

Product Operations Table:

Products

Input Table **Operations/Routing Tables** All Operations Tables All Routing Tables IBOM Data Table

Product Operations/Routing Table

Amount of time required for the labor to run each piece

Percent of the products assigned to the operation

Drop-down list for different products

Select Product to Display: HUB1

Sort Show Optional Parameters Copy Table

Show Real Times Add Default Routing

	Operation Name	Operation Number	Equipment Assigned	% Assigned	Equipment Setup Time (Lot)	Equipment Run Time (Piece)	Labor Setup Time (Lot)	Labor Run Time (Piece)
Edit Copy Delete	BENCH	10	BENCH	100	0	10	0	10
Edit Copy Delete	RFTURN	20	VT_LATHE	100	180	17	180	15
Edit Copy Delete	DEBURR	30	DEBURR	100	0	10	0	10
Edit Copy Delete	FTURN	40	VT_LATHE	100	120	25 + 1/2	120	20
Edit Copy Delete	INSPECT	50	INSPECT	100	7	12	7	7
Edit Copy Delete	REWORK	60	REWORK	100	90	32	90	32
Edit Copy Delete	SLOT	70	MILL	100	60	60	60	40
Add			NONE	100	0	0	0	0

Operation Name
(Must be unique)

Equipment assigned to the operation

Operation Number
(Must be unique)

Time to set up the equipment for the entire lot

Time the equipment needs to run a single piece

Time required for labor to set up for the entire lot

Note: Equipment and Labor setup and run times are in Operation Time Units

Note: Operation Numbers should correspond to the same Operation Name across all products

Cells in the Optional Parameters:

- Tbatch: Time required due to transferring transfer batches
- Equipment/Labor Setup Piece: Additional set-up time required by the equipment/labor for each piece in the lot
- Equipment/Labor Run Time Lot: Additional time required by the equipment/labor to run an entire lot

Routings of HUB1 from Operation: All ▼ Drop-down list for filtering From Operation

Show Real Percentage Sort

	From Operation	To Operation	Percent Routed	From Operation Number	To Operation Number
Edit Delete	INSPECT	SCRAP	5	50	10000
Edit Delete	INSPECT	REWORK	10	50	60
Edit Delete	REWORK	SCRAP	20	60	10000
Edit Delete	REWORK	INSPECT	80	60	50
Edit Delete	INSPECT	SLOT	85	50	70
Edit Delete	SLOT	STOCK	100	70	9999
Edit Delete	FNTURN	INSPECT	100	40	50
Edit Delete	DEBURR	FNTURN	100	30	40
Edit Delete	RFTURN	DEBURR	100	20	30
Edit Delete	BENCH	RFTURN	100	10	20
Edit Delete	DOCK	BENCH	100	0	10
Add	▼	▼	0		

Operation that the product is coming from

Operation that the product is arriving at

Percent of the product that is being routed between the two operations

Number of the operation that the product is arriving at

Product Routing Table:

Note: This table is only shown the Routings for the product selected in the drop-down list above the Operations Table