

9. Finish production

Production orders can be finished in the office environment with the [Production Manager](#). When producing with the 'Production' flow, the closing of the production can also be performed on the terminal.

9.1. Office

Select the production line and click on the 'Detail' button. The 'Detail' button is only active, if there is a started production order assigned to the selected [production line](#).

The produced quantity is displayed on the screen but it cannot be modified on the [Production Manager](#).

On the 'Production detail' screen click on the 'Finish production' button. The closing process depends on the selected production manager type for the [production line](#).

9.1.1. Production manager type: SPL_CONS_LOCK

When the production manager type is set to SPL_CONS_LOCK for the Production Line, the system will use the stock locked during the production as the base of the consumption.

On the 'Stop production' window add the consumed quantities.

The lined up and not lined up components are displayed in separate sections. Different batches are displayed in separate lines. The number of the displayed rows can be limited on the [Production controller](#). Time registrations cannot be modified on the Production manager.

Not lined up ingredients

Add the used quantity to the line of the batch it was consumed from. By default the used quantity is zero. It is also possible to define the used quantity by adding the remaining quantity. Because the sum of the '# Used' and '# Remaining' quantity must be equal to the '# On line' quantity, when modifying either one of them, the other one is automatically updated.

The added consumed quantity cannot exceed the on line quantity.

By default the used weight is also zero. When adding the used or the remaining quantity of a catch weight item, the system automatically fills the standard weight based on the ingredient's catch weight settings. It is possible to modify the weight within the allowed quantity tolerance defined in the Item Master Data.



When the 'Use waste?' option is enabled in the Production controller, the waste quantity and the waste weight can be added as well. In this case the # On line quantity equals with the sum of the # Used, # Rest and # Waste quantities. After modifying two of those fields, the system automatically updates the third one. The # waste field can only be modified if the 'Allow waste to be editable when finishing production on production manager?' option is set to true in the [Production controller](#).

When there are serial numbered items among the ingredients, the serial numbers of the consumed

product must be selected. Click on the serial number field in the line of ingredient managed by serial numbers. A 'Serial Number Selection' window will open up. Select the serial numbers of the consumed products.



Lined up ingredients

Since the used quantity of the lined up ingredients cannot be measured, define it by modifying the quantity remaining in the tank. The # used quantity cannot be changed directly. The system will calculate the used quantity by subtracting the remaining quantity from the in tank quantity before the production.

9.1.2. Production manager type: MPL_CONS_INPUT

When the production manager type is set to MPL_CONS_INPUT for the Production Line, every production order started on a production line with the same input location as the selected production line will be closed in one step. The system will use the stock on the input location as the base of the consumption.

9.1.2.1. Confirm material consumption

On the 'Stop production' screen started production orders assigned to production lines with the same input location are listed.

The lined up and not lined up components for the selected production order are displayed in separate sections. Different batches are displayed in separate lines. The number of the displayed rows can be limited on the [Production controller](#). Time registrations cannot be modified on the Production manager.

Not lined up ingredients

When the production manager type is MPL_CONS_INPUT, the used quantity and weight cannot be modified.

The system will issue the entire stock located on the input location for the component. When the production orders have common materials, the system will divide the stock to issue between the production orders based on the theoretical quantities of the component.

Lined up ingredients

Since the used quantity of the lined up ingredients cannot be measured, define it by modifying the quantity remaining in the tank. The # used quantity cannot be changed directly. The system will calculate the used quantity by subtracting the remaining quantity from the in tank quantity before the production.

9.1.3. Close the production

To close the production, press the 'Stop production' button.
After the button has been pressed,

- the system will remove the lock from the components
- the used and waste quantity of the ingredients will be issued and an 'Issue for production' document will be created. Waste quantities are displayed in separate lines and indicated as waste in the 'Issue for production' document. For more information about additional Produmex production issue lines see: 3.3.4. Production issue lines.
- the remaining quantity of the ingredients will be moved to the rest location of the production line and a 'Move' document will be created
- the used quantities will be added to the 'Issued' field of the production order
- both the SAP and Produmex status will be changed to 'Closed' on the production order



9.2. Shopfloor

For the detailed description about finishing the production on the shopfloor see:
8.2.1.2 End production 8.3.9. End production (disassembly)

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