pick to location
The location where the needed ingredients are picked to. When this is not filled in, the system uses the input location. The Component Weighing Flow uses the Pick to location as input for the items to be weighed. The weighed items will be stored on the input location. Stock on a Pick to location is not taken in account to create picklist proposals.

Lock items picked to this location
If the setting is enabled, the *Picking for Production Flow* and the *Picklist for Production Flow* locks the items that are picked to this location. During the *Component Weighing Production Flow* the locked stock is moved to the input location after it was weighed.
On a Beas-WMS integration environment the stock is locked regardless the value of this setting.

Input location
The location where the needed ingredients are picked to. the production flows move stock from the input location to the production line. Stock on an input location is not taken in account to create picklist proposals.

Output location
The location where the finished products will be stored.

Rest location
Location to which the rest of used materials and ingredients are moved. It is possible to use the input location as rest location. In this case the remaining items will be ready to use for the next production order.

Parent production line
The parent production line is used if for instance the production is done in several steps. In this case the user can define the sequence of the production lines.

Production manager type
This is used when the processing of the production issues is done administratively. The setting is used only by the Production Manager.

It has two possible values:

- SPL_CONS_LOCK: When producing on the shop floor, the items to consume are not directly consumed, but they are locked. When processing the production order administratively, the

system will use the locked stock as base for the consumption.
- MPL_CONS_INPUT: When the users do not want to perform the tasks to move the correct stock to the production line when producing, this option is used. When processing the production order administratively, all stock on the input location is used as base for the consumption. Furthermore, all production orders on production lines with the same input location will be processed in 1 time.

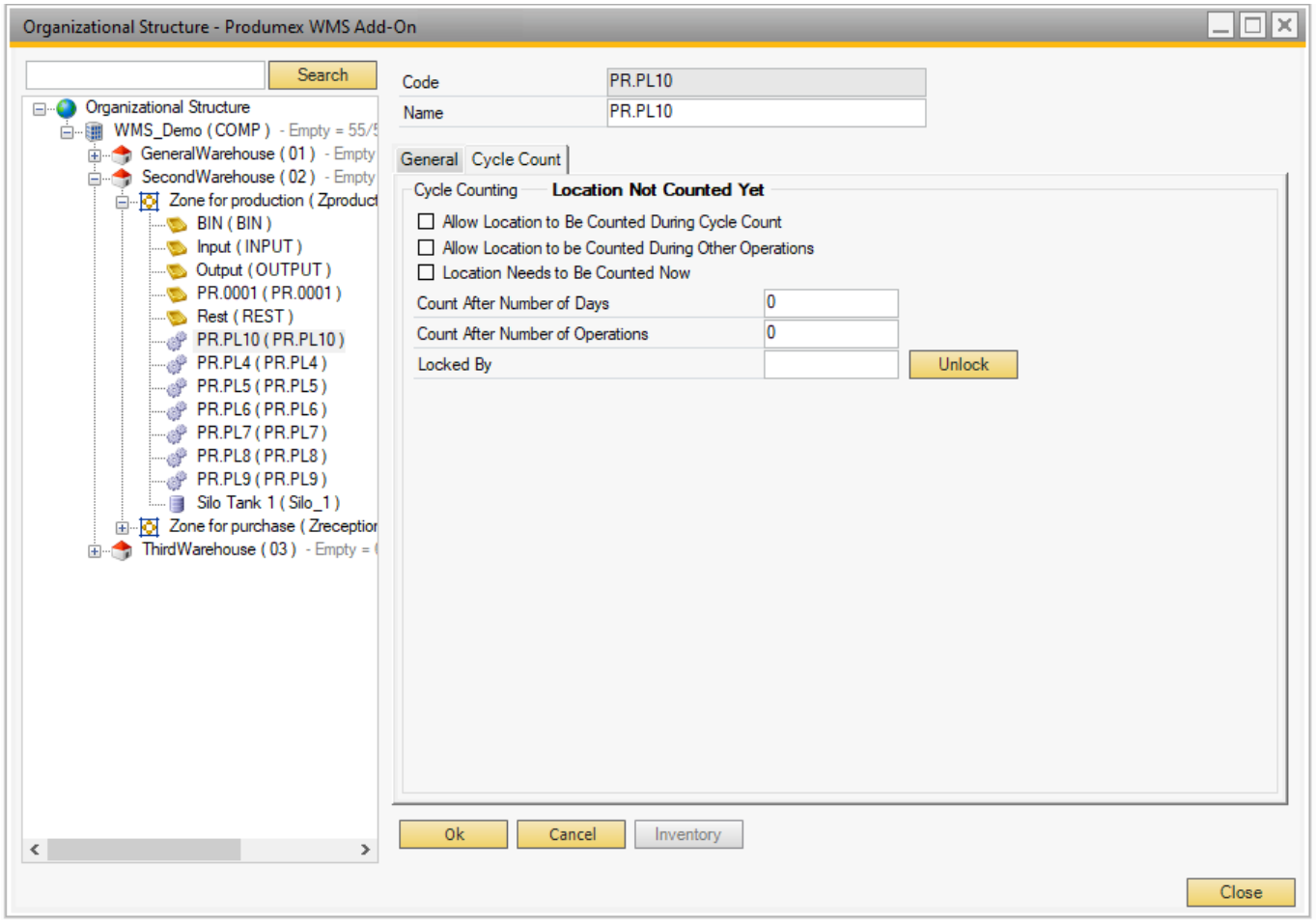
Current production order
The current production order for this production line *(read-only)*

Can be lined up
Some locations can be lined up. If a location is added here, it means the stock in this location is used directly, and does not need to be picked. This is usually used for tanks and/or silo's.
However an output location of another production line can also be set as 'lined up'. Now the produced items on the 'previous' *(linked)* production order can directly be used instead of picking the items.
Stock on possible lined up location is not taken in account to create pick list (proposals).

Produce ingredients
This option is used if a linked production order needs to automatically produce stock.
The prerequisites for this to work correctly, is that the lined up location is used as an output location on another production line. At the time of production on the shopfloor, a started production order needs to be found on the production line with as output location the lined up location.

Lined up locations
The current lined up locations

3.3.2. Cycle count



Allow location to be counted during cycle count
Is the location allowed to be counted?

Allow location to be counted during other operations
Is the location allowed to be counted during other operations? This means that when this location is used on certain flows, the system will check if a count is needed. If so, the system will ask the user to perform a count.

Locations needs to be counted now
When this option is enabled, the location will be counted, regardless of the other settings (Number of days, number of operations, ...)

Count after X days
When a location has not been counted for the number of days defined here, the location needs to be counted. If the number is 0, this setting is not taken in account, and the setting on company level is taken.

Count after X operations
If the number of operations since the last count exceeds the defined number of operations, the location needs to be counted. If the number is 0, this setting is not taken in account and the setting on company level is taken.

Locked by (read-only field)
This field shows the key of the user that is locking the location, because he needs to count the location or is currently in process to count the location.
When a location is locked, it cannot be used in other processes.

The location is released by clicking the ‘unlock’ button.
Stock on locked locations is not taken in account to create pick list (proposals).

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