

Routings, Work Centers, and Shop Floor Control

The QMRP™ Routings, Work Centers, and Shop Floor Control functions define the work centers and operations that a manufactured item will pass through on the shop floor. Programs within this module are used to establish, evaluate, and maintain routings, work centers, and manufacturing procedural notes. Additionally, "outside services" may be defined and maintained as part of a routing.

Multiple routing revision levels may be established for each item with up to 100 operation steps within each revision. Both run times and costs are maintained in the routing for use by the manufacturing process, product costing, and manufacturing cost reporting functions. Setup times and costs can also be established for each type of operation.

Standard operations can be established prior to creating routings and can be updated automatically during the routing entry stage. Subsequent maintenance of standard operations can be duplicated to all routings in which they are used. Work centers can be established to define machine and labor capacities and efficiencies, overhead rates, and machine costs per hour. Work centers, also referred to within routings, are critical for operation of the Capacity Planning/Priority Dispatch module.

When manufacturing orders have been released and are in process on the shop floor, they can be monitored through work-in-process inquiries and reports. Work-in-process is automatically updated from the Labor Distribution module, if activated. Otherwise, manual entries can be made to update the quantity or percentage of work completed against each order at each stage of manufacture.

Highlights:

- Both standard and alternate operations can be built on any routing revision.
- Regular, batch, indirect, unattended, and purchased service operations types are available.
- Run times are defined in units per hour or hours per unit.
- Automatically converts standard units of measure into operational units of measure.
- On-line inquiries display routings by item or order.
- Audit trail maintained on all updates to routings and work centers.
- Optional detailed utilization forecast allows variable machine and labor calendars per week.
- "Where-used" reports and on-line inquiries for standard operations are available.
- Labor and overhead codes are user-defined.
- On-line inquiry shows work-in-process including order and item number, quantity ordered and scrapped, quantity and percentage completed, hours remaining, and other details.
- Shop floor data collection is integrated with work-in-process inquiry.



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