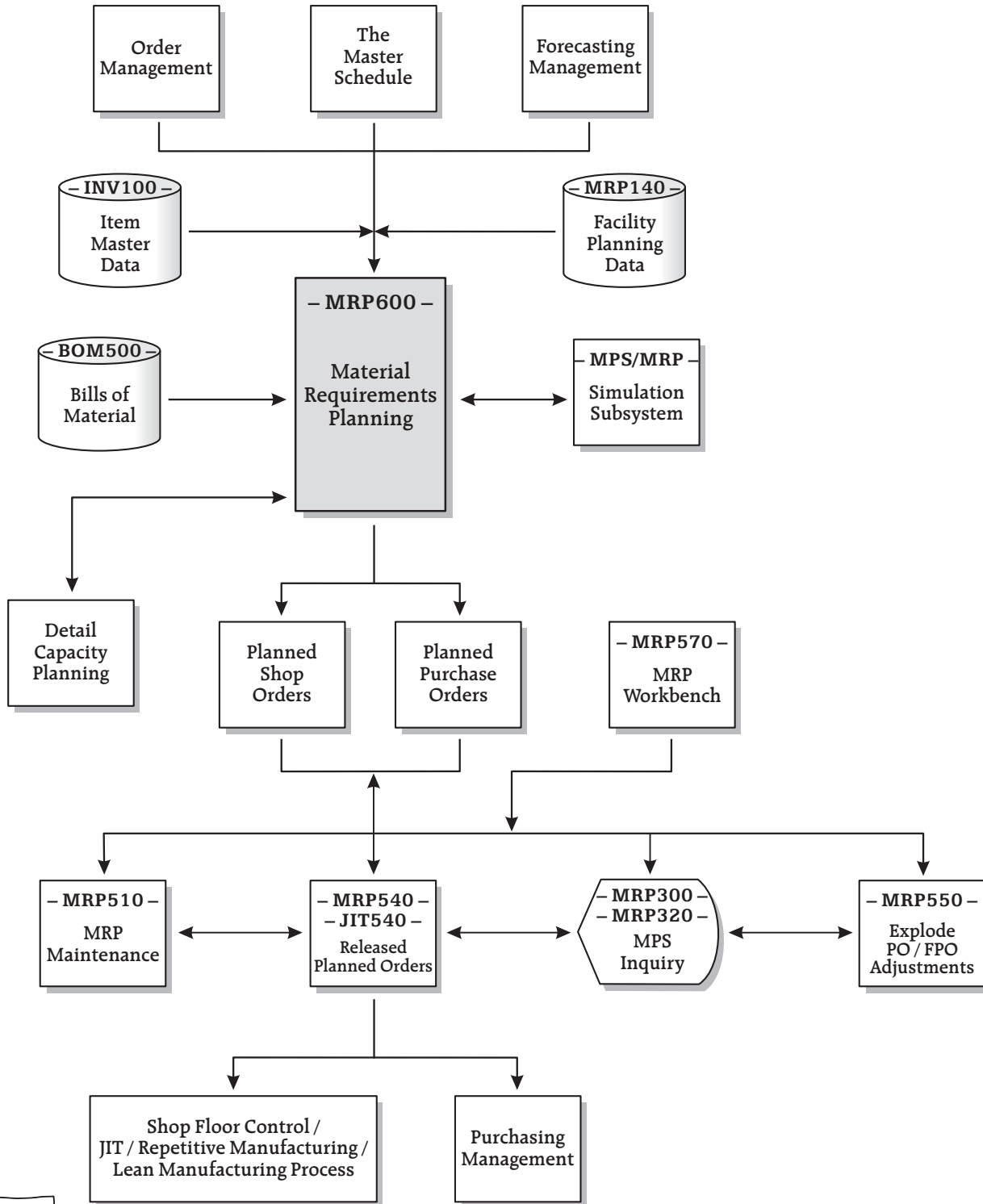


## Material Requirements Planning Process Flow



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## Key Program Features

### System Parameters .....SYS800

#### Field Definitions ...cont. from the previous page

∇ Consume customer orders and forecast demand:

- 1 = **Yes**: compare customer orders for all nettable warehouses in a facility to total accumulated forecasts for the facility
- 2 = **No**: compare customer orders for a warehouse only to the forecast for that warehouse

∇ Ignore resupply orders for demand consumption:

- 1 = **Yes**: *exclude* resupply orders for demand by each warehouse
- 2 = **No**: *include* resupply orders in the calculation of demand

∇ Horizon

- ◇ number of periods for repetitive items
- ◇ number of days for other items

Enter the number of periods or days for which the master schedule is to be frozen. The system will not plan orders within the horizon time frame. Horizon can be overwritten in the Item Master file.

∇ Ignore horizon for item types 0 and 5 (phantoms and planning bills):

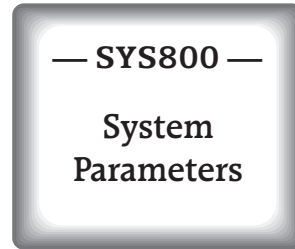
- Y** = **Yes**: the system *will* plan orders within the horizon time for item types 0 and 5
- N** = **No**: the system *will not* plan orders within the horizon time for item types 0 and 5

∇ Prorate forecasts:

- Y** = **Yes**: *prorate* the total forecast across a period from the planning start date to the end of the period
- N** = **No**: *do not prorate* – show all forecasts for the period in the beginning of the period

∇ Maintain multiple forecast sources per day:

- 1 = **Yes**: allow multiple detailed forecasts by item / warehouse date in MRP100
- 2 = **No**: allow only one total forecast record by item / warehouse in MRP100

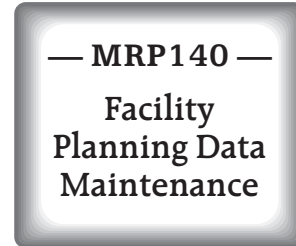


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## Key Program Features

### Facility Planning Data Maintenance ..... MRP140

This program allows maintenance to be performed on the Item Facility Data file. This program provides unique planning parameters by item and facility when MPS / MRP is run by facility.



The record created using MRP140 overrides certain data in the Item Master for MPS / MRP purposes. This record is automatically created by the system on the first transaction involving the particular item / facility. The system creates the record using information from the Item Master by default.

Use F15 to copy default data from the Item Master (to save key strokes), then manually change fields as necessary. Press Enter to update the changes for this item / facility.

### Significant MPS/MRP Fields

#### ∇ Yield type

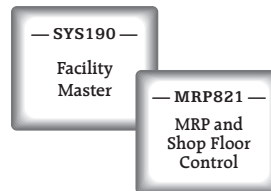
Determines how the yield factor is calculated:

**Blank** .. use default from Facility Maintenance (SYS190) or MRP and Shop Floor Control parameters (MRP821)

**0** ..... manual parent yield percent

**1** ..... populates a calculated yield for each step in the routing; total item yield is evenly populated over all the routing steps

**2** ..... each step of the routing has an individual yield percent



...continued on the next page



## Key Program Features

### Facility Planning Data Maintenance..... MRP140

#### Significant MPS/MRP Fields

...cont. from the previous page

∇ Primary vendor and ∇ Secondary vendor

Enter the primary and secondary vendor numbers for this item / facility. (It is quite common for facilities to have different vendors since they may purchase from local suppliers.)

∇ Shop order generate:

**0** = **No:** *do not automatically* generate shop orders

**1** = **Yes:** *automatically* create shop orders for items upon creation of a customer order for the item. Also creates automatic multilevel shop orders when using SFC530 – Multilevel Shop Order Release

∇ Control dates 1 through 5

These fields allow the entry of days required between the due date of an item and the date that it can be used by production.

∇ Production line

Required for items identified as a “flow item”

— MRP140 —

Facility  
Planning Data  
Maintenance

— SFC530 —

Multilevel  
Shop Order  
Release

## **Key Program Features**

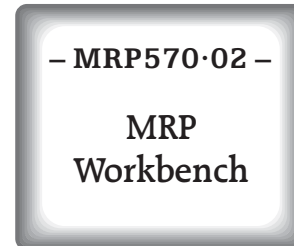
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### **MRP Workbench..... MRP570-02**

...continued from the previous page.

#### **Available Scheduling Actions**

- ∇ Create
- ∇ Revise
- ∇ Firm / un-firm
- ∇ Delete
- ∇ Release forward
- ∇ Release backward
- ∇ Release purchase order
- ∇ Create KFP comments
- ∇ Material availability
- ∇ Planning / pegging inquiry



#### **Available Planning Function Keys**

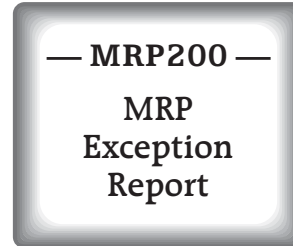
- ∇ Purchase orders — PUR500
- ∇ Item release date — MRP570
- ∇ Cancel release — MRP570
- ∇ Item / vendor quality — PUR120
- ∇ Item / facility quality — SFC121
- ∇ Forecasts — MRP100
- ∇ Requisitions — PUR600
- ∇ Shop orders — SFC500
- ∇ Customer orders — ORD700

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## Key Program Features

### MRP Exception Report ..... MRP200

This is a detailed report used to analyze and execute planned orders. The action messages or system-suggested actions to be taken provide planners with assistance in planning and execution.



*Note: This is generally a very long report, but with practice you can learn to limit the report to print just what you need. Companies new to MPS/MRP will find this report exhausting. With time, discipline and continuous improvements to the MPS/MRP cycle, the report will shrink to a manageable size.*

### Parameters

∇ Sort by:

- 1 = planner
- 2 = buyer
- 3 = item
- 4 = vendor

∇ Lower and upper planner limit

Enter the lower and upper limit of planners for inclusion in the report.

∇ Lower and upper buyer limit

Enter the lower and upper buyer codes for inclusion in the report.

∇ Lower and upper vendor limit

Enter the lower and upper vendor codes for inclusion in the report.

∇ Lower and upper item number

Enter the lower and upper item numbers for inclusion in the report.

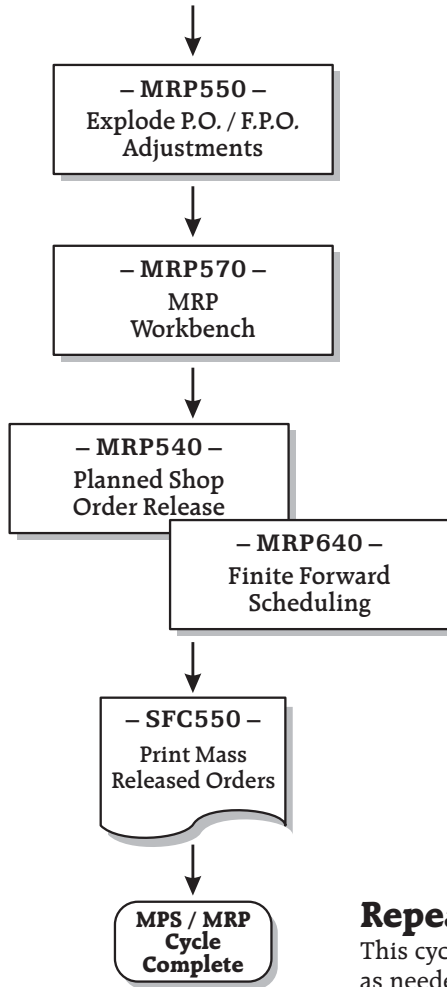
∇ Facility code

Enter the facility code.

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Unbeaten Path®

## A Cookbook Approach (one of many): The MPS/MRP Cycle



### Step 11

This program adjusts for changes in method codes.

### Step 12

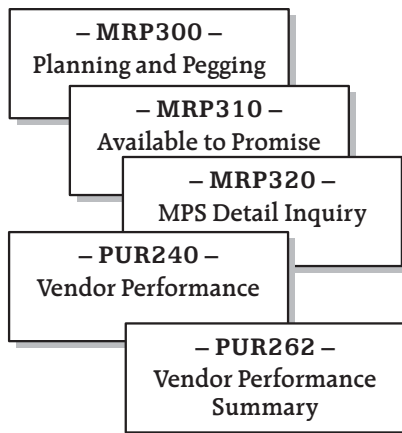
Execute the plan.  
Release planned orders. Use MRP640 as a tool to assist the production scheduler.

### Step 13

Print shop paper.

### Repeat cycle as needed.

This cycle can be repeated daily, weekly or as needed. Find the routine that fits best.



### Use as needed:

Use these ERP LX features to review and evaluate as needed:

- ▽ Planning and Pegging (MRP300)
- ▽ Available to Promise (MRP310)
- ▽ MPS Detail Inquiry (MRP320)
- ▽ Vendor Performance (PUR240)
- ▽ Vendor Performance Summary (PUR262)