

Apparel & Footwear

Production Process

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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. The header includes fields for Customer (C0003), Name (MAX Fashion), Contact Person, Customer Ref. No., and Local Currency. The right side shows order details: No. (New1), 1, Status (Open), Posting Date (09/01/17), Delivery Date (11/01/17), and Delivery Date (09/01/17). The main table lists items with columns for Item No., BP Catalog No., Item Description, and Quantity. The items are: 1. CT002-GRN- (Casual Trouser 2 Green), 2. CT002-GRU- (Casual Trouser 2 Grun), 3. CT002-PNK- (Casual Trouser 2 Pink F), and 4. A right-click context menu is open over the table, showing options like Cancel, Close, Duplicate, Row Details..., New Activity, Gross Profit..., Volume and Weight Calculation..., Opening and Closing Remarks, Transfer Request, Item Transfer, Generate Pick List, View Pick Lists, Related Activities, Related Opportunities, Relationship Map..., Critical Path OverView, Stock Allocation, View allocation Data, and Copy Order to Manufac. Order (highlighted). The bottom right shows a summary table with Total (LC) and Whse values: INR 17,000.00, INR 10,200.00, INR 6,800.00, and a total of INR 34,000.00. The bottom left has buttons for OK, Cancel, and Add A. F. Items.

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

Total (LC)	Whse
INR 17,000.00	01
INR 10,200.00	01
INR 6,800.00	01
Total	

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

The screenshot shows the 'Manufacturing Order' form. At the top, there are fields for 'Order Number' (47), 'Doc. Numbering' (Manual), 'Cut Ticket Date' (11/02/17), 'Due Date', 'PDC Segmentation', 'User' (manager), and 'Customer'. Below these are tabs: 'Contents', 'Details', 'Operations', 'Cost Summary', 'Planning', and 'UDF'. A 'Set all status to' dropdown is present. The main table has columns: '#', 'PO Entry', 'PO No.', 'Status', 'Model Product', 'Item Code', 'Item Description', and 'Planned'. A right-click context menu is open over the table, listing options: 'Copy', 'View Balance', 'Reload BOM', 'Report Completion', 'Bar Code Printing', 'Add Any Item', 'Import Sales Order' (highlighted), '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', and 'View allocation Data'. At the bottom, there are 'Add' and 'Cancel' buttons, and a 'Remarks' field. On the right side, there are buttons for 'Add Any Item' and 'Add A. F. Items'.

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

The screenshot shows the 'Manufacturing Order' form with the 'Add A. F. Items' dropdown menu open. The menu lists three options: '1 - Apparel' (selected), '2 - Fabric', and '3 - SHOES'. The form fields and tabs are the same as in the previous screenshot. The main table has columns: '#', 'PO Entry', 'PO No.', 'Status', 'Model Product', 'Item Code', 'Item Description', 'Planned', 'Recived From Contractor', 'Completed', and 'Rejec...'. Below the main table, there is a 'Total Units' section with columns: '#', 'Item Code', 'Item Description', 'Base', 'Planned', 'Issued', and 'Available'. At the bottom, there are 'Add' and 'Cancel' buttons, and a 'Remarks' field. On the right side, there are buttons for 'Add Any Item' and 'Add A. F. Items'.

Manufacturing Order

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

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

Buttons: Add, Cancel, Calculate ATP, View ATP, View ATP overall details

Remarks:

Buttons: Add, Cancel, Add Any Item, Apparel

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 Number: 36, Cut Ticket Date: 05/12/16, User: manager
 Doc. Numbering: Manual, Due Date: 05/12/16, Customer: ,
 Code: 36, PDC Segmentation: , 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	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	000165	000165-BLU-34	Jeans Blue Pant 34	1.00	0.00	0.00
3	<input checked="" type="checkbox"/>	298	298	Planned	000165	000165-BLU-34	Jeans Blue Pant 34	1.00	0.00	0.00
4	<input checked="" type="checkbox"/>	299	299	Planned	000165	000165-BLU-34	Jeans Blue Pant 34	1.00	0.00	0.00

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

Buttons: 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:

Buttons: Update, Cancel, Add Any Item, Apparel

The setting that release automatically the order is “Auto Release”.

Go to: Apparel and Footwear / Administration / Setup / General setting / production tab

The screenshot shows the 'Apparel And Footwear Setup' window with the 'Production' tab selected. The 'Auto Release' checkbox is checked and highlighted with a green box and a red arrow. Other settings include 'Default Price List' set to 'Sales', 'Default Sales Price List' set to 'Sales', 'Default Currency' set to 'USD', and 'Bad Qty Warehouse' set to '03'. The 'Cut Ticket' section has several checkboxes, including 'Display a warning in Cut Tickets when components falls into negative stock' which is checked. The 'Send Out' section has 'Goods Issue Decrease Account' set to '100011'. The 'General' section has 'Auto Release' checked, 'Issue from Production Automatically' checked, 'Create Good Issue Autom. Special Orders' checked, and 'Use Advance Cost Sheet' checked. The 'Consumption By Pattern' checkbox is also checked.

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

The screenshot shows the 'Manufacturing Order' window with the 'Operations' tab selected. The 'Operations' section shows a list of operations with their descriptions and status. The operations are: 141 (Sewing), 142 (Packing), 143 (QA), and 144 (Cutting). All operations are marked as 'Open'. The 'Contractor' section shows a list of contractors with their user, barcode, planned quantity, issue quantity, and received quantity. The contractors are: manager (0000014100017), manager (0000014100024), manager (0000014100031), and manager (0000014100048). The 'Planned Qty' for all contractors is 1.00, and the 'Issue Qty' is 1.00. The 'Received Qty' is 0.00 for all contractors.

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.

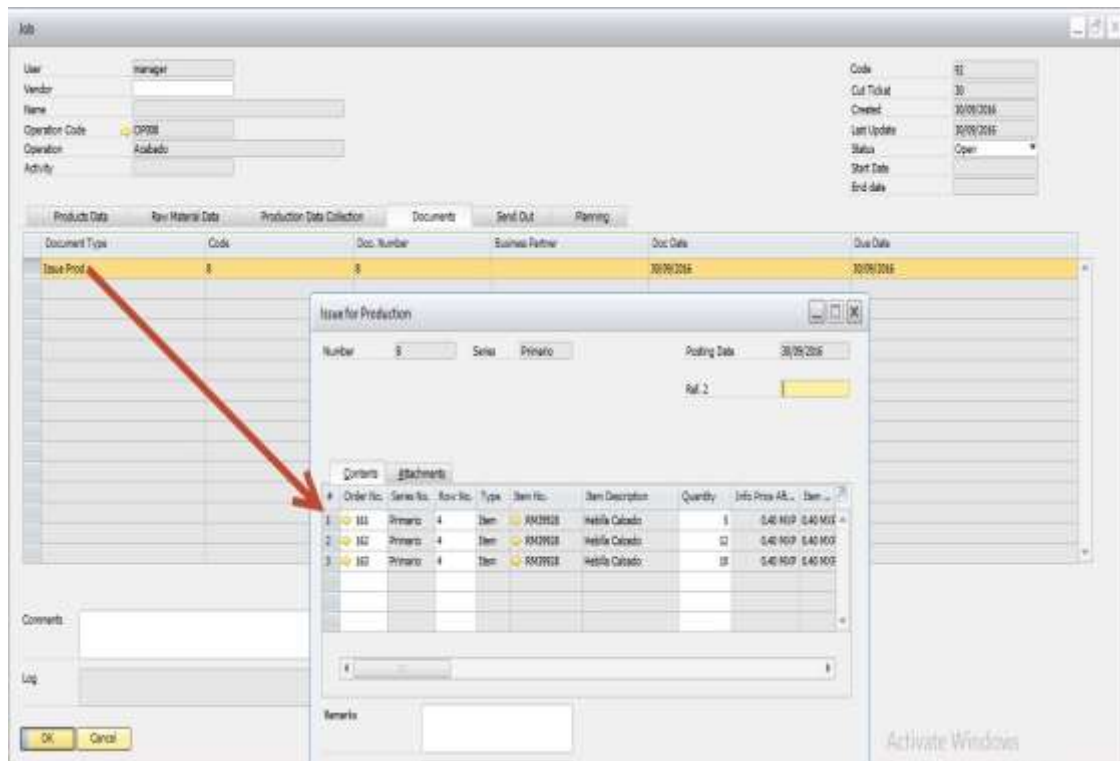
1.4 Release planned quantity automatically from PDC

In order to automate the process of releasing raw materials, there is an option to trigger this action.

All materials with manual issue method linked to an operation, release the planned BOM quantity automatically when the PDC is created. This will increase the WIP cost and avoid manual user intervention.

[illegible][illegible]

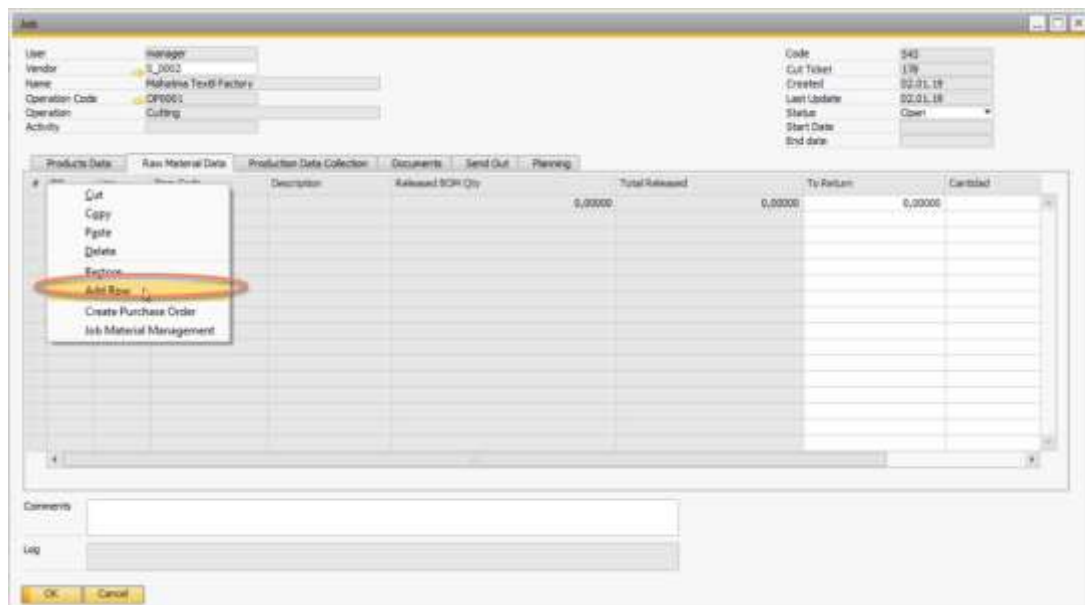
The issue for production is created in the background.



1.5 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 Ticket:
Created:
Last Update:
Status:
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	Caridad

Select Materials

ItemCode	ItemName	PlannedQty
JMTF	3M Thinsulate Featherless	15,00000
ET #608078-21	Etiqueta Nike TOR Rouge	15,00000
FB_0002-BLK	DrFit Fabric Black	22,50000

Comments:

Log:

OK Cancel

Add Cancel

- And Finally Update the Job

Job

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

Code: 943
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	Caridad
1	883	3	JMTF	3M Thinsulate Featherless	5.000.000,00000	0,00000	0,00000	
2	884	3	JMTF	3M Thinsulate Featherless	5.000.000,00000	0,00000	0,00000	
3	885	3	JMTF	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	

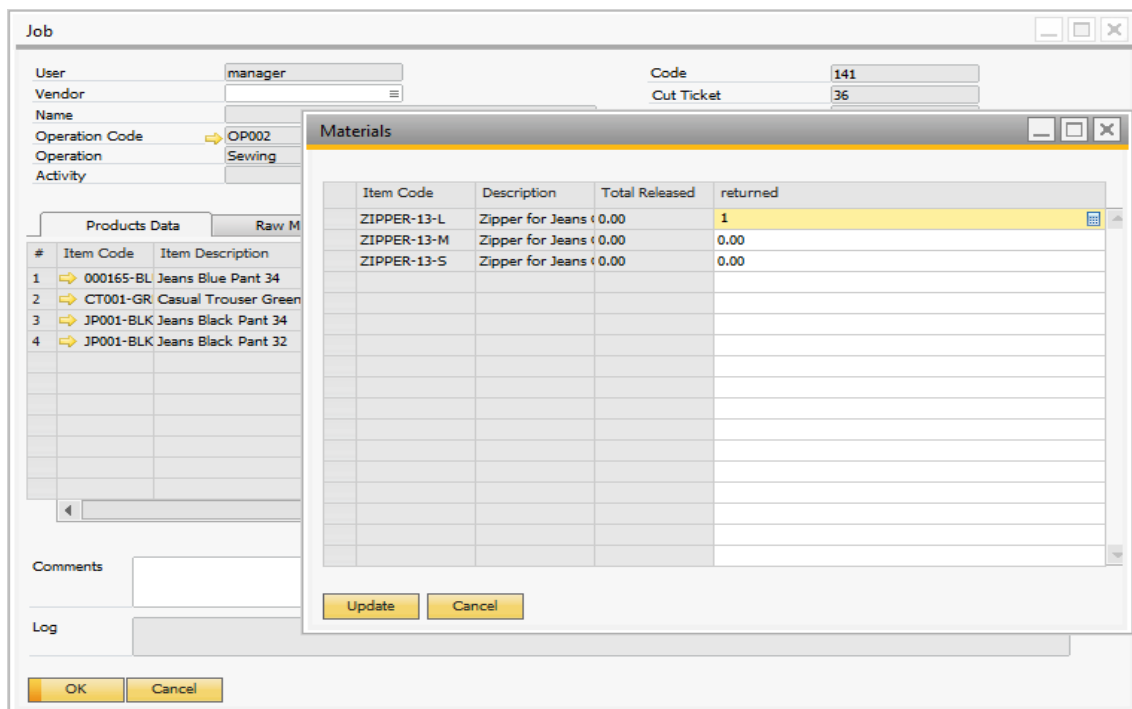
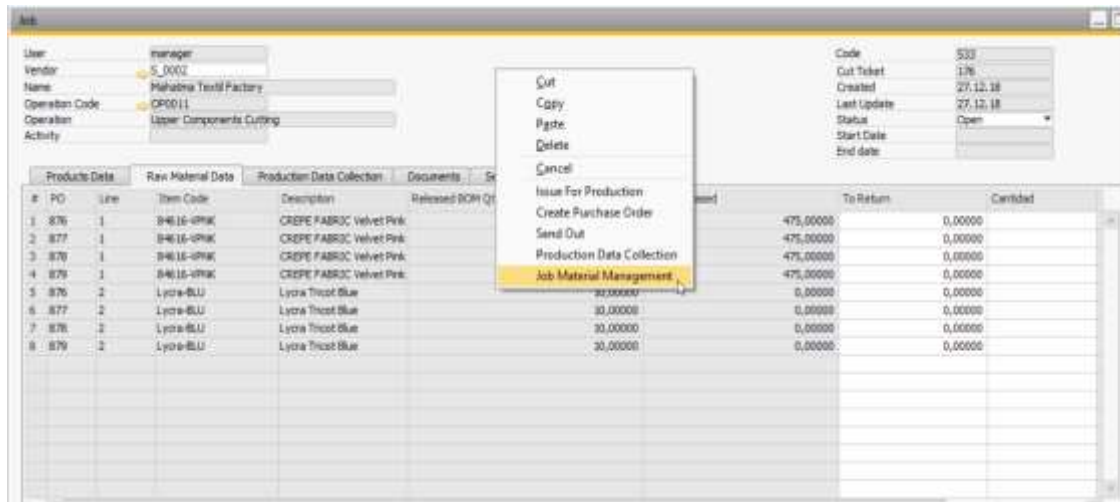
Comments:

Log:

Update Cancel

1.6 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.



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?

?

Yes

No

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...

Update

Cancel

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 its generated and its 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	118012001	Standard Cotton Fabric Navy Blue		100	\$
2	171	Primary	Item	118012001	Standard Cotton Fabric Navy Blue		100	\$
3	172	Primary	Item	118012001	Standard Cotton Fabric Navy Blue		100	\$
4	173	Primary	Item	118012001	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: 46 Cut Ticket Date: 10/04/16
Doc. Numbering: Manual Due Date: 10/07/16
Code: 46 POC 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	808080740010	100.000
	manager	808080740025	100.000

Material Management

- Cut
- Copy
- Paste
- Delete
- Filter Table
- View Balance
- Reload BOM
- Date Selection
- Report Completion
- Bar Code Printing
- Add Item
- Material Management
- Import Sales Order
- Close all lines
- Release Order
- Copy Prod. Orders generated from MRP
- Print Production Order
- Copy from Demand Planning (Vologs)
- 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.)

- 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.

Material Management

General Replacement Adjustment Add New Lines

#	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.	Item
198	RM0011000	Sta
199	RM0011010	Sta
200	RM0012001	Sta
201	RM0012920	Sta
202	RM0012991	Sta
203	RM010	Ha
204	RM011	Pol
205	S1001-1000-5	Din
206	S1001-1000-5.5	Din
207	S1001-1000-6	Din

Choose Cancel New

- Add new lines (if an additional item is needed)

Adds new material to ALL BOMs that are selected.

Material Management

General Replacement Adjustment Add New Lines

#	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

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.

Non Productive Times

#

Code

Name

Time

1

Lunch

Lunch

12

2

OK

Cancel

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 Product

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: Barriosueto, Enlla
 Posting Date: 07/05/2015 Shift:
 Variant:
 Minutes Presence:
 Unproductive Minutes:

#	Str Code	Cutback#	PO	Model Code	Description	Color	Scale	Size	Variable	Work Center	Resource	Stage	Operation Code	Operation	Qty	Ref Qty	PlanQty
1	00000001000	1		BU2304	Busto Volcom 2012	S-XL	S					1	OP001	Corte	100.000	0.000	0.000
1	00000001000	1		BU2304	Busto Volcom 2012	S-XL	M					1	OP001	Corte	200.000	0.000	0.000
1	00000001000	1		BU2304	Busto Volcom 2012	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

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: []

General

- ☐ Bess 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

Use Standard Exchange Rate: ☐
 Standard Exchange Rate Date: []
 Use Exchange Rate Date from Cost Sheet: ☐
 Use Patterns in Cost Sheet: ☐
 BarCode: ☐ Use Group Number
 Extra Cost Item: []

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
 UoM Name: []
 Weight: []

☐ 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: Posting Date: 26/11/2018 Minutes Presence: 0,00 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

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
 Vendor:
 Name:
 Operation Code: Corte
 Operation: Cortes
 Activity:
 Code: 22
 Cut Ticket: 8
 Created: 27/11/2018
 Last Update: 27/11/2018
 Status: Open
 Start Date:
 End date:
 Comments:
 Log:
 OK Cancel

#	Item Code	Item Description	Group#	Bar Code	Issued	Planned	Received	Bad Qty	Comments
1	Pjama-C_004-S	Pjama T-Rex Azul Scale_Jean S	9-36-Pjama-C_004-S	000002200019	3,000	3,000	3,000	0,000	
2	Pjama-C_004-M	Pjama T-Rex Azul Scale_Jean M	9-37-Pjama-C_004-M	000002200026	3,000	3,000	3,000	0,000	
3	Pjama-C_004-L	Pjama T-Rex Azul Scale_Jean L	9-38-Pjama-C_004-L	000002200033	3,000	3,000	3,000	0,000	
4	Pjama-C_004-XL	Pjama T-Rex Azul Scale_Jean XL	9-39-Pjama-C_004-XL	000002200040	3,000	3,000	3,000	0,000	
5	Pjama-C_005-S	Pjama T-Rex Verde Scale_Jean S	9-40-Pjama-C_005-S	000002200057	4,000	4,000	2,000	2,000	
6	Pjama-C_005-M	Pjama T-Rex Verde Scale_Jean M	9-41-Pjama-C_005-M	000002200064	4,000	4,000	4,000	0,000	
7	Pjama-C_005-L	Pjama T-Rex Verde Scale_Jean L	9-42-Pjama-C_005-L	000002200071	4,000	4,000	4,000	0,000	
8	Pjama-C_005-XL	Pjama T-Rex Verde Scale_Jean XL	9-43-Pjama-C_005-XL	000002200088	4,000	4,000	4,000	0,000	
9	Pjama-C_005-S	Pjama T-Rex Verde Scale_Jean S	9-43-Pjama-C_005-S	000002200095	2,000	0,000	0,000	0,000	Rework

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

Production Data Collection

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

PDC Entries Non Productive Time Quality/Defects

#	Bar Code	CutTicket#	PO	Model Code	Description	Color	Scale	Size	Variable	Work Center	Resource	Stage	Operation Code	Operation	PlanQty	Qty	Bad Qty
1	0000000000013	6	23	Mod_01	Mod_var2	C_001	Scale_001	S	V2	Corte	Cortadora 1	8	Corte	Cortas	1,000	-1,000	0,000
2	0000000000075	6	23	Mod_01	Mod_var2	C_001	Scale_001	S	V2	Corte	Cortadora 1	8	Corte	Cortas	0,000	1,000	0,000

Add Cancel Clear All Clear

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:

Vendor	Bar Code	CutTicket#	Model Code	Description	Color	Scale	Size	Variable	Stage	Operation Code	Operation	PlanQty
<input type="checkbox"/>	0000000000013	5	Mod_02	Mod_02	C_001	Scale_001	S	V2	8	Corte	Cortes	1,000
<input type="checkbox"/>	0000001500066	10	Pjama	Pjama T-Ren	C_005	Scale_001	M		15	packaging	packaging	2,000
<input type="checkbox"/>	0000001500071	10	Pjama	Pjama T-Ren	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.

[illegible]

- Defects

[illegible]

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 Number45

Doc. Numbering Code45

Cut Ticket Date10/04/16

Due Date11/27/17

PDC Segmentation

Contents

Details

Operations

Cost Summary

Planning

UDF

Operation CodeOPS

StageItem DescriptionOperation No.

174OP01

275OP02

376OP03

Contractor

User

Barcode

Planned Qty

manager

manager

0000007400018

0000007400025

100.000

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

Relase Order

Copy Prod. Orders generated from MRP

Print Production Order

Copy from Demand Planing (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

Code45

Cut Ticket No.

Materials

Productive Operation

Non-Productive Operation

#	Posting Date	Prod. Ord. No.	Warehouse	Item Code	Description	Quantity	Cost	Total Cost	Operation
1	10/04/16	135	01	00000001	Standard Cotton Fabric Navy Blue	9.000	\$ 0.96	\$ -35.83	Cutting / Corte
2	10/04/16	136	01	00000001	Standard Cotton Fabric Navy Blue	9.000	\$ 0.96	\$ -35.83	Cutting / Corte
3	10/04/16	137	01	00000001	Standard Cotton Fabric Navy Blue	9.000	\$ 0.96	\$ -35.83	Cutting / Corte
4	10/04/16	138	01	00000001	Standard Cotton Fabric Navy Blue	9.000	\$ 0.96	\$ -35.83	Cutting / Corte
5	10/04/16	139	01	00000001	Standard Cotton Fabric Navy Blue	2.388.000	\$ 0.96	\$ 2304.11	
6	10/04/16	140	01	00000001	Standard Cotton Fabric Navy Blue	2.388.000	\$ 0.96	\$ 2304.11	
7	10/04/16	141	01	00000001	Standard Cotton Fabric Navy Blue	2.388.000	\$ 0.96	\$ 2304.11	
8	10/04/16	142	01	00000001	Standard Cotton Fabric Navy Blue	2.388.000	\$ 0.96	\$ 2304.11	
9	10/04/16	143	01	00000001	Standard Cotton Fabric Navy Blue	9.000	\$ 0.96	\$ -47.32	
10	10/04/16	144	01	00000001	Standard Cotton Fabric Navy Blue	9.000	\$ 0.96	\$ -47.32	
11	10/04/16	145	01	00000001	Standard Cotton Fabric Navy Blue	9.000	\$ 0.96	\$ -47.32	
12	10/04/16	146	01	00000001	Standard Cotton Fabric Navy Blue	9.000	\$ 0.96	\$ -47.32	
13	10/04/16	147	01	00000001	Standard Cotton Fabric Navy Blue	2.388.000	\$ 0.96	\$ 2304.11	

Total Material Cost

\$ 10,44C24

Total Operation Cost

\$ 490.88

Total Non-Operation Cost

\$ 12.88

OK

Cancel

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

Cost Summary Report

Code: 45
Cut Ticket No: 45

Materials | Productive Operation | Non-Productive Operation

#	Posting Date	BarCode	Style	Color	Size	Variable	Operation	Qty	Cost	TotalCost
1	10/04/16	000007400032	MT020023	1010	L		OP01	100	\$ 1	\$ 100
2	10/04/16	000007400025	MT020023	1010	M		OP01	100	\$ 1	\$ 100
3	10/04/16	000007400018	MT020023	1010	S		OP01	100	\$ 1	\$ 100
4	10/04/16	000007400049	MT020023	1010	XL		OP01	100	\$ 1	\$ 100

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

OK Cancel

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

Cost Summary Report

Code: 45
Cut Ticket No: 45

Materials | Productive Operation | Non-Productive Operation

#	Posting Date	POC #	Employee	Total Hr-Pro Time (PDC)	Operation	Total Qty	Proportional Minutes	Cost	Total
1	10/04/16	7	Designer, Lucas M	12.000000	Cutting / Corte	100	2	\$ 1	\$ 3
2	10/04/16	7	Designer, Lucas M	12.000000	Cutting / Corte	100	3	\$ 1	\$ 3
3	10/04/16	7	Designer, Lucas M	12.000000	Cutting / Corte	100	3	\$ 1	\$ 3
4	10/04/16	7	Designer, Lucas M	12.000000	Cutting / Corte	100	3	\$ 1	\$ 3

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

OK Cancel

1.13 Production in Warehouse - Cost Report

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

Production Stock / Cost Report

Date From Date to
Warehouse From Warehouse To

Show

Cancel



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	Available Stock	Delivery Qty	Delivery Qty Cost	Final Stock Balance
03 - UK Allocation Warehouse										
000201	Gins Dress	0.00	23.00	0.00	0.00	0.00	-72.06128	0.00	0.00	0.00
037464012	CACHETERO DESCADERADO LISO	0.00	0.00	0.00	0.00	0.00	-296.00	0.00	0.00	0.00
071.0038	SANDALIA CASUAL A GUARNITE	118.00	123.00	2,214.30	0.00	0.00	140.00	0.00	0.00	118.00
1000	Full Figure Support	4,200.00	0.00	0.00	0.00	0.00	-4,723.00	0.00	0.00	4,200.00
1259449	UA Storm Toss Jacket	0.00	17.80	0.00	0.00	0.00	0.00	0.00	0.00	0.00
155022082	METALLICA BOTTALATO A LEATHERA BEVAIA LGA	12,006.00	0.00	60,026.00	0.00	0.00	16,011.00	0.00	0.00	12,006.00
2200101	ALGODON REPUERTO REP.30138	10.00	194.81	1,996.20	0.00	0.00	1,789.00	0.00	0.00	10.00
365950145	511™ Slim Fit CU-DE Shorts	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
679	Funckiansjake Damen	2,123.00	23.00	48,780.00	0.00	0.00	1,858.00	0.00	0.00	2,123.00
803000	New Ladies Shoe	0.00	0.00	0.00	0.00	0.00	680.00	0.00	0.00	0.00
80400	Ladies Brizel	11.00	0.00	0.00	0.00	0.00	-22.00	0.00	0.00	11.00
804001	Brizel - Ladies	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
AP001	City Gear Style	480.00	0.00	0.00	0.00	0.00	379.00	0.00	0.00	480.00
AP8325	ADIDAS ZX FLUX	0.00	0.00	0.00	0.00	0.00	1,380.00	0.00	0.00	0.00
AP8325	ADIDAS ZX FLUX	1,700.00	0.00	0.00	0.00	0.00	3,140.00	0.00	0.00	1,700.00
AP8325	AP8325 Style	0.00	3.30	0.00	0.00	0.00	0.00	0.00	0.00	0.00

1.14 Cost production report

Cost Summary Report									
Code <input type="text" value="03"/>									
Cut Ticket No <input type="text" value="03"/>									
Filter Table									
Production Costing Summary									
#	Posting Date	Prod Ord No.	Warehouse	Item Code	Description	Quantity	Cost	Total Cost	Operation
1	09/09/16	162	01	RMD12001	Standard Cotton Fabric Navy Blue	120.000	\$ 0.96	\$ 115	Sewing / Costura
2	09/09/16	163	01	RMD12001	Standard Cotton Fabric Navy Blue	120.000	\$ 0.96	\$ 115	Sewing / Costura
3	09/09/16	164	01	RMD12001	Standard Cotton Fabric Navy Blue	120.000	\$ 0.96	\$ 115	Sewing / Costura
4	09/09/16	165	01	RMD12001	Standard Cotton Fabric Navy Blue	120.000	\$ 0.96	\$ 115	Sewing / Costura
5	09/09/16	164	01	RMD11	Polybag	4.000	\$ 0.78	\$ 3.09	
6	09/09/16	163	01	RMD11	Polybag	4.000	\$ 0.78	\$ 3.09	
7	09/09/16	162	01	RMD11	Polybag	4.000	\$ 0.78	\$ 3.09	
8	09/09/16	165	01	RMD11	Polybag	4.000	\$ 0.78	\$ 3.09	
9	09/09/16	164	01	RMD10	Hantag	4.000	\$ 1.25	\$ 5	
10	09/09/16	163	01	RMD10	Hantag	4.000	\$ 1.25	\$ 5	
11	09/09/16	162	01	RMD10	Hantag	4.000	\$ 1.25	\$ 5	
12	09/09/16	165	01	RMD10	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

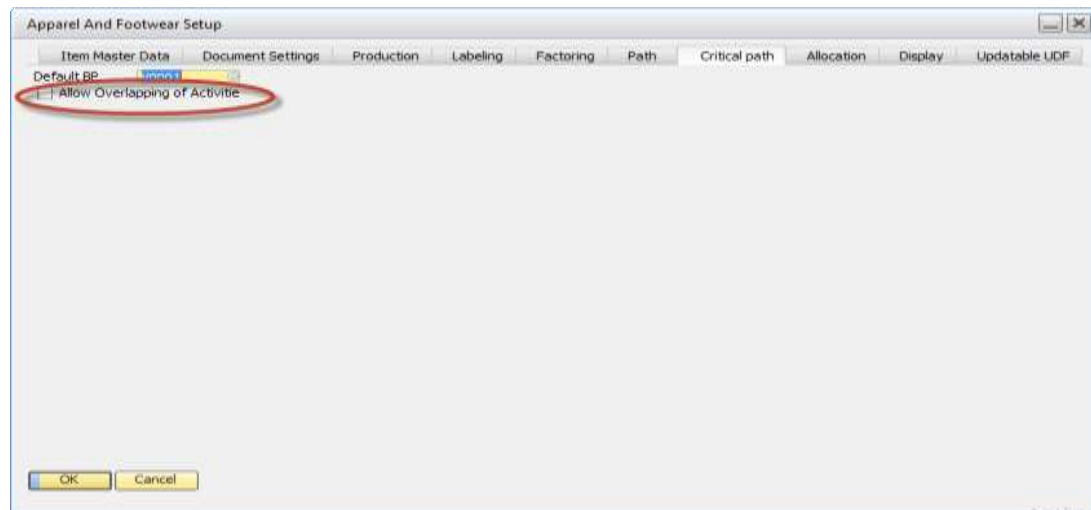
Non-Productive Operation

Posting Date	PDC #	Employee Name	TotalN-Pro Time	Operation	Total Qty	Prop. Minute	Cost	Total cost
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1.15 Link critical path activity to JOB

It is possible to track a production activity in the critical path. This is by relating the two activities. If the production task is delayed the critical path gets updated automatically.

Important: make sure you don't have the allow overlapping activities active in the setup



Create a style with a workflow, then create a project

Product

Doc. Numbering: Manual
 Style Code: NIVARE01
 Description: SAP T Shirt
 Design Code: SAP T Shirt
 Status: Production
 Product Line: Men
 Product Group: Shirts
 AP Segmentation: Apparel
 SAP Item Group:
 Season: Spring Summer 2014
 Collection:
 Sub-Collections:
 Composition:
 Care Instruction Group:
 Brand:

Designer: Logistica, Jorge H
 Division:
 Year:
 Owner:
 Country of Origin:
 Drop:
 Drop Start Date:
 Drop Cancel Date:
 Customer:
 Vendor: V00001
 Main Warehouse: 01
 Secondary Warehouse:
 Price List: Europe
 Currency: \$
 Price: 14.00

☒ Inventory Item
☒ Sales Item
☒ Purchased Item
☐ Fixed Assets
☒ Active
☐ Raw Material
☐ Embroidery/Engraving

Size Color Variants Workflow Prepacks Design and Concepts POIR Constructions Details Branding Cost Sheet Log Comments Stock UOF

Code: 1112

#	Code	Description	Department	Roll	User	User	Lead	Lead Time	Active
1	R003	Pre Production	General	▼ Einkauf	▼ manager		1	10	<input checked="" type="checkbox"/>
2	R001	Production PO	General	▼ Einkauf	▼ manager		1	1	<input checked="" type="checkbox"/>
3	R005	Delivery	General	▼ Einkauf	▼ manager		1	15	<input checked="" type="checkbox"/>

OK Cancel Copy From Duplicate Events and Activities Create UPC Codes Generate SKUs

Assign the JOB number to the critical path activity

Critical path

Code: 268-NIVARE01-112
 Description:
 Model Code: NIVARE01
 Model: SAP T Shirt
 Workflow: PROO
☐ Compare Planning

Status: In progress
 Calendar: 2013 Holidays
 Plan: Forward plan
 Date: 09/30/16
 Document Type:
 Document:

#	Item	Lead Time (C...)	Lead	Date From (Planned)	Date To (Planned)	Planned Date	Planned date to	SAP A...	Priority	Comments	Job Doc Num
1		10.000	0.000	09/30/16	10/14/16	09/30/16	10/14/16	607	Normal	NIVARE01	
2		1.000	0.000	10/14/16	10/17/16	10/14/16	10/17/16	608	Normal	NIVARE01	
3		15.000	0.000	10/17/16	11/02/16	10/17/16	11/02/16	609	Normal	NIVARE01	

List of ArgsSendOut

Find:

#	Doc	Operation	Description
1	602	OP002	Send Out

Update Cancel

The activity is showed in the production JOB

[illegible]

If the planning in production is updated then the critical activity in the project is also updated

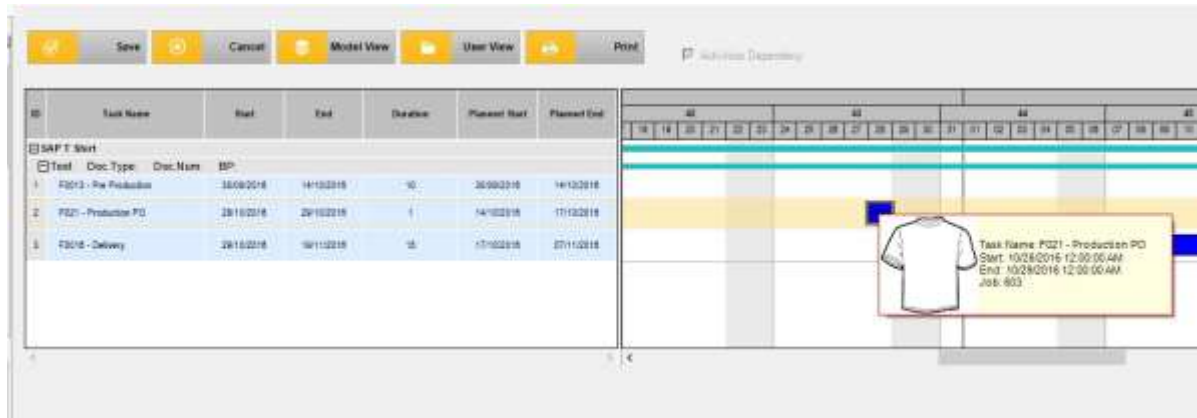
The screenshot displays the SAP Critical Path Gantt Chart and its associated Activity Detail window. The Gantt Chart shows a project timeline with activities and their durations. The Activity Detail window provides information about a specific activity, including its name, start and end times, and the user assigned to it.

Activity Detail Window:

- Activity:** Task
- Type:** General
- Subject:** SAP
- Assigned To:** User
- Assigned By:** Manager
- Personal:** ☐
- Calendar:** General
- Document:** PO
- Attachments:**
- Critical Path:**
- Remarks:** HW14001 - SAP - PO
- Start Time:** 08/08/14 8:00AM
- End Time:** 08/10/14 1:00PM
- Duration:** 3 Days
- Status:** Not Started
- Resource:** None

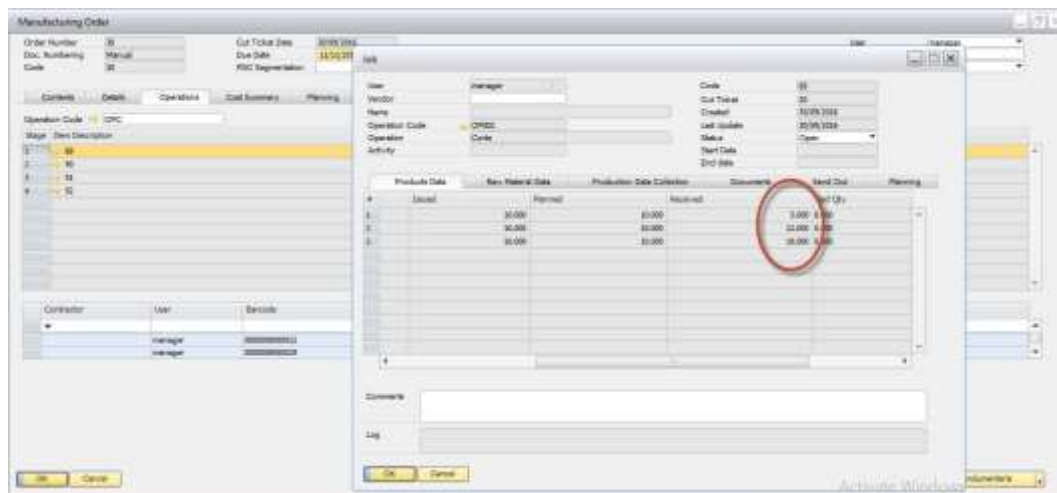
Gantt Chart Table:

Activity	Start	End	Duration	Lead Time	Lead Time (Normal)	Lead Time (Critical)	Lead	Date From (Normal)	Date To (Normal)	Planned Date	Planned Date to	ERP A...	Priority	Comments	Job Backlog
HW14001 - SAP - PO	08/08/14	08/10/14	3 Days	0.000	0.000	0.000	0.000	08/08/14	08/10/14	08/08/14	08/10/14	08/08/14	Normal	HW14001 - SAP - PO	0.000
HW14001 - SAP - PO	08/08/14	08/10/14	3 Days	0.000	0.000	0.000	0.000	08/08/14	08/10/14	08/08/14	08/10/14	08/08/14	Normal	HW14001 - SAP - PO	0.000



The predecessor Job quantity entered is updated in the successive Jobs.

In the PDC module, if the user enters less or more quantities, this information is updated to the successive jobs. As an example, in the Job **Cutting** I enter 5 units for a size and 12 for another. Planned quantity for both sizes is 10 units.



In the next job the issued quantity gets updated based on the predecessor job

Manufacturing Order

Order Number: 33, Doc. Numbering: Manual, Code: 33, Cut Ticket Date: 30/09/2016, Due Date: 11/10/2016, POC Segmentation: Job

User: manager, Code: 95, Cut Ticket: 33, Created: 30/09/2016, Last Update: 30/09/2016, Status: Open, Start Date: , End Date:

Operation Code: OPC, Stage: Item Description

#	Code	Issued	Received	Bad Qty
1	000000018	5,000	0,000	0,000
2	000000025	12,000	0,000	0,000
3	000000032	10,000	0,000	0,000

Comments: , Log:

OK Cancel

When entering PDC quantities the suggested or issued quantity to register is displayed

Production Data Collection

Code: 23, Posting Date: 30/09/2016, Employee: Merchandiser, Jorge H, Shift: , Vendor: , Minutes Presence: 0.00, Unproductive Minutes: 0.00

#	Bar Code	CutTick#	PO	Model Code	Description	Color	Scale	Size	Variable	Work Center	Resource	Stage	Operation Code	Operation	Qty	Bad Qty
0000009000018	30	161	BED0881	Calzado Bedstu	2039	CAL22	6			Departamento de Costura	Costura	90	OP005	Pespunte	5,000	0,00
0000009000025	30	162	BED0881	Calzado Bedstu	2039	CAL22	7			Departamento de Costura	Costura	90	OP005	Pespunte	12,000	0,00
0000009000032	30	163	BED0881	Calzado Bedstu	2039	CAL22	8			Departamento de Costura	Costura	90	OP005	Pespunte	10,000	0,00

Add Cancel Clear All Clear