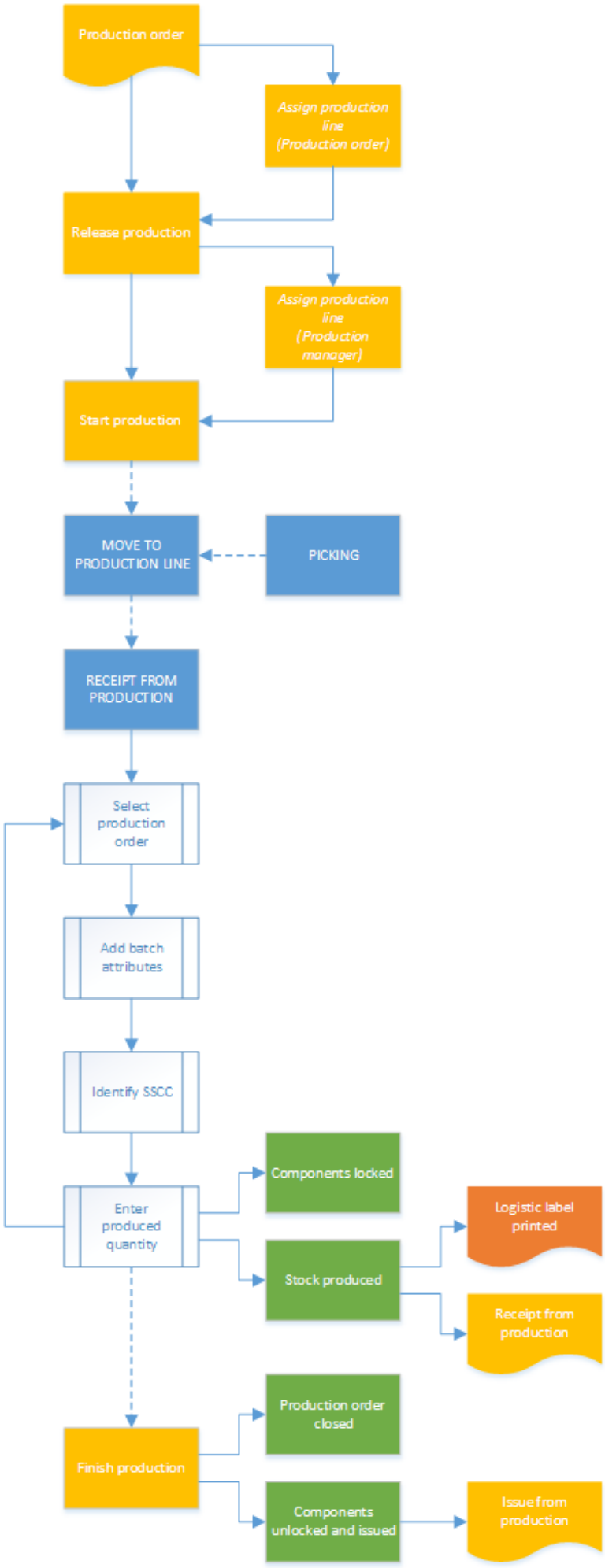
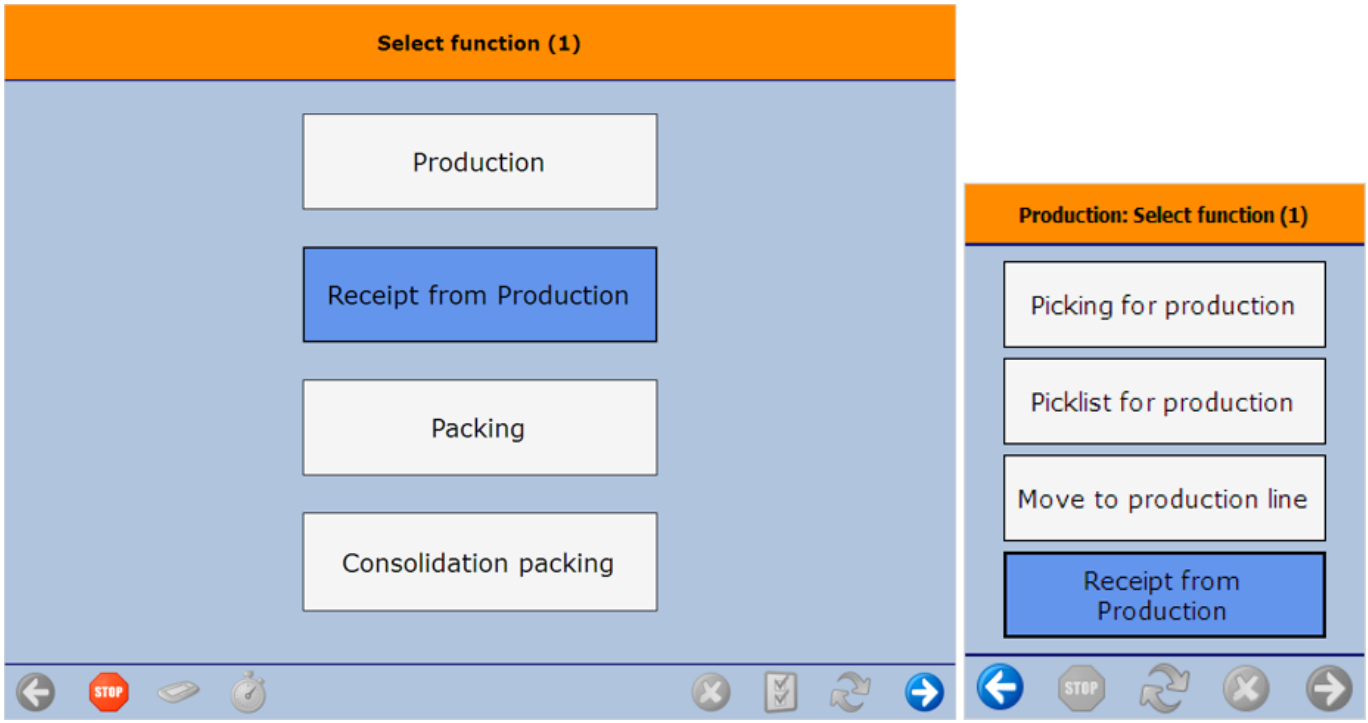
Receipt from Production Flow


Production order
Assign production line (Production order)
Release production
Assign production line (Production manager)
Start production
MOVE TO PRODUCTION LINE
PICKING
RECEIPT FROM PRODUCTION
Select production order
Add batch attributes
Identify SSCC
Components locked
Enter produced quantity
Logistic label printed
Stock produced
Receipt from production
Production order closed
Finish production
Components unlocked and issued
Issue from production

- Production order
- Release production order
- Release production order
- Production picking
- Production move
- Production receipt
- Select production order
- Identify batch
- Identify SSCC
- Identify batch
- Production
- Finish production

To initiate the flow, press the 'Receipt from Production' button on the terminal or on the scanner.



1. Select a production order

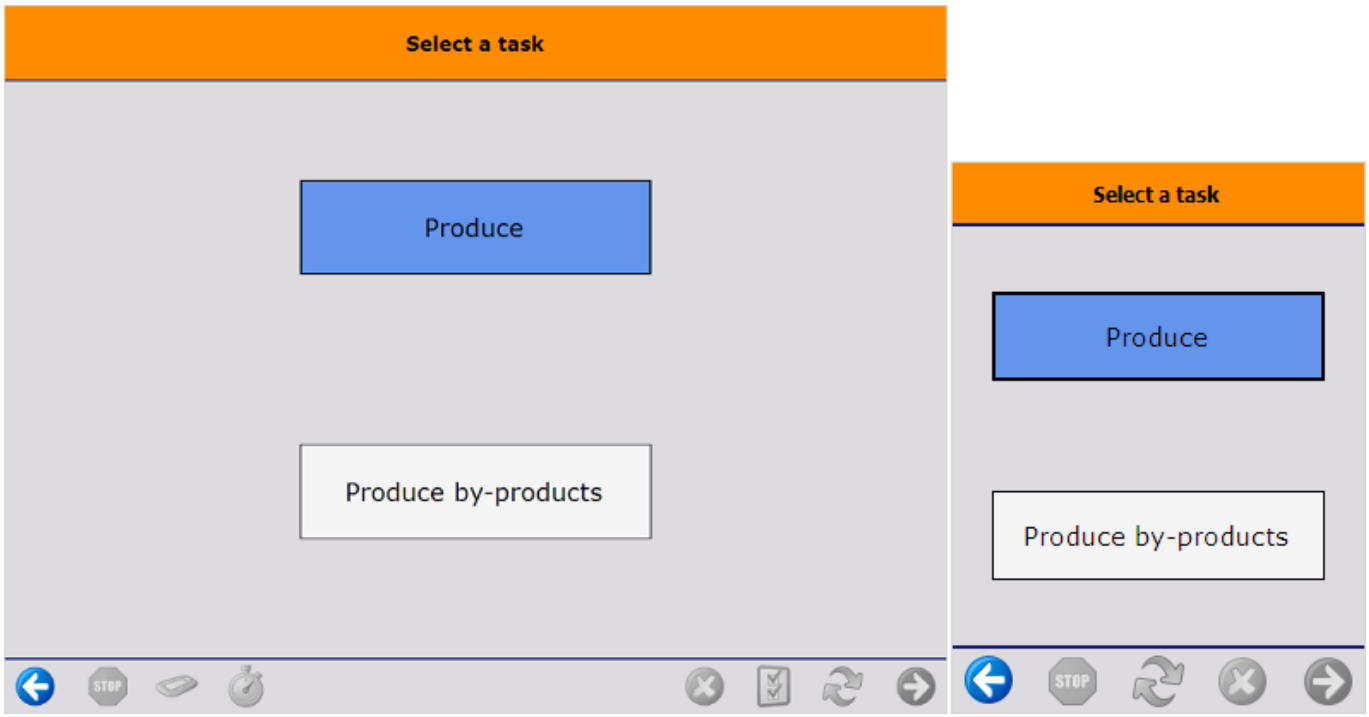
Select a production order from the list and press the right arrow button to proceed.
When using the default settings, only the production orders with 'Started' status are displayed in the list.
When the 'Allow starting production order on receipt flow' option is set to true on the Production controller, the released production orders with an assigned production line are displayed on the list too. The system will automatically change the status to 'Started' when proceeding with these orders.

On the scanner, 'Started' orders are indicated with an icon. 'Standard' and 'Special' type flows are indicated with the icon. 'Disassembly' productions are indicated with the icon.
After the production order has been selected, the system checks whether there are enough stock on

the production line to produce. When there is not enough stock to produce, an error message is shown.

2. Select a task

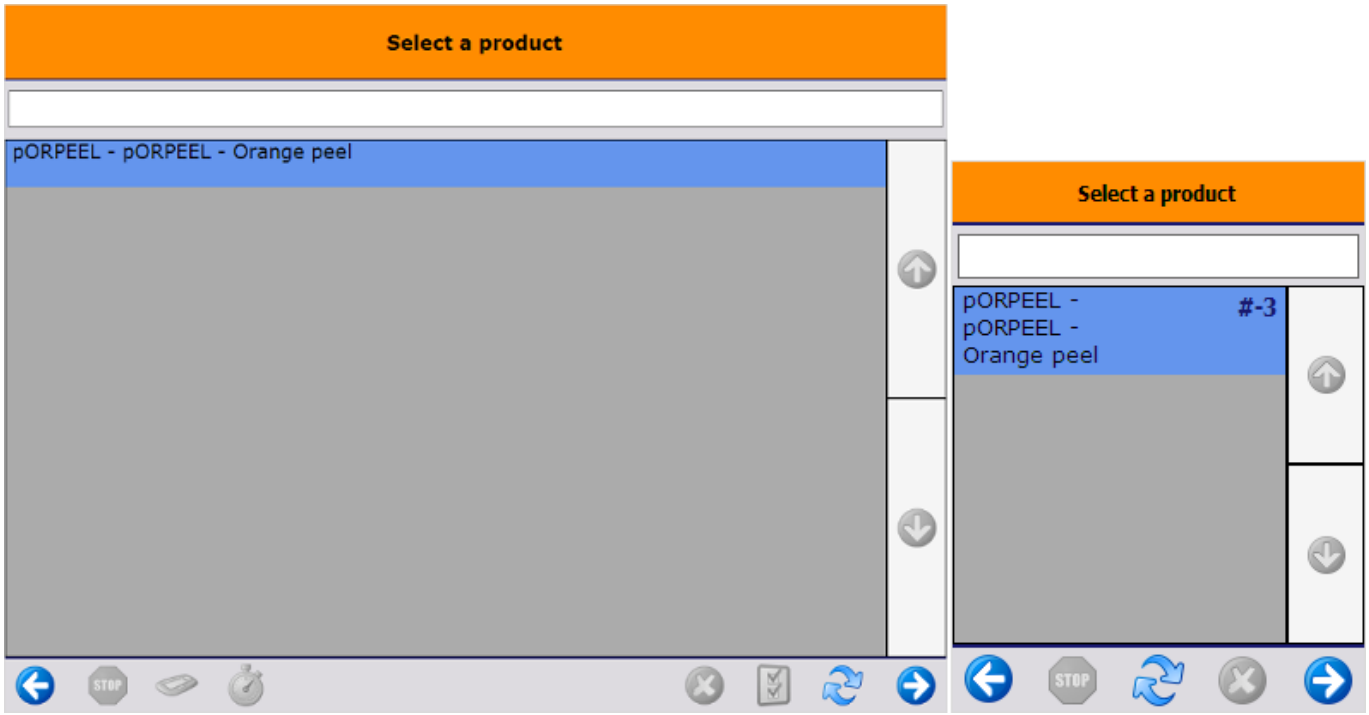
If there is a by-product line on the production order, the Select task screen opens. This screen is automatically skipped if the production order does not contain by-products.



To produce the main product, press the ’Produce’ button.

To produce by-product(s), press the ’Produce by-products’ button. On the next screen select a by-product to produce from the list. Every by-product from the production order is listed.

The steps of main product and by-product production are similar. The differences are described at each given step.



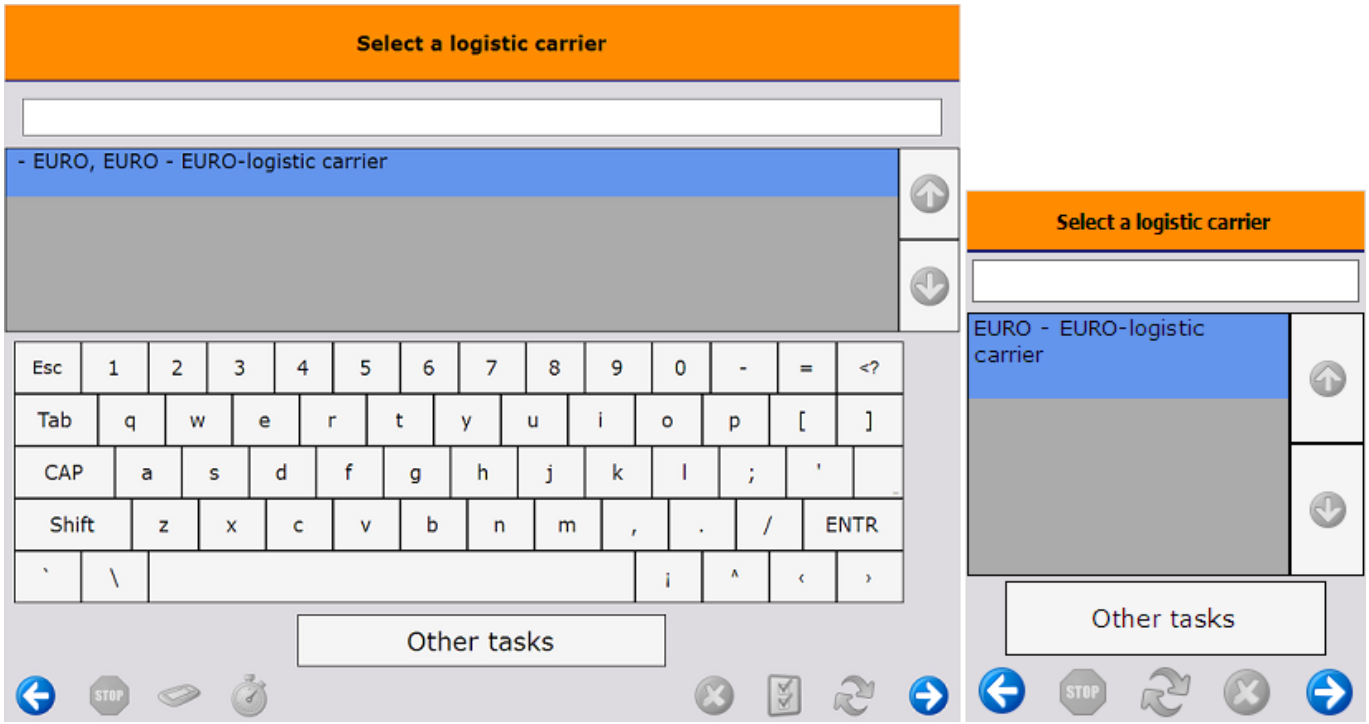
3. Identify batch

Depending on the batch number settings for production the system might ask to enter the batchnumber, if the product is managed by batches.
Depending on the best before date settings for production, the system might ask to enter the best before date, if the product has a best before date.

When the product has batch attributes, the system asks for adding those attributes too.

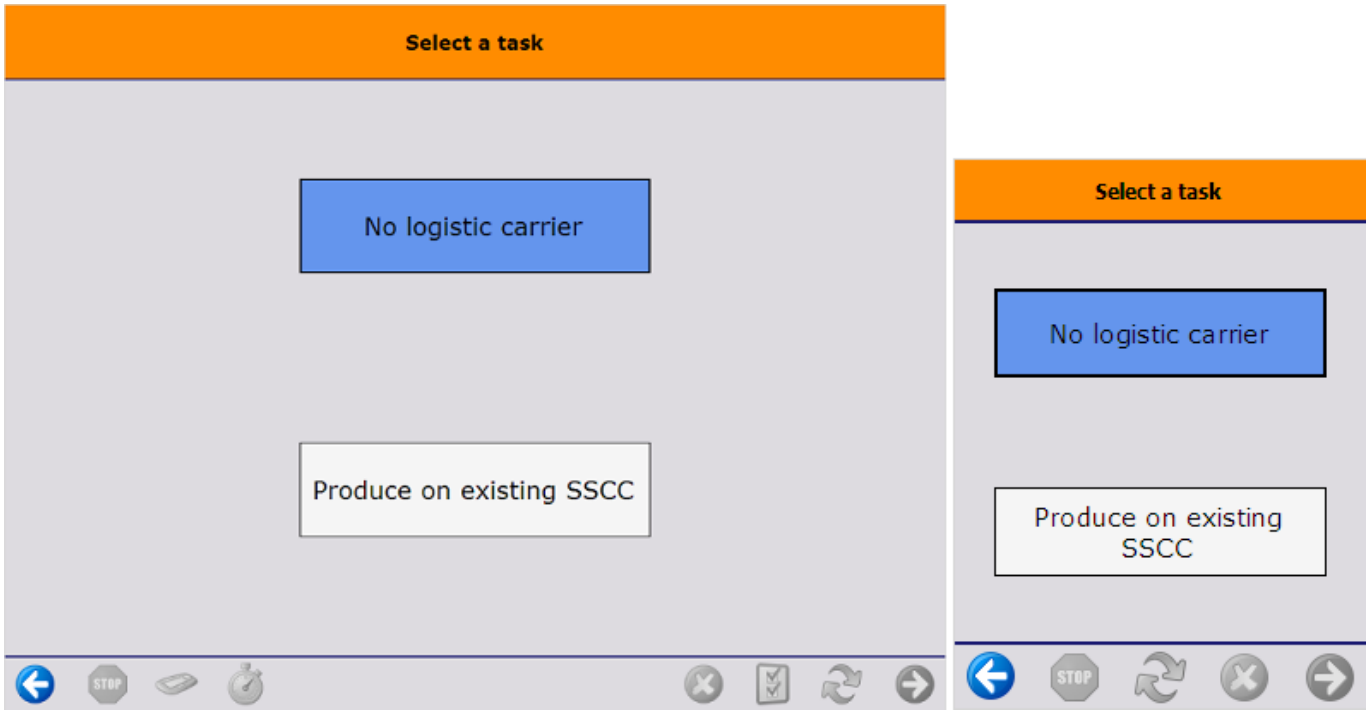
4. Select logistic carrier and identify the SSCC

Then select the logistic carrier from the list. Every logistic carrier that has stock on the *'Stor. Loc. logistic carriers'* location for the warehouse is listed.

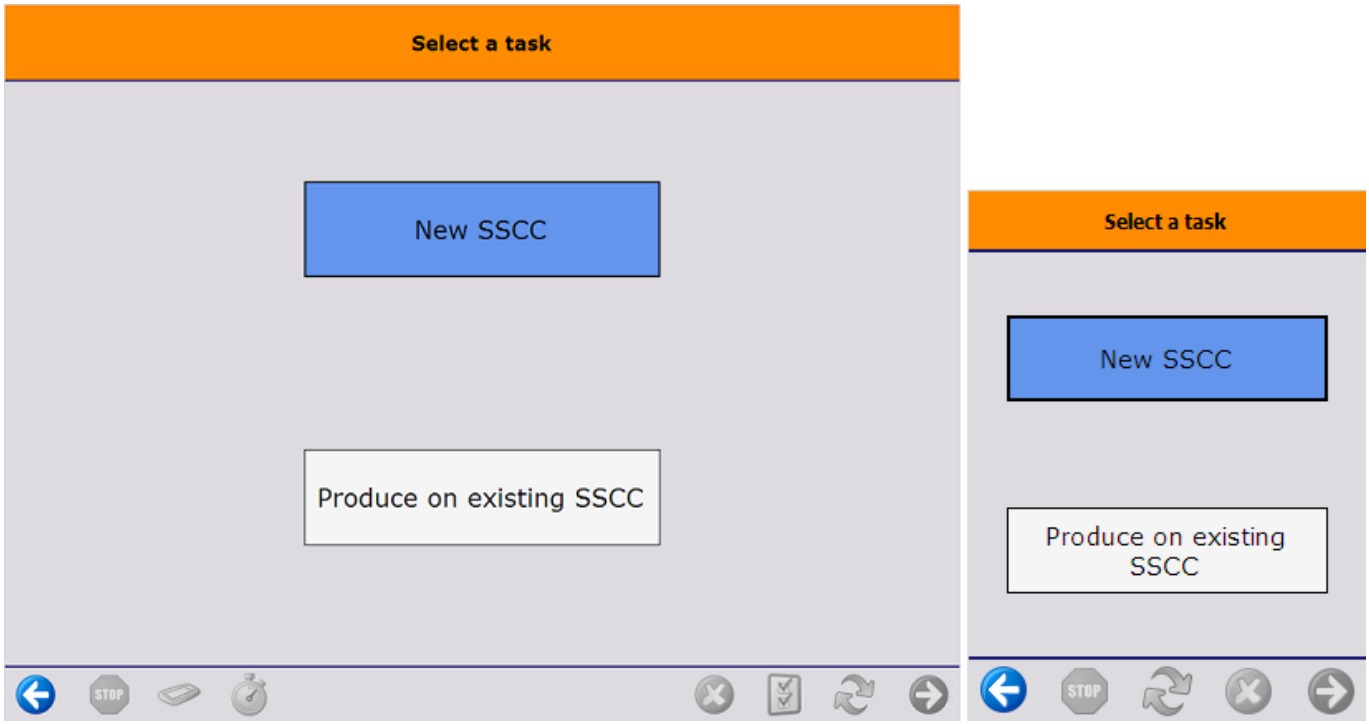


To produce without a logistic carrier press the ‘Other tasks’ button. On the next screen select a task:

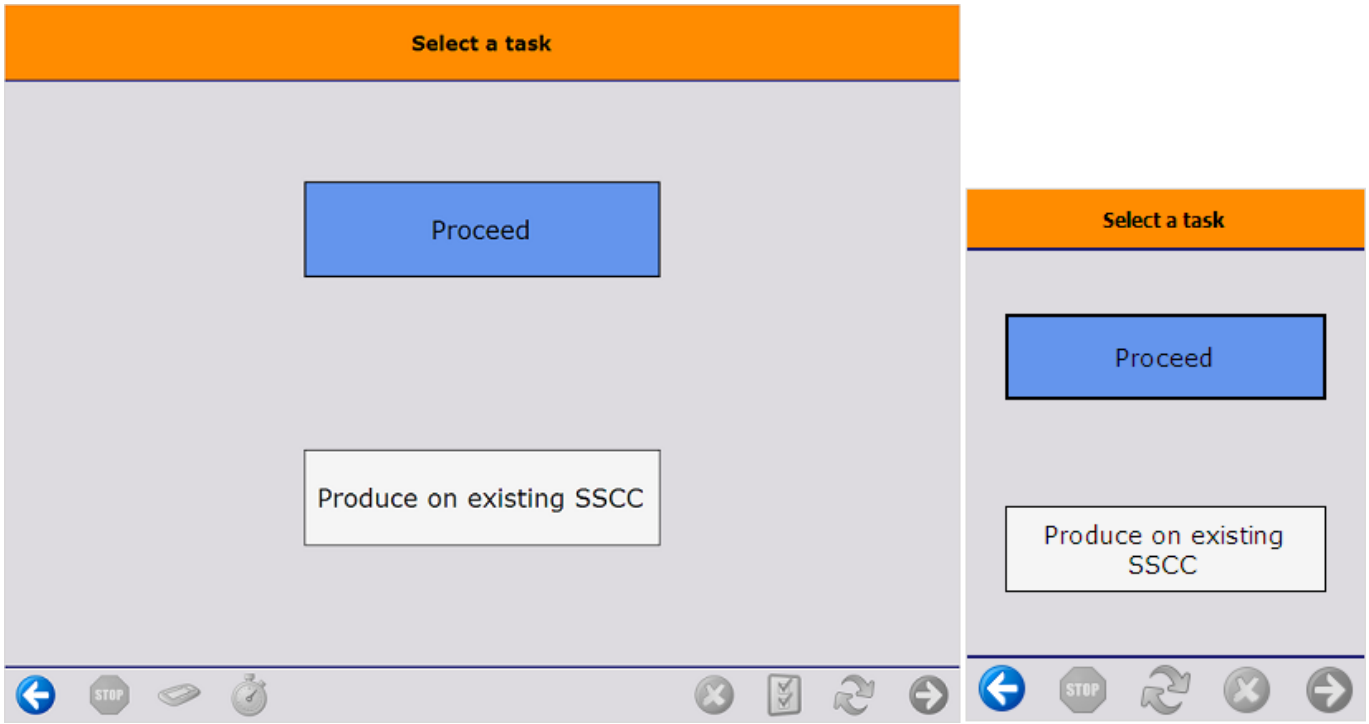
- Press the ‘No logistic carrier’ button to produce onto a new SSCC.
- Press the ‘Produce on existing SSCC’ button to produce onto an existing SSCC. On the next screen scan the target SSCC.



The system automatically proceeds to the Select a task screen and skips the Select a logistic carrier screen if there is no available logistic carrier on the *‘Stor. Loc. logistic carriers’* location or if the company does not use logistic carriers. In this case the ‘New SSCC’ button is displayed instead of the ‘No logistic carrier’ button. Press this button to produce onto a new SSCC. No logistic carrier will be linked to the produced item.



The system also proceeds automatically if the product has a ‘Default log. car. production’ set on the Produmex Production tab of the Item Master Data. In this case a ‘Proceed’ button is displayed instead of the ‘No logistic carrier’ button. Press this button to create a new SSCC with a linked logistic carrier.



5. Enter the quantity produced

After the SSCC has been defined, add the produced quantity. By default the planned quantity is displayed, but it is possible to produce different quantities.
The maximum of the produced quantity for the main product is calculated based on the following values:

- base quantity of the components from the production order
- the quantity tolerance of components set in the production order
- the available quantity on the production line

Note: lined up components and time registration items are not taken into account when calculating the maximum quantity.

The calculation of the maximum quantity occurs in three steps:

- First the system calculates the maximum producible quantity for each material based on only that material.
  Maximum quantity = Quantity on the production line/ (base quantity *(1-quantity tolerance))
- Then the system selects the lowest value from the maximum producible quantities. To define the maximum quantity, the system rounds down that value to the decimal places specified for the uom in the Item Master Data of the product.



The produced quantity for by-products is not limited by the available quantity of the materials on the production line.

5.1. Enter the weight

In case of producing a catch weight item, enter the produced weight too. The maximum weight is calculated from the produced quantity, the default weight and the weight tolerance defined in the Item Master Data of the product.



If the *Weight Capture needed during Production* setting is enabled on Item Master Data > Produmex tab > Production tab, the system displays the *Enter the weight* screen during the flow. In this case the product / by-product must be weighed with a scale.

- Prerequisites: You must define a scale for the production line or the output location of the production line in the Organizational Structure.
- The setting applies to items that are not managed by serial numbers.
- If the item is a catch weight item, you can weigh the item after the first quantity has been added.



5.2. Items managed by serial numbers

When the item to produce is managed by Produmex or ‘On release only’ type serial numbers, it is possible to add the quantity by scanning the serial numbers or by entering the quantity.
When the item to produce is managed by ‘On every transaction’ type serial numbers, the quantity can only be added by scanning the serial numbers.
For more information about quantity entering methods see: Screens for entering additional

information.

6. Production

After the quantity has been added, the product is produced and the system moves the product to the output location. The quality status of the received product is the quality status set as the *Quality status production* on the Production tab of the Organizational Structure.

When the product is produced, the system locks the consumed stock. The locked quantity is calculated from the produced quantity and the base quantity of the component. Materials are not locked for by-products.

Documents:

- When producing by-products, the system creates a receipt for production document for the by-product and no other documents.
- When producing the main product, the system creates a receipt for production document for the main product and issue for production documents for material items which are on lined up location with direct consumption setting.

7. Print event

If set in the Organizational Structure, the *'Production: logistic unit produced event (400)'* print event is triggered and the Production label is printed. The default report of the print event is *DefaultProductionLabel.rpt.*

8. Item produced

On the screen the 'The item is produced' message is displayed. Press 'Ok' to go back to the 'Select a production order' screen. When the 'Proceed with current production order after entering quantity on prod. receipt flow?' option is set to true in the Production controller, the system automatically proceeds with the current production order.

If the production order is not closed, it is possible to produce more than the planned quantity.

Close the production in the Production Manager.

If the *Automatically close production orders on completion? (Y/N)* setting is enabled on the production controller, the production order is automatically closed when the planned quantity for the main product has been reached. The Issue for Production documents are booked with the planned quantities and the components are issued.

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